

HOUGHTON®-CAST 420 M

Water Soluble Diecasting Release Agent & Forging Lubricant

DESCRIPTION

HOUGHTON®-CAST 420 M is based on a blend of additives, which provide good adhesion on the die surface and excellent surface wetting properties which improve die release properties and resist soldering and galling.

HOUGHTON®-CAST 420 M is successfully used for non-ferrous forging and aluminium alloys high pressure die casting.

APPLICATIONS

HOUGHTON®-CAST 420 M is a water-based diecasting release agent formulated for use mainly in cold chamber high pressure aluminium, magnesium and some zinc, lead and brass diecasting operations.

HOUGHTON®-CAST 420 M has been designed for the manufacture of diecast parts that are subsequently painted or plated and can be cleaned with water based cleaners, removing the need for abrasive cleaning methods.

HOUGHTON®-CAST 420 M form on the die and the mold a translucent coating with excellent mold release and lubrication properties. This coating allows a good metal flow during hot forming, leaving a adherent and resistant film on the die and mold, even when is at high temperature.

RECOMMENDATION FOR USE

HOUGHTON®-CAST 420 M is normally diluted with water and manually or automatically sprayed onto the dies.

Typical working dilutions - (it can be used outside these suggestions for some operations)

High pressure diecasting - aluminium/magnesium - 30:1 - 150:1 (0.70% - 3.00%)

Die Temperatures

Diecasting - typically >200°C, ideally 300°C to 400°C.

Non-Ferrous Forging : 5 to 20%

TYPICAL PHYSICAL PROPERTIES

<i>Appearance</i>	<i>Milky white liquid</i>
<i>Specific gravity @ 20°C</i>	<i>0,99</i>
<i>pH</i>	<i>9,4</i>
<i>Refractometer factor</i>	<i>5</i>

BENEFITS

- Reduces costs - use at very high dilutions in water, improves productivity by providing good metal release, allows metal to flow through the dies, extends ejector pin life.
- Reduces costs - excellent lubricity reduces scrap, extends die life by preventing build up of solder in the dies, good microbiological resistance, parts are easy to clean
- Eliminates staining - compatible with yellow and non-ferrous metals, brighter cleaner parts
- Operator friendly - non-irritating to skin, clean working environment, easy to mix with water and to check concentration

ADDITIONAL PRODUCT DATA

It is recommended that dilutions are made with suitable mixing equipment. If manually mixing, add product to water while mixing for best results.

RELATED PRODUCTS

Houghton specialises in products and services for Heat Treatment, Machining and Grinding, Cleaning, and Fire Resistant Hydraulic Fluids and Industrial Lubricants. For more information, please contact your local Houghton representative.

STORAGE

Please refer to section 7 of Safety Data Sheets for handling and storage information, including product shelf life. Product should be stored under cover in clean, dry conditions and protected from frost. Recommended storage temperature is usually between 5°C and 40°C unless otherwise specified. Product may separate if frozen. Use stock in delivery rotation.

HEALTH AND SAFETY

Safety data sheets are available in accordance with Regulations (EC) No 1907/2006 Annex II and (EC) No 1272/2008.

FB 2016/11/02 GB



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