



Intralube® E

Your new powder mix for excellent lubrication

The Intralube E is a press-ready mix that will improve your pressing and sintering process by optimising lubrication and ensuring low staining after sintering.

Intralube E offers up to 20% better lubrication compared to a standard premix. It also shows a clean burn off resulting in clean part surfaces and no residues in the furnace. Intralube E is especially designed also to work with warm die compaction.

Main product benefits

- » Excellent lubrication
- » Zinc-free
- » Low staining tendency
- » Suitable for warm die compaction

Basic product characteristics

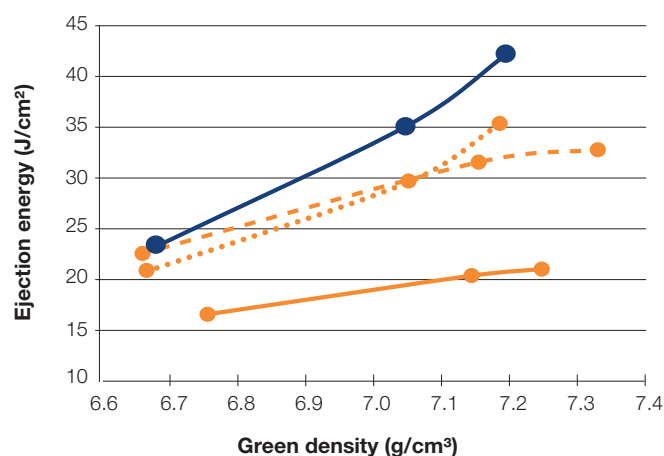
Measured on mixes based on Distaloy® AB with 0.5% graphite and lubricant.
Compaction was made at 600 MPa at room temperature and with warm die.

	Intralube® E mix		Premix	Premix
Lubricant	Lube E		Amide wax	Kenolube®
Typical amount	0.6		0.8	0.6
Apparent density (g/cm³)	3.0		3.1	3.0
Zinc	No		No	Yes
Die temperature	Room temperature	70 °C	Room temperature	Room temperature
Green density (g/cm³)	7.11	7.16	7.05	7.11
Green strength (N/mm²)	17	21	12	16
Ejection energy (J/cm²)	37	30	40	38
Ejection force (N/mm²)	33	28	33	35

The excellent lubrication properties of Intralube E mixes can be used to either improve ejection properties or to increase density by decreasing the lubricant content. Both ejection properties and density can be improved further by applying warm die compaction.

Intralube E mixes also helps improve surface quality. Compare the pictured components below to the left a premix made with Amide wax and to the right one made with Intralube E mix.

Ejection energy



Material: ASC100.29 + 0.5% C + lubricant
Compaction: 400, 600 and 800 MPa at room temperature and with warm die

For more information on Astaloy and other Höganäs products, please contact your local sales representative.