Data Sheet -ZDXPOM Fe50Ni B



(材料属性参考表)

requirements, so they are not written out.	/ 1/1 1/1 1/14/11-7-3	7 1710									
Product description Feedstock for metal injection moulding. W			`								
Note											
MFI g/10min 500 800 1100 DIN EN ISO 1133 (190°C/21.6kg)				•							
株结								DIN EN ISO 1133 (190°C/21.6kg)			
大学 大学 大学 大学 大学 大学 大学 大学	(按重量百分比计算) Typical composition after		Fe	C	Cr	Ni	Mo	Mn	Si	S	P
原目 Project 場合語。		>	-		-	49.0	-	-	-	-	-
Project		<	Bal.	0.01	-	51.0	-	-	-	-	-
Density 新顽力 Hc Cocreive force 剩余磁感应强度 Residual magnetic induction 磁导率 Permeability 磁化强度 Magnetization intensity 硬度 Hardness Zone 1 建议注射温度 Recommended injection temperature 建议模具温度 Recommended injection temperature 多考生还密度区间 Reference density interval 注射工艺 Injection process Injection process Density Fried 10 A/m (@ Éster for 7.85 g/cm²) 0.8T 10 A/m (@ Éster for 7.85 g/cm²) 150 C 20 C Zone 2 Zone 3 Zone 4 Nozzle 185°C 185°C 175°C 150°C 190°C 22 Vi模具温度 Recommended injection temperature 多考生还密度区间 Reference density interval 其余注塑工艺参数受到产品形状及要求影响较大,故未写出。 需要注意的是,注塑工艺的设定对于产品的生坯密度有着较大的影响,而这也可能导致产品最终尺寸和其他要求不符使用者的期望。 Other injection molding process parameters are greatly affected by product shape and requirements, so they are not written out.						as sintered 烧结态					
四型特性 Typical properties Coercive force 剩余磁感应强度 Residual magnetic induction 磁导率 Permeability 磁化强度 Magnetization intensity 硬度 Hardness Zone 1 110-160HV10 建议注射温度 Recommended injection temperature 建议模具温度 Recommended injection temperature 建议模具温度 Recommended injection temperature 参考生坯密度区间 Reference density interval 注射工艺 Injection process 其余注塑工艺参数受到产品形状及要求影响较大,故未写出。 需要注意的是,注塑工艺的设定对于产品的生坯密度有着较大的影响,而这也可能导致产品最终尺寸和其他要求不符使用者的期望。 Other injection molding process parameters are greatly affected by product shape and requirements, so they are not written out.						>7.85 g/cm ³					
Residual magnetic induction 磁导率 Permeability 磁化强度 Magnetization intensity 硬度 Hardness						10 A/m (@ <u>烧结密度 7.85g/cm³</u>)					
Permeability 磁化强度 Magnetization intensity 硬度 Hardness ### Zone1						0.8T					
Magnetization intensity 硬度 Hardness Zone 1 ② Zone 2 ② Zone 3 ② Zone 4 Nozzle Recommended injection temperature 建议模具温度 Recommended injection temperature 参考生坯密度区间 Reference density interval 其余注塑工艺参数受到产品形状及要求影响较大,故未写出。 需要注意的是,注塑工艺的设定对于产品的生坯密度有着较大的影响,而这也可能导致产品最终尺寸和其他要求不符使用者的期望。 Other injection molding process parameters are greatly affected by product shape and requirements, so they are not written out.						μ _{max} =28000(@ <u>烧结密度 7.85g/cm</u> ³)					
### Band						Js(4Ka/m)=1.36T					
Recommended injection temperature 185℃ 185℃ 175℃ 150℃ 190℃ 建议模具温度 90-125℃ Recommended injection temperature 参考生坯密度区间 5.07-5.13g/cm³				110-160HV10							
建议模具温度 Recommended injection temperature 参考生坯密度区间 Reference density interval 其余注塑工艺参数受到产品形状及要求影响较大,故未写出。 需要注意的是,注塑工艺的设定对于产品的生坯密度有着较大的影响,而这也可能导致产品最终尺寸和其他要求不符使用者的期望。 Other injection molding process parameters are greatly affected by product shape and requirements, so they are not written out.		建议注射	温度			Zone1		Zone 2	Zone 3	Zone 4	Nozzle
Recommended injection temperature 参考生坯密度区间 Reference density interval 其余注塑工艺参数受到产品形状及要求影响较大,故未写出。 需要注意的是,注塑工艺的设定对于产品的生坯密度有着较大的影响,而这也可能导致产品最终尺寸和其他要求不符使用者的期望。 Other injection molding process parameters are greatly affected by product shape and requirements, so they are not written out.		Recommended injection temperature				185°C		185°C	175°C	150°C	190°C
注射工艺 Injection process Reference density interval 其余注塑工艺参数受到产品形状及要求影响较大,故未写出。 需要注意的是,注塑工艺的设定对于产品的生坯密度有着较大的影响,而这也可能导致产品最终尺寸和其他要求不符使用者的期望。 Other injection molding process parameters are greatly affected by product shape and requirements, so they are not written out.						90-125°C					
Injection process 其余注塑工艺参数受到产品形状及要求影响较大,故未写出。 需要注意的是,注塑工艺的设定对于产品的生坯密度有着较大的影响,而这也可能导致产品最终尺寸和其他要求不符使用者的期望。 Other injection molding process parameters are greatly affected by product shape and requirements, so they are not written out.						5.07-5.13g/cm ³					
·		需要注意的是,注塑工艺的设定对于产品的生坯密度有着较大的影响,而这也可能导									
		requirements, so they are not written out. It should be noted that the setting of injection molding process has a great influence on the									

