

Shenzhen Kadam Technology Co., Ltd

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Kadam® MIM C110

Product Description

The gas atomized powder is based on the oxalic acid catalytic debinding system and can be used directly for injection molding material granules to produce C110 copper sintering parts.

Product Standard

Item	Unit	Specification	Test method
Melt flow index (MFI)	g/10min	1200±500	ISO1133
Green part density	g/cm ³	5.40±0.03	ISO3369
Sintering density	g/cm ³	>8.3	ISO3369

Powder Composition (wt%)

Cu	O
Bal.	≤0.40

Standard Processing

Standard injection molding machine for thermoplastic resins, based on the oxalic acid catalytic debinding system.

Typical Characteristics

After Sintering

Ultimate tensile strength	≥195MPa
Typical sintering hardness	50-65HV0.2
Elongation	≥ 35 %
Thermal conductivity (W/(m*K))	≥351
Conductivity (%IACS,20°C)	≥90
Over size factor (OSF) *	1.216±0.003 (Sintering density 8.5-105°C)

*The hardness of heat treatment and over size factor (OSF) are related to customer process conditions (Especially the sintering temperature) for reference only.

Injection Molding

Injection temperature	Zone 1	Zone 2	Zone 3	Nozzle
	180°C	185°C	190°C	195°C
Mold temperature	90 ~ 125 °C			
Screw speed	50 r/min			
Injection speed	10 cm ³ /s			
Molding pressure	900 bar			
Holding pressure	900 bar			
Holding time	0.1~3 s			

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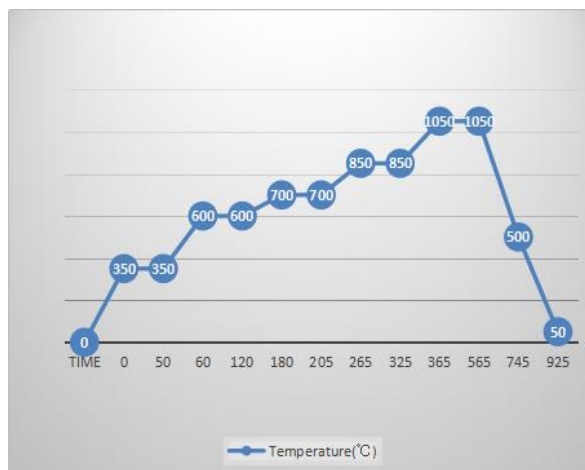
*As reference for forming conditions, due to differences in molding machine and mold, molding conditions should be adjusted, be sure to ensure the actual temperature is not higher than 200°C, otherwise it will greatly reduce the service life of the raw materials and cause irreversible damage to the material.

Debinding

Recommend the use of anhydrous oxalic acid, 2 stage catalytic debinding temperature 110~145°C and 160~190°C, the debinding process is finished when a minimal debinding loss of 9.4% is reached, it's not suitable to place too long after debinding. Need to pay attention on the oxygen content in furnace cannot be over 4.5% (volume fraction) in debinding process, it will cause an explosion if exceed; however embryo easily absorbs the moisture in the air after debinding, therefore, it is not recommendable to see whether the debinding craft is finished by identifying its debinding rate, in addition, it is better in mezzanine without POM in the product.

Sintering

A typical sintering cycle is: room temperature to 5°C per minutes up to 600 °C, hold for 60 minutes, with 5°C per minute up to 1050°C (The characteristics of the sintering furnace are different, the maximum temperature is for reference only. The specific temperature is based on the test result), hold for 180 minutes, and then with the furnace cooling. (Follow the sintering curve)



This information is compiled according to our knowledge, for reference only. We will keep the right to change the range of parameters within the process or product development scope. Due to we cannot control the various production conditions of different factories, please test the applicability of the user before production.