

## **CASTER ACE NO. 363**

**(For zinc / soluble with water, kerosene or solvent)**

Caster Ace No. 363 is an improved die lubricant based on Caster Ace No. 360, to increase the effectiveness of die release, and Caster Ace No. 363 can be diluted with water, kerosene, or solvent.

Caster Ace No. 363 does not interfere with paint or plate adhesion as it contains no material such as pigment, wax or silicon, and it never separates even after being substantially diluted.

For aluminum jobs (No. 363 is suitable for rather small or thin castings), start with 30 to 1 dilution and it is possible to increase the dilution ratio finally.

For zinc jobs, start at 50 parts water, but most jobs will run at a 80 to 1 dilution.

In both aluminum and zinc jobs, if the die temperature is relatively low, dilute with kerosene or solvent. Or when water is used, lower the dilution ratio and apply less quantity.

On the contrary, if the die temperature is relatively high and it is required to cool off the die, increase the dilution ratio with water and spray substantially. If this remedy is not enough to get a satisfactory die release, use kerosene or solvent for thinner.

### **Performance Benefits**

1. Excellent die release
2. Provides a film that resists soldering
3. Promotes metal flow
4. None of stained castings or "build-up" on the die.
5. Brighter & cleaner finish

### **Typical Properties**

Appearance: Oil type brown liquid  
Specific Gravity(20°C): 0.91  
Viscosity(20°C): 185Mps  
Flash Point: 230° C  
P H: 7.6

### **Use**

1. Dilute with water or kerosene
2. For average jobs, dilute with 60 parts of water or 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