



## DIE CASTING LUBRICANTS

Die castings the process of forcing molten metal under high pressure into mold cavities (which are machined into dies). Most die castings are made from non-ferrous metals, specifically Zinc, Copper, Aluminium, Magnesium, Lead and Tin based alloys, although ferrous metal die castings are possible. The die casting method is especially suited for applications where a large quantity of small to medium sized parts are needed, ensuring precise surface quality and dimensional consistency.

This level of versatility has placed die castings among the highest volume products made in the metal working industry.

The following oil base lubricants are recommended for die-casting applications.

PRODUCT	Lubricant	Viscosity (CPs at 25°C)	Particle size Microns	Specific Gravity (gms/cc)	Diluent	Flash Point°C	Application	Pkg (kgs)
LUBRICOTE-X 27	Graphite	1300 -1500	35 - 40	0.96-1.10	Oil	220 min.	Plunger lubrication for cold chamber high pressure die casting of Aluminium. Apply by Dip or Swab	25
LUBRICOTE-X 54	Graphite	1500 -1800	30 - 35	1.05	Mineral	220	Plunger lubrication for cold chamber high pressure die casting of Aluminium. Apply by Dip or Swab	25