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(54) Titre : MATERIAU DE FRICTION, PROCEDE POUR SA PREPARATION ET GARNITURE DE FRICTION
(54) Title: FRICTION MATERIAL, METHOD OF PREPARING SAME AND FRICTION LINING

(57) **Abrégé/Abstract:**

A friction material comprising a sintered mass of iron in which graphite particles are dispersed, which sintered mass is formed from between 13 and 22 vol.% of iron fibres, between 13 and 22 vol.% of iron particles having a particle size of 10-400 µm, between 40 and 70 vol.% of graphite particles having a particle size of 25-3000 µm, and between 10 and 15 vol.% of a metallic binder having a melting point of 800-1140 °C, and a method of preparing such a friction material, wherein a mixture of these components is compressed at a pressure of at least 100 MPa so as to form a compact having a desired form and size, and where the compact thus formed is sintered at a temperature between 800 and 1140 °C for a period of time which is sufficiently long for achieving concretion of iron fibres, iron particles and metallic binder.



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(54) Title: FRICTION MATERIAL, METHOD OF PREPARING SAME AND FRICTION LINING		
(57) Abstract A friction material comprising a sintered mass of iron in which graphite particles are dispersed, which sintered mass is formed from between 13 and 22 vol.% of iron fibres, between 13 and 22 vol.% of iron particles having a particle size of 10-400 μm , between 40 and 70 vol.% of graphite particles having a particle size of 25-3000 μm , and between 10 and 15 vol.% of a metallic binder having a melting point of 800-1140 °C, and a method of preparing such a friction material, wherein a mixture of these components is compressed at a pressure of at least 100 MPa so as to form a compact having a desired form and size, and where the compact thus formed is sintered at a temperature between 800 and 1140 °C for a period of time which is sufficiently long for achieving concretion of iron fibres, iron particles and metallic binder.		

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Friction material, method of preparing same and friction lining

The present invention relates to a friction material and
5 in particular a brake lining material comprising a
sintered mass of iron in which graphite particles are
dispersed.

A number of commercially available brake lining materials
comprise particles, such as iron particles and graphite
10 particles, bonded together by an organic binder, such as
a phenol-formaldehyde resin.

If brake linings consisting of such a material are
exposed to severe energy loads and consequently high
temperatures, such as temperatures of the order of
15 700 °C, which e.g. arise when they are used in brakes for
trucks, a decomposition of the organic binder occurs
under formation of gaseous decomposition products. Hereby
the useful life of the brake linings is reduced.

Metal bonded brake lining materials are also known, viz.
20 materials comprising a sintered iron matrix containing
comparatively small amounts of dispersed graphite
particles. These known metal bonded lining materials
suffer from the disadvantage that at severe energy loads
melting may occur of parts of the iron matrix, whereby an
25 incipient welding together of the brake pads and the
brake drum or the brake disc occurs.

It is known to use brake linings which essentially
consist of graphite in brakes for Formula I racers. Such
brakes are very efficient, but they are worn down very
30 rapidly and normally only last one race.

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It has been attempted to prepare metal bonded brake lining materials having a large content of graphite particles, but these attempts have run up against the difficulty that increasing content of graphite particles in the iron matrix entails decreasing strength and consequently reduced wear resistance.

EP 0 093 673 discloses a friction material comprising a major amount (72-85 weight-%) of iron powder, graphite (3-14 weight-%), coke (2-12 weight-%), low melting material (3-10 weight-%), such as tin, and a friction modifying agent (up to 3 weight-%), some of the iron powder being optionally replaced with iron fibres.

It is the object of the present invention to provide a friction material having higher wear resistance than the friction material according to EP 0 093 673.

The friction material according to the invention is characterized in that the sintered mass comprises from between 13 and 22 vol.-% of iron fibres, between 13 and 22 vol.-% of iron particles having a particle size of 10-400 μm , between 40 and 70 vol.-% of graphite particles having a particle size of 25-3000 μm , and between 10 and 15 vol.-% of a metallic binder having a melting point of 800-1140 $^{\circ}\text{C}$.

