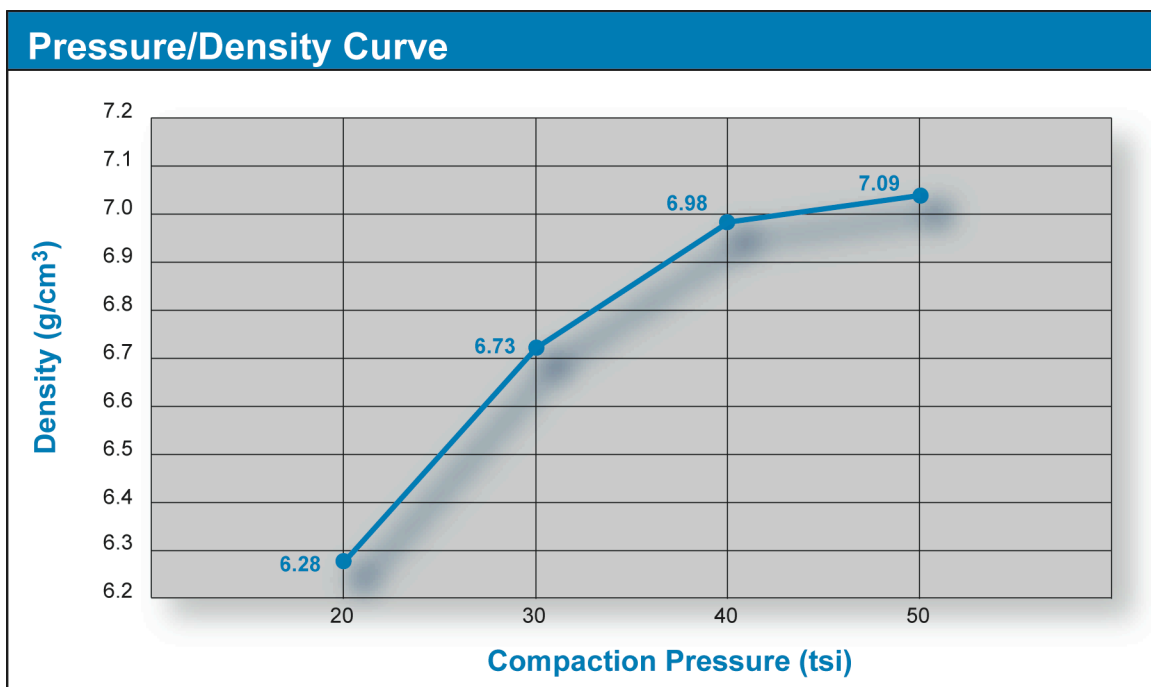


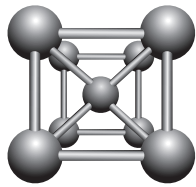
*The Rapid Response Premix Facility for the Powdered Metal Industry*

## ARC-4 (FC-0208) Remill Data Sheet

ARC-4 remill is an iron based mix meeting MPIF FC-0208 chemistry requirements and produced mainly from recycled green powder metal compacts. ARC-4 is a press ready mix containing 0.75% lubricant. It is commonly used to produce net-shape lawn and garden, light industrial and household goods. ARC-4 may be machined, but some applications may not machine as well as new powder mixes. Additions of MnS are common for applications requiring machining.

Typical Blend Chemistry (%)	
Chemistry	Typical
Iron	Balance
Copper	1.67
Carbon	0.80
Lubricant	0.75
Others	1.08





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## ARC-4 (FC-0208) Remill Data Sheet

Typical Blend Properties		
	ARC-4	Virgin Blend <sup>1</sup>
Hall Apparent Density (g/cm <sup>3</sup> )	3.18	2.88
Hall Flow Rate (seconds per 50g.)	30.6	32.5

Typical Compacted Properties		
	ARC-4	Virgin Blend <sup>1</sup>
Compacting Pressure to 6.8 g/cm <sup>3</sup> (tsi)	32.7	31.5
Green Strength at 6.8 g/cm <sup>3</sup> (psi)	1345	2085

Typical Sintered Properties <sup>2</sup>		
	ARC-4	Virgin Blend <sup>1</sup>
Dimensional Change (%)	0.35	0.46
Apparent Hardness (HRb)	78	74
Transverse Rupture Strength (psi)	122,600	123,200

1) A-1000B, 2.00% Copper, 0.80% graphite, 0.75% EBS

2) Compacted to 6.8 g/cm<sup>3</sup> and sintered in 90%/10% N<sub>2</sub>/H<sub>2</sub>