green density of the product, which may also cause the final size of the product and other

requirements do not meet the user's expectations.

	脱脂酸 Debinding acid	98% HNO ₃				
	脱脂温度 Debinding temperature	100-150°C				
脱脂工艺	脱脂时间	取决于零件厚度				
Debinding process	Debinding time	Depending on part thickness (e.g. 3 mm part approx. 3h)				
	脱脂工艺 Debinding process	当生坯最低脱脂率 达到 9.8%时,可以终止脱脂制程 When the minimum debinding rate of green part when it reaches 9.8%, the debinding process can be terminated.				
	烧结气氛	氢气烧结				
烧结工艺 Sintering process	Sintering atmosphere	100% dry argon				
	烧结载具	氧化铝陶瓷片				
	Sintering substrate	Non-metallic base (e.g. Al2O3)				
	负压脱脂 Negative pressure degreasing	从室温升高至 600℃过程中,采用有多段持温的负压脱脂,以确保剩余粘结剂能被脱脂干净,总时间450min 左右。 From room temperature to 600 ℃, vacuum debinding with multi-stage holding temperature is used to ensure that the remaining binder can be removed completely, and the total time is around 450 min.				
	真空烧结 Vacuum sintering	从600℃以3℃/min 升温至850 摄氏度持温一段时间进行真空内烧,目的是确保产品碳含量在合理区间。 From 600 ℃ to 850 ℃ at 3 ℃ / min and holding for a period of time, the vacuum internal sintering is carried out to ensure that the carbon content of the product is in a reasonable range 。				
	分压烧结 Partial pressure sintering	从 850℃以 3℃/min 升温至 1050℃后短暂持温,之后以同样的升温速度升高至 1260℃,使得材料致密化,最后随炉冷却。 From 850 ℃ to 1050 ℃ at 3 ℃/ min, holding for a shortime, and then it was raised to 1260 ℃ at the same heating rate for material densify, and finally cooled with the furnace。				
保质期	如果储存得当: 12 个月, 防止原料受潮。					
Shelf life	If stored appropriately: 12 months. Protect feedstock against moisture.					

免责声明:本物性表仅基于我们的知识和经验得出,具有一定的参考意义,但由于影响产品最终要求和性能的因素众多,并不能完全排除使用者由于各种原因导致与期望不符的现象。

Disclaimer: this property sheet is only based on our knowledge and experience, and has certain reference significance. However, due to many factors affecting the final requirements and performance of the product, it cannot completely exclude the user's non-compliance with expectations due to various reasons.