

CASTER ACE NO. 160X

(Water soluble lubricant for Aluminum die-casting.)

Caster Ace No. 160X is a water soluble emulsion type die release agent, which is based on refined mineral oils and high purity organic synthetic compounds.

It is usually determined by ingredients of a die lubricant at what temperature the die lubricant will start wetting the die surface.

A die lubricant which has the ability to adhere to the die surface of high temperature, will wet and cool down the die quickly, and if, once the die surface is cooled down, the lubricant will adhere to the die more easily and will form a film on it.

However, it is said that the die lubricant film should be "controlled film" and should be neither too thick nor too thin. If the film is too thick, the incoming metal might engulf the film and take it away, which will cause a problem of gassing or flow lines. If too thin, the film might be torn partially, and it will induce soldering or galling from insufficient die release.

Caster Ace No.160X adheres to a die surface of high temperature, while, even under relatively low temperature, it is designed to form a "controlled film". Therefore, it will provide a good die release under a wide range of die temperatures.

Performance Benefits

1. Excellent casting surfaces
2. No build up or clogging of spray heads
3. Suitable range is medium to high Temperature

Typical Properties

Appearance:	White to light yellow
Specific Gravity(15°C):	0.98
Viscosity(25°C):	7.0Mps
P H:	9.4
Flash Point:	None

Use

1. Dilute with water
2. For ADC10 and 12, we recommend an initial dilution rate of 80-120 to 1.
3. For ADC6, we recommend an initial dilution ratio of 40-80 to 1.

Storage

Products should be stored on their sides in a clean, dry place and protected from extremes of temperature.

Health and Safety

Under normal conditions of use is not known to offer any serious health hazard. We would however, recommend good standards of industrial hygiene are observed when handling this product.

Package

18 kilogram pail /180 kilogram drum