

Debinding

Economic aspects

Sintering, like moulding, is common to...
It may be batch or continuous, in gas...
furnaces, under hydrogen or in...
because of the furnace cap...
(with the same starting...
temperature to be...

Equipment... the actual number
of parts... and the cycle time
(for... continuous sintering).
Costs... continuous sintering, depend on the
con...

In general... will have to be sintered slower than
thin comp... the variation in cycle time is much less than for
debinding, ... from a few (6-8) hours to 24 hours.

Each furnace use energy and gases, and these costs will refer to the
number of parts processed.

An additional source of cost is the necessity of sintering supports.
These can be disposable MIM feedstock supports that sinter
together with the part and are removed later, or ceramic supports
that do not change during sintering and are used in many cycles
until they eventually get damaged and have to be replaced.