The invention is based on the discovery that by using comparatively large graphite particles, the graphite particles normally used in metallurgical processes typically have a particle size of 0.1-10 μm , and a metallic binder having a melting point within the temperature range in which the sintering takes place, a strong and stable iron framework is formed in which the graphite particles are embedded, and from where they can be released under the influence of friction and form a film between brake pad and brake drum or brake disc.

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The iron fibres, the iron particles and the metallic binder are thus the sintering active and consequently strength imparting components, while the graphite particles are the friction controlling components of the sintering mass.

The iron fibres present in the friction material are preferably steel fibres, i.e. fibres of an iron alloy having a carbon content of up to 2%. The iron fibres preferably have a length between 0.5 and 5 mm and a thickness within the range 10-100 μm .

As mentioned, the iron particles have a particle size from 10 to 400 μm , and preferably a particle size from 20 to 200 μm .

As mentioned, the graphite particles have a particle size from 25 to 3000 μm , and preferably a particle size from 90 to 1000 μm .

As metallic binder, preferably a metallic material selected from Cu, Sn and Zn is used.

Bronze in powder form and of a type in which the content of copper is from 85 to 99 %, and the content of tin is from 1 to 15 %, is particularly useful.

The friction material according to the invention may in addition to the components mentioned above contain from 0.1 to 15 vol.-% of additional components, such as Al_2O_3 , FeSi, Fe_3Si_2 , FeSi_2 , Fe_2Si_5 , MgCO_3 , SiO_2 , BN, $\text{Ca}_3(\text{PO}_4)_2$, BaSO_4 , Fe_2O_3 , CuAl_2 , Si, Al, Cu, P, and sulphides of Mo, Mn, Sb, Cu, Sn and W.

Admixing of a ceramic material into the sintered mass causes a stabilization of the friction at fluctuating temperatures. A particularly good stabilization is

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obtained by using a ceramic material having two different grain sizes.

A particularly preferred additive is Al_2O_3 , which serves to increase the friction coefficient and keep the
5 friction coefficient constant.

The present invention further relates to a method of preparing a friction material, which method is characterized in that a mixture comprising 13-22 vol.-% of iron fibres, 13-22 vol.-% of iron particles having a
10 particle size between 10 and 400 μm , 40-70 vol.-% of graphite particles having a particle size between 25 and 3000 μm , and 10-15 vol.-% of metallic binder is compressed at a pressure of at least 100 MPa so as to form a compact having a desired form and size, and that
15 the compact formed is sintered at a temperature between 800 and 1140 °C for a sufficiently long period of time to achieve concretion of iron fibres, iron particles and metallic binder.

Optionally, iron fibres, iron particles and metallic
20 binder can be mixed prior to these components being mixed with the graphite particles.

When Al_2O_3 is to form part of the mixture of starting materials, it is preferred to disperse Al_2O_3 in water and to mix the dispersion thus formed with the graphite
25 particles, and to remove the water from the mixture prior to it being mixed with the other components.

The mixture of graphite particles and Al_2O_3 may expediently be added with a minor amount, e.g. 1-3 weight-% of an oil, such as a vegetable oil, prior to the
30 mixing with the other components.

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In the following the invention is described in more detail with reference to the example below.

EXAMPLE

22 cm³ of iron fibres, 22 cm³ of iron particles having an average particle size of 100 μm, and 15 cm³ of bronze powder having a melting point of 1040 °C were mixed in a V-mixer with internal rotor for about 10 min.

1 cm³ of Al₂O₃ particles were added to 100 cm³ of water, and the mixture thus formed was subjected to an ultrasonic treatment so as to form a homogeneous dispersion. The dispersion was mixed with 40 cm³ of graphite particles having an average particle size of 300 μm, following which the water was removed by evaporation in an oven.

The mixture of graphite and Al₂O₃ particles thus obtained was added with 2 weight-% of vegetable oil, and the composition was mixed until an even distribution of the Al₂O₃ particles on the graphite particles had been obtained. The mixture of graphite particles, Al₂O₃ particles and vegetable oil, and the mixture of iron fibres, iron particles and bronze powder were mixed in a V-mixer, internal rotor not being used for the first 5 min, and internal rotor being used for the succeeding 2 min.

