

ZDX 众德祥
Feedstock MIM

产品 Product	304H(高碳含量) 304H（High carbon content）									
产品描述 Product description	金属注射成型原料 Feedstock for metal injection moulding.									
收缩率 Oversize factor	1.162 Min.	1.165 Average		1.168 Max.						
熔体流动指数 MFI g/10min	800 Min.	1200 Average		1600 Max.		DIN EN ISO 1133 (190°C/21.6kg)				
烧结后典型成分 (按重量百分比计算) Typical composition after Sintering		Fe	C	Cr	Ni	Mo	Mn	Si	S	P
	>	-	-	18.0	8.0	-	-	-	0	0
	<	Bal.	0.08	20.0	11.0	-	2.0	1.0	0.03	0.035
典型特性 Typical properties	项目 Project				烧结态 as sintered			热处理 heat treated		
	密度 Density				>7.75 g/cm³					
	屈服强度 Yield strength _{Rp02}				>160 MPa					
	抗拉强度 Tensile strength				>480 MPa					
	延伸率 Elongation A10				>40 %					
	硬度 Hardness				150-200 HV10					
	盐雾测试 Salt spray test				36 h					
注塑工艺 Injection process	建议注射温度 Recommended injection temperature				一段 185°C Zone 1	二段 185°C Zone 2	三段 175°C Zone 3	四段 150°C Zone 4	射嘴 190°C Nozzle	
	建议模具温度 Recommended injection temperature				90-125°C					
	参考生坯密度区间 Reference density interval				5.35-5.41 g/cm³					
	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. 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.									

脱脂工艺 Demanding process	脱脂酸 Debinding acid	98% HNO ₃
	脱脂温度 Debinding temperature	100-150°C
	脱脂时间 Debinding time	取决于零件厚度 Depending on part thickness (e.g. 3mm part approx. 3h)
	脱脂率 Debinding rate	当生坯最低脱脂率, 达到 7.2%时, 可以终止脱脂制程。 When the minimum debinding rate of green part reaches 7.2%, the debinding process can be terminated.
烧结工艺 Sintering process	烧结气氛 Sintering atmosphere	氩气烧结 100% dry argon
	烧结载具 Sintering substrate	氧化铝陶瓷片 Non-metallic base (e.g. Al ₂ O ₃)
	负压脱脂 Negative pressure debinding	从室温升高至 600°C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 °C, 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°C以 3°C/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 °C to 850 °C at 3 °C / 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°C以 3°C/min 升温至 1050°C后短暂持温, 之后以同样的升温速度升高至 1380°C, 使得材料致密化, 最后随炉冷却。 From 850 °C to 1050 °C at 3 °C/ min, holding for a short time, and then it was raised to 1380 °C at the same heating rate for material densify, and finally cooled with the furnace.
	保质期 Shelf life	如果储存得当: 12 个月, 防止原料受潮。 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 datasheet is only based on our knowledge and experience, which has certain reference significance. However, it cannot completely exclude the user's non-compliance with expectations due to various reasons, because there exist many uncontrolled factors affecting the final requirements and performance of the products.