

ALU-JECT



DESCRIPTION

► ALU-JECT is a non-pigmented, water based lubricant designed for billet end coating. It is formulated using organometallic compounds which apply a boundary film to prevent welding of the billet to the dummy block, providing excellent release characteristics.

► ALU-JECT is capable of wetting temperatures as high as 1112 °F (600 °C).

PRECAUTIONS

ALU-JECT should be stored in a cool dry place. The product can withstand freezing, however it should not be allowed to have more than one freeze/thaw cycle. Partially used containers should be re-sealed to prevent evaporation and contamination.

ALU-JECT LIQUID



USAGE

- ☒ Hot Billets (unoxidized surfaces)
- ☒ Shear Blade
- ☒ Container sealing surface
- ☒ Hot Dummy Block

DILUTION

ALU-JECT is diluted by adding water to the lubricant

DILUTION RATIO'S

Typical dilution ratio is 1:3/ (ALU-JECT:WATER) and is recommended for initial evaluations. Actual dilutions will vary according to the application technique.

APPLICATION

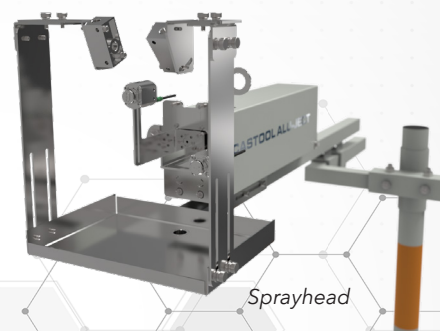
ALU-JECT should be sprayed to achieve the best results. Spray application provides a uniform film thickness, which allows lower friction values, however the product can be successfully swab applied.

PHYSICAL PROPERTIES

CHARACTERISTICS	VALUE
Appearance	Amber Liquid
Carrier/Diluent	Water
Active material	23%
Viscosity Afnor Ford Cup#6	70 seconds
Viscosity Cinematic@40°C	600 mm ² /s
Density	9.15 lb./gal. 1.096 g/cm ³
pH (concentrate)	8-10
Shelf Life	1 year

LIQUID BILLET LUBRICATION SYSTEM

Castool has developed a unique process of application for a liquid soluble lubricant to a preheated extrusion billet or tool. The obstacle to their use is the Leidenfrost affect, which makes it difficult to coat a surface hotter than 1112 °F (600 °C) with a water based product. This application process enables improved coverage and reduces overspray and cost.



BENEFITS AND FEATURES

ALU-JECT LIQUID

- ✓ Does not contain graphite or boron nitride
- ✓ Highly economical
- ✓ Easy to mix and dilute
- ✓ Easily applied by automatic or manual spray equipment
- ✓ Stable solution - no settling or splitting
- ✓ Safe to use

ALU-JECT STICK

- ✓ Minimal smoke
- ✓ Does not contain graphite or Boron Nitride
- ✓ Good flow characteristics

ALU-JECT PB TABLETS

- ✓ Minimal packaging
- ✓ Less inventory/less space
- ✓ Ensure good dilution ratio
- ✓ High lubricating/parting properties
- ✓ Safe to use
- ✓ Less carbon dioxide
- ✓ No waste
- ✓ Low energy consumption in initial manufacturing

ALU-JECT can be used to reduce costs and significantly improve productivity



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ALU-JECT STICK

ALU-JECT STICK : A cream colored, sodium-based soap, supplied in the form of solid soap bars. No graphite, excellent lubricity, good adherence.



APPLICATIONS

- Aluminum Extrusion lubrication of dummy block, billet face, container seal face, billet and butt shears etc.
- Lubricating Steel Wires following surface grinding (after welding).
- The product can be used to lubricate most steel surfaces.

"ALU-JECT Stick should be stored in a cool dry place. Please refer to the "Safety Data Sheet" for proper handling and first aid instructions."

USAGE

- ✓ Hot Dummy Block
- ✓ Shear Blade
- ✓ Container sealing surface

CHARACTERISTICS	VALUE
Appearance	Off white
Odor	Mild "soapy"
Decomposition temperature	149°C (300°F)
Temperature of Storage	0-50°C (30-120°F)
Shelf Life	2 years
<small>Above details are issued from a production average; they are not specifications</small>	

ALU-JECT PB TABLETS

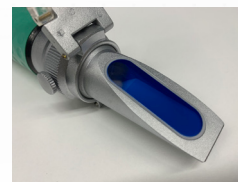
ALU-JECT PB Tablets : A non-pigmented, lubricant in tablet form designed for billet end coating. It is formulated using organometallic compounds which apply a boundary film to prevent welding of the billet to the dummy block; providing excellent release characteristics.



USAGE

- ✓ Hot Billets (unoxidized surfaces)
- ✓ Shear Blade
- ✓ Container sealing surface
- ✓ Hot Dummy Block

OCULAR REFRACTOMETER



OCULAR REFRACTOMETER

A hand held refractometer with Brix scale to measure water based soluble fluids concentration.

Calibrate with distilled water or water used to dilute product.

Reference temperature : 20 °C (68 °F)

