

CASTER ACE NO. 360

(For Zinc / soluble with water, kerosene or solvent)

Caster Ace No. 360 is a new die release compound, soluble in ordinary tap water, kerosene or other light petroleum fractions. Due to its versatility and the fact it provides good die release for even intricate and hot running jobs, it has solved many problems for die casters.

Caster Ace No. 360 is supplied as a stable fluid, which does not separate. Initial testing is started by thinning 1 part of Caster Ace No.360 with 30 parts of water whatever dilution you desire. This dilution will work fine on most jobs--but many jobs will take much higher dilution.

In some cases, such as short-run Aluminum work, where dies are not water-cooled, Caster Ace No. 360 has been thinned with 25 to 50 parts water and sprayed on the die between each shot. Such a high water percentage cools the die substantially especially when spray time is increased a few seconds. Of course, severe draft angles or other factors may demand a much lower water ratio.

When automatic spray is applied after each and every casting cycle, it is obvious that greater dilution can be employed than when spray is manually applied after every 3 or 4 casting cycles.

The base oils in Caster Ace No. 360 have been carefully balanced and selected in terms of boiling and flash points so there will be a minimum of gassing or possible entrapment of volatile fractions. This means fewer rejects due to porosity.

For best results Caster Ace No. 360 should be applied with spray systems, either manually operated or automatic. It will not clog any spray gun. When used and diluted properly there is no

problem with die coating "build-up" or staining of castings.

Caster Ace No. 360 contains no silicone or other troublesome material. Since it contains no water when shipped from our factory it is unaffected by freezing temperatures.

Typical Properties

Appearance:	Yellowish Brown
Specific Gravity(20°C):	0.91
Viscosity(20°C):	245Mps
Flash Point:	230°C
P H:	7.5

Use

1. Dilute with water or kerosene
2. For average jobs, dilute with 60 parts of water or 80 parts of kerosene.
3. Find the best mixture for your job, since job condition is different.

✧ For safety, keep it away from extreme heat when it is diluted with kerosene.

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