

DATA SHEET

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B-TECH RELEASE 65

**Release agent for high pressure
die-casting of light alloys****DESCRIPTION**

Aqueous emulsion based on a compound of lubricants, polymers and special additives, completely synthetic.
High performance die lubricant for high pressure die casting of light alloys.


TECHNICAL DETAILS


<i>Physical form:</i>	liquid	<i>Density (20°C):</i>	appr. 0.990 g/ml
<i>Colour:</i>	white	<i>Boiling Point:</i>	appr. 100 °C
<i>Odour:</i>	very mild	<i>Flammability:</i>	not flammable
<i>pH (pure):</i>	approx. 9.5	<i>Miscibility:</i>	miscible in water


SPECIFICATIONS

TEST	METHOD	STANDARD LIMITS
Appearance	Vis. (AO/1)	white liquid
pH (pure prod.)	Ind. strip (PM/2)	8.0 – 9.5
Chem-phys. stability	Centrif. A (SE/4)	creaming max 5% settling max 1%


CHARACTERISTICS

 B-TECH RELEASE 65 has been specially formulated to enhance the releasing power keeping the die clean from scale residues and soldering. Moreover it prevents the build up due to carbon lacquers.


 B-TECH RELEASE 65 is suitable for general purpose and is also indicated for high weight/dimension pieces. It ensures an enhanced capacity of flowing and compaction of the melted alloy.


 B-TECH RELEASE 65 is a low smokiness, low environmental impact product.

HOW TO USE


 Dilute with automatic mixer, or pour the product into water and stir briefly to get good homogenisation.

It is not necessary to shake the diluted product during the use.


 The best usage dilution depends on the specific cast/mould, thicknesses, configuration, range of temperature and lubrication cycle, and therefore must be determined by means of empirical tests. The initial suggested dilution percentage range is: 1:100 (1.0%) to max 1:50 (2.0%).

 Apply the diluted product with manual or automatic spraying system at a pressure of 4 - 6 bar. Do not blow compressed air into the diluted product.

STORAGE

 Avoid storage with exposure to direct sunlight. Do not store near heating sources. Store at temperatures not above +35 °C.

 Store at temperature above +5 °C.

 Shelf life: not less than 12 months, in the original unopened packaging. Keep containers closed in order to avoid water evaporation and contamination of the product.

In case of longer storage (over 4 months) stir the product briefly in the original container before using.

PACKAGING

Drums: 200 Kg Net

Tanks: 1000 Kg Net (IBC)

FURTHER INFORMAT.

Like for all die lubricants of the CASTING series, the casts obtained with this product are "paintable". It is advisable, however, to carry out preventive tests on the castings produced in the specific application conditions.

For information regarding safety, transport and disposal, refer to the Safety Data Sheet of the product.

The data in this technical information sheet correspond to the properties of the product at the time of the sale and with regard to the specified application. It is on the responsibility of the user to make sure that the product is suitable for the use to which he intends to apply it.