

## Accepted Manuscript

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PII: S0032-5910(17)30949-X  
DOI: doi:[10.1016/j.powtec.2017.11.069](https://doi.org/10.1016/j.powtec.2017.11.069)  
Reference: PTEC 12988

To appear in: *Powder Technology*

Received date: 17 July 2017  
Revised date: 25 November 2017  
Accepted date: 30 November 2017



Please cite this article as: G. Thavanayagam, J.E. Swan, Aqueous debinding of polyvinyl butyral based binder system for titanium metal injection moulding, *Powder Technology* (2017), doi:[10.1016/j.powtec.2017.11.069](https://doi.org/10.1016/j.powtec.2017.11.069)

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# Aqueous debinding of polyvinyl butyral based binder system for titanium metal injection moulding

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## Abstract

Titanium is biocompatible, has high specific strength and high corrosion resistance compared to other materials. Producing near-net shape parts by metal injection moulding (MIM) minimizes the need for secondary operations required for other metal-working processes such as casting, forging, and investment casting. Removing binder (debinding) from the MIM moulded part without disturbing the powder particles is a crucial stage. Titanium-MIM parts were manufactured from hydride-dehydride (HDH) titanium alloy powder Ti-6Al-4V ( $d_{10}$ ,  $d_{50}$  and  $d_{90}$  of 12.8, 51.8 and 117.7  $\mu\text{m}$  respectively) and various polyethylene glycol-polyvinyl butyral (PEG-PVB) based binder systems. The effect of binder composition, powder loading (55 and 60 vol. %), debinding time and temperature on the debinding rate for removing PEG with water, and porosity and microstructure of moulded parts was investigated. Solvent debinding had dissolution-controlled and diffusion-controlled stages; increasing debinding temperature shortened the dissolution-controlled stage. The amount of PEG removed increased with initial

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