

## Topic: Plunger Lubricant for Aluminum Die Casting Process

980Oils Products	RANDOCAST PL31 (Water Base Type)
Applications	Plunger in Aluminium Die Casting
Customer /Location	SPT/Phra Nakhon Si Ayutthaya, Thailand
Previous Lube/Fluids	China
Materials	Aluminium, ADC12
Process/Machines	Aluminium Die Casting
Customer Requirements	Usage Quality Improvement

### Issue/Problems:

Usage Quality Improvement.

### Solutions:

Machine: DCC-1600 Impress-Plus (1,600 Tons)

Dosage: 0.2 sec./shot

Experimental		
Product	Randocast PL31	Current Product
		
Observation Results	Smoke: ■ Level 	Smoke: ■■■■ Level 
	Fire: ■ Level 	Fire: ■■■■ Level 
	Noise: No No problems with friction noise in the plunger	Noise: No No problems with friction noise in the plunger
	Part: At the head of gate 	Part: At the head of gate 
	Consumption: 10 Liters/day/machine	Consumption: 15 Liters/day/machine

### Summary:

1. Smoke and fire generation appear to have decreased from before.
2. At the head of gate on workpiece, there are no black stains and no burn marks.