

DATA SHEET

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B-TECH RELEASE 79**High performance Die Lubricant for die-casting of structural and complex castings****DESCRIPTION**

High performance product, based on an emulsion of precious semi-synthetic active materials and performance additives, used as lubricating release agent in high pressure die-casting of Aluminium and Magnesium alloys. Developed for the die casting of high integrity castings (structural pieces) it is also suitable for complex or large parts.

TECHNICAL DETAILS

Physical form: milky liquid
Colour: white
Odour: typical
pH (pure): 9.5

Density (20°C): 0.985 g/ml
Boiling Point: appr. 100 °C
Flammability: not flammable
Miscibility: miscible in water

SPECIFICATIONS

TEST	METHOD	STANDARD LIMITS
Appearance	Vis. (AO/1)	milky white liquid
pH (pure prod.)	Ind. strip (PM/2)	9.0 – 10.0
Chem-phys. stability	Centrif. A (SE/4)	creaming max 5% settling max 1%

CHARACTERISTICS

☒ Very high adhesion of the film to the die surface which ensures optimum molten metal flow as well as high sliding power for any moving parts of the die. Moreover:


- Filling of the cavity is assisted even in case of thin walled parts;
- Sticking phenomena are significantly reduced, leaving the die surface free of soldering and other hard residues.


🔧 B-TECG RELEASE 79's special formulation allows depositing the film in a broad range of temperature, ensuring good performance at higher temperature as well as in colder zones of the die.

💧 Its «clean» formulation, free of hard polymers, prevents build-up and does not release residues:

- It does not pollute the castings destined to the thermal treatments;
- It does not induce entrapped gas into the castings.

HOW TO USE

 Dilute with automatic mixer, or pour the product into water and stir briefly, the blending is immediate. It is not necessary to stir the product during the use. It is not indicated to blow air into the bulk. Avoid to dip contaminated pipes into the product.


 The suggested dilution percentage range is: 1:100 (1.0%) to 1:33 (3.0%) referred to Aluminum alloys die casting.

The best usage dilution depends on the specific mould, on its range of temperatures and many other parameters and could even be higher than the suggested range in order to strongly promote flowing of the alloy.


Do not stir vigorously the diluted product. Do not blow air in the bulk to avoid foaming.

 Apply the diluted product with manual or automatic spraying system.

STORAGE


 Avoid storage with exposure to direct sunlight. Do not store close to heating sources. Store at temperatures below +40C.

 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 (cube)

FURTHER INFORMAT.

Like for all die lubricants of the CASTING series, the castings obtained with this product are "over-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 corresponds 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 she/he intends to apply it.