The mixture thus obtained was pressed into briquettes having the dimensions 4 x 9 x 2 in a single-axis press and at a pressure of 300 MPa.

The green compacts obtained were then sintered in an oven in an atmosphere of H₂ and N₂. The compacts were first sintered at 700 °C for 0.5 h, and then at 1100 °C for 0.75 h. Finally, the sintered compacts were cooled to

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room temperature in an atmosphere of H_2 and N_2 for a period of time of 0.75 h.

The sintered compacts thus obtained were mounted on a steel plate, and the product thus obtained could
5 hereafter be used for brake linings.

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CLAIMS:

1. A friction material comprising a sintered mass of iron in which graphite particles are dispersed, wherein the sintered mass comprises between 13 and 22 vol.-% of iron fibres, between 13 and 22 vol.-% of iron particles having a particles size from 10 to 400 μm , between 40 and 70 vol.-% of graphite particles having a particle size from 25 to 3000 μm , and between 10 and 15 vol.-% of a metallic binder having a melting point from 800 to 1140°C.
2. A friction material according to claim 1, wherein the iron fibres are steel fibres.
3. A friction material according to claim 1 or 2, wherein the iron fibres have a length from 0.5 to 5 mm and a thickness from 10 to 100 μm .
4. A friction material according to any one of claims 1 to 3, wherein the iron particles have a particle size from 20 to 200 μm .
5. A friction material according to any one of claims 1 to 4, wherein the graphite particles have a particle size from 90 to 1000 μm .
6. A friction material according to any one of claims 1 to 5, wherein the metallic binder is selected from a group consisting of Cu, Sn and Zn.
7. A friction material according to claim 6, wherein the metallic binder is bronze containing from 85 to 99% of copper and from 1 to 15% of tin.
8. A friction material according to any one of claims 1 to 7, wherein the sintered mass is formed from a

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mixture which additionally contains from 0.1 to 15 vol.-% of additional components.

9. A friction material according to claim 8, wherein the additional components are one or more items selected from a group consisting of Al_2O_3 , FeSi , Fe_3Si_2 , FeSi_2 , Fe_2Si_5 , MgCO_3 , SiO_2 , BN , $\text{Ca}_3(\text{PO}_4)_2$, BaSO_4 , Fe_2O_3 , CuAl_2 , Si , Al , Cu , P , and sulphides of Mo , Mn , Sb , Cu , Sn and W .

10. A friction material according to claim 8, the additional components comprise a ceramic material.

10 11. A friction material according to claim 10, wherein the ceramic material is present in the sintered mass in two different grain sizes.

12. A method of preparing a friction material in the form of a sintered mass of iron in which graphite particles are dispersed, wherein a mixture comprising 13-22 vol.-% of iron fibres, 13-22 vol.-% of iron particles having a particle size between 10 and 400 μm , 40-70 vol.-% of graphite particles having a particle size between 25 and 3000 μm , and 10-15 vol.-% of metallic binder is compressed at a pressure of at least 100 MPa so as to form a compact havinag a desired form and size, and that the compact thus formed is sintered at a temperature between 800 and 1140°C for a sufficiently long period of time to achieve concretion of iron fibres, iron particles and metallic binder.

25 13. A method according to claim 12, wherein iron fibres, iron particles and metallic binder are mixed prior to these components being mixed with the graphite particles.

14. A method according to claim 13, wherein the graphite particles are used in mixture with Al_2O_3 particles.

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15. A method according to claim 14, wherein the mixture of graphite particles and Al_2O_3 particles is prepared by dispersing Al_2O_3 particles in water, mixing the dispersion thus formed with graphite particles, and removing the water
5 by evaporation.

16. A method according to claim 14, wherein the mixture of graphite particles and Al_2O_3 particles additionally contains oil in an amount of 1-3 weight-%.

17. A brake lining comprising a friction material
10 according to any one of claims 1 to 11.

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