

Method of manufacturing of antifrictional material includes reception of dry furnace charge, mixing of powder-like components of antifrictional material, molding and sintering of furnace charge. Before molding dry furnace charge is mixed with straw oil which amount is equal 1-7 per cent by weights, and then it is sintered. Element of friction unit includes a bearing element, antifrictional and intermediate layers on the basis of iron and copper and it contains ferrophosphorus. Bearing element of the unit is made of from low-carbon steel and has thickness of 1 - 250 mm, the thickness of intermediate layer makes 0,2-0,5 mm, thickness of antifrictional layer - 0,5-15 mm. The method of manufacturing of friction unit element, which consists of a bearing element, antifrictional and intermediate layer, includes application on bearing element and sintering of furnace charge of intermediate layer on the basis of a mix of powders of iron and copper, application on intermediate layer and sintering of furnace charge of antifrictional layer on the basis of a mix of powders of iron and copper. To the composition of furnace charge of intermediate layer is added ferrophosphorus. Thus before application on bearing element the furnace charge of intermediate layer is mixed with kerosene, and furnace charge of intermediate layer is poured through a sieve by dosed portions and furnace charge of intermediate layer is sintered at temperature of 1083 - 1150 °C in atmosphere of protective gas. The furnace charge of antifrictional layer is molded by rolling by dosed portions between rollers of rolling mill and sintered at temperature of 940 - 1083 °C in atmosphere of protective gas.