

CASE STUDY 131

[COST EFFECTIVE DIE FACE LUBRICANT FOR AUTOMOTIVE CASTINGS]



CUSTOMER DETAILS:

A renowned die-casting component manufacturer of India having plants in the West of Maharashtra and globally. The main components manufactured by the company include two-wheeler cylinder block, base bracket, base plate.



OBJECTIVE FOR TRIAL:

- To reduce the cost of die face lubricant
- Need to achieve the required finish



OPERATING/ APPLICATION DETAILS:

Description	Specification
Machine Make	: 840 T Buhler
Component	: Cylinder Block
Material	: ADC 12
Component Weight	: 3 to 4 kgs
Dilution Ratio	: 1:100, 1:120
Sprayer Type	: Manual
Spray Time	: 6-8 sec [Moving & Fixed die]
Die Temperature	: Before spraying 230-240 deg C & After spray - 160- 170 deg C
Present product	: xxxx

PRODUCT RECOMMENDED: HILUBRIC LH 2223



COMPONENT VIEW:



TRIAL RESULTS



Finish was
ok



No Ejector
noise recorded



No soldiering



Overall Cost savings
achieved – 5-7 %