

## **Plunger Ace No. 25**

**(Water based plunger tip lubricant)**

When using water based plunger tip lubricant, it is very important to disperse it as widely as possible upon its initial application, because water based one does not spread after surface contact also create a thinner film, which will help to insure the complete vaporization of the water before the molten metal is injected into the mold.

Therefore, it is best to apply Plunger Ace No. 25 by dripping the lubricant into the sleeve from the pour hole and swiftly dispersing it with a blast of compressed air.

### **Performance Benefits**

1. Contains carefully selected ingredients, which ensure good performance.
2. Forms a strong film, which possesses excellent heat resistance and lubricity
3. Does not affect the castings
4. Will not clog spray nozzles or build up.
5. Contains nothing that would be injurious to workmen under normal conditions of use

### **Typical Properties**

Appearance: Black emulsion  
Specific Gravity(15°C): 1.01  
Viscosity(25°C): 830Mps  
PH: 9.0

### **Use**

1. Apply a quick blast of compressed air blow immediately after dripping. No 25 will disperse ideally if the compressed air is discharged within 0.5 seconds after dripping.
2. The blast of compressed air should be for a period of two seconds or more. 4kg/cm air pressure or more is desirable for the compressed air.
3. A copper pipe for the compressed air should be 4mm or more (in inside diameter). An inside diameter of 6mm would be better when the pipe is longer than 3 meters.

### **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