

DIEDRESS - 1400**(Boron Nitride base coating For GDC & LPDC)****PRODUCT :**

Diedress – 1400 is specially designed coating. Unique property of coating gives excellent release and hence better life of diecoat.

FUNCTION :

In GDC and LPDC, castings are produced with larger / thinner sectioned aluminium alloys. When hot metal (aluminum alloy at 720°C) is cast into die (at 250°C) the rate of heat extraction from the metal will be high and as a consequence fluidity of the cast metal will be reduced. Correct use of an insulating coating can control the rate of heat extraction in various parts of the die and so retain fluidity as well as provides a desirable directional solidification pattern in the casting

APPLICATION:

Dilute the coating with soft water in the ratio 1:3-5 (Product : Water) mix uniformly and apply coating by spraying. The application of the coating is varies from very thin, where maximum chilling is required and thick on runners, feeders, thin cast sections, etc.

Spray the diluted coating on to the die and core faces using a good atomizing gun. The die temperature should be between 180 to 220°C so that the spray hits and dries quickly without running. Then re-heat the die to normal working temperature before casting metal.

SPECIFIC PROPERTIES:-

1. Colour & Appearance : Off White Thick Liquid
2. Specific gravity in gm/cc. : 1.64 – 1.68.

INSTRUCTION :

- * Dilute the Diedress – 1400 @ 1:3-5 (Coating: water). Mix it thoroughly.
- * Clean the Tools i.e. should be free from Rust, Grease etc.
- * Pre-heat the tools at a Temp.180°C -220°C Apply the coating by spraying application.

ADVANTAGES DUE TO BN:

- *Non wetting to aluminium
- *Protects metallic dies with critical geometry/design.
- *Reduce maintenance cost
- *Life of coating is more compare to talcum based coating.

PRECAUTIONS:- Ensure that diluted coating is of uniform consistency.

Ensure that coated tools are free from moisture for usage.

STANDARD PACKING :-1 & 5 KG.P.C

SHELF LIFE : 6 Months from the date of manufacturing.

STORAGE : Store in cool & dry place with intact packing.