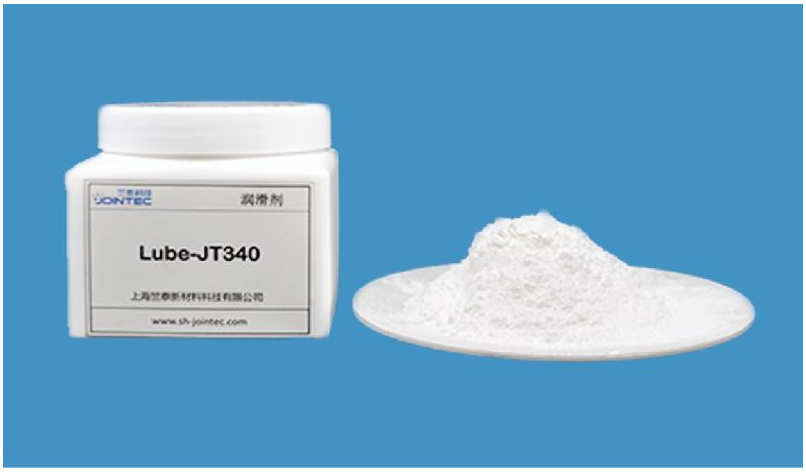
PM Lubricant Lube JT-340



Lube JT-340 is a modified wax base lubricant, which retains the advantages of wax, such as easy dewaxing and spot free. Lube JT-340 is a product with excellent comprehensive performance. Due to its excellent lubrication performance, the surface of pressed parts is bright, which improves the service life of the mold, and it is easy to remove at sintering process. After sintering, the parts are spot free and bright, which fully meets with the high appearance surface requirements, and does not affect the subsequent processes such as heat treatment and steam treatment. There are no strict requirements on the sintering atmosphere, which reduces the cleaning and maintenance of the sintering furnace, at the same time, improves the production efficiency of PM parts. The addition amount is generally 0.6-0.8 wt.%. Compared with other conventional wax, the powder performance and lubrication performance are better. Suitable for pressing high density parts, such as gear hub, camshaft peach piece, VVT and so on.

Excellent quality for powder metallurgy product upgrading and efficient production.

Data and properties comparison

Material tested: Fe(100 mesh water atomized)+0.5%C (natural)+0.6%Lube

Powder properties

	Hall Flow s/50g (24H)	Apparent Density g/cm^3	Green strength MPa	Compressibility g/cm^3
Lube JT-340	32	3.13	13	7.12
Wax	31	3.08	14	7.12

Note: 100 Mesh water atomized pure Iron as base powder, compressed density 7.20 g/cm^3 at 600MP die wall lubrication

Sintered properties

	Tensile strength MPa	Yield strength MPa	Elongation %	dimensional change (green-sintered) , %
Lube JT-340	295	198	5.40	0.11
Wax	298	197	5.45	0.11

Note: compressed density 7.20 g/cm^3, sintered at 1120℃ for 30 min in 90/10 N_2/H_2

Main performance advantages

- Excellent lubricity, suitable for pressing high density parts, such as gear hub, camshaft peach piece, VVT, etc
- Low demoulding force, the surface of pressed parts is bright, and the service life of the die is improved
- No spots, meet the high surface requirements of the products, do not affect the heat treatment and steam treatment and other subsequence process
- It is easy to remove during sintering, and there is no strict requirement for atmosphere, which reduces the cleaning and maintenance of sintering furnace
- Low addition amount, 0.6-0. 8 wt.%, which can improve the economic benefit.

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