

## PRODUCT DATA SHEET

### **DIEDRESS – 4250E**

(Lubricant for die face and plunger lubricant in high pressure die-casting)

#### **PRODUCT :-**

DIEDRESS – 4250E is a graphite base creamy lubricant specially developed for lubrication of deep draw and difficult release areas on die face and as plunger lubricant.

#### **PURPOSE :-**

In pressure die casting process, molten aluminum is injected into the die cavity at a very high velocity. This leads to attack of molten aluminum on die face which results to soldering or welding of castings to the die face. The problem of soldering is more severe in hot spot areas such as in-gates, runners, deep draws, plungers etc.

Normal graphite in oil type lubricants tend to give stains or fumes etc.

DIEDRESS – 4250E is designed in such a way that it imparts superior anti- soldering properties to die surface and thus ensures easy casting release.

#### **ADVANTAGES :-**

1. Better casting quality.
2. Increases plunger tip life.
3. Reduce rejection as soldering is minimized.
4. Improves productivity because of easy casting ejection and better plunger life & thus reduces the down time.
5. Consistent performance because of better suspension and easy remix ability property.
6. Better working conditions because of less fumes.

#### **APPLICATION:-**

Stir the container well; ensure that die surface is clean before application of DIEDRESS -4250E. Apply DIEDRESS- 4250E on plunger tip, in the hot spot, deep draw areas etc. by brushing or swabbing. Application frequency depends upon complexity of die.

#### **SPECIFIC PROPERTIES :-**

1. Appearance : Black creamy liquid
2. Specific gravity :  $1.00 \pm 0.1$  gm/ cc

**STANDARD PACKING** -20 liters. P.C.

**SHELF LIFE** :- 1 year from the date of manufacturing

#### **SAFETY PRECAUTIONS -**

1. Avoid direct exposure to flame and fire.
2. Replace lid tightly after use.