

CASE STUDY 125

[NEW SERIES DIE FACE LUBRICANT FOR ALUMINIUM HPDC CASTINGS]



CUSTOMER DETAILS:

One of the largest aluminium casting manufacturers from Western India producing castings for the two-wheeler industry.



OBJECTIVE FOR TRIAL:

- 1 To reduce the cost of die face lubricant
- 2 Good surface finish
- 3 No soldiering
- 4 No peel-off problem after shot blasting



OPERATING/ APPLICATION DETAILS:

Machine make	- High pressure Yuzumi diecasting machines of different tonnages 400/650/800/900
Components	- Crankcase/Cover
Material	- Aluminium
Component Weight	- 400 gms to 4 kgs
Dilution Ratio	- 1:125 to 1:130
Sprayer Type	- Manual & Auto
Die Temperature	- Before spray 320-330 deg C & After spray - 220-230 deg C
Present product	- Wacker Metroark 3027

PRODUCT RECOMMENDED: HILUBRIC LH 2228



COMPONENT DETAILS



CRANK CASE



COVER

TRIAL RESULTS



Good surface finish



No major break down



No soldiering/ catching/peel-off



Dilution ratio 1:125-1:130 against competitor 1:90



Overall Cost savings achieved 7-8 %