

HIGH PRESSURE DIE CASTING RELEASE AGENTS

WATER – BASED PRODUCTS

Product	Cast Metal	Remarks
ISOLAT 911	Aluminium Magnesium Zinc	Release agent based on synthetic oils; Suitable for a wide spectrum of castings, ranging from large and heavy parts to smaller castings.
ISOLAT Enviro 911	Aluminium Magnesium	Same as Isolat 911, but based on natural oils.
ISOLAT 4007	Aluminium Magnesium	Hydrophobic emulsion based entirely on synthetic oils. This product yields exceptionally bright casting surfaces.
GRAPHITEX CR 3401	Copper Brass	Graphite-based release agent for yellow metals.

OIL- AND SOLVENT- BASED PRODUCTS

Product	Cast Metal	Remarks
ISOLAT UP 27 <i>Minimal spray lubricant</i>	Aluminium Magnesium Zinc	<p>Synthetic die release oil with extreme release power; <u>Suitable as minimal spray lubricant:</u> Recommended as a coating for new dies; this product forms a permanent patina on the die surface. It can either be applied on its own or in conjunction with water-based release agents.</p> <p>Bright casting surfaces are guaranteed.</p>
ISOLAT N	Aluminium Magnesium	Mineral oil-based die-oil to be used either by its own, or in conjunction with water-based release agents
ISOLAT ZN 90	Zinc	Solvent/oil-based release agent for zinc and its alloys; suitable even for the most complex castings. This product can be further diluted with light hydro carbons.
ISOLAT SOLVENT No. 1	Zinc	Solvent-based release agent; ready for use.

PASTE RELEASE AGENTS

Product	Alloy	Properties
ISOLAT TM 201	Aluminium Magnesium	Aluminium pigmented release agent incorporating a ceramic bonding agent.
ISOLAT TM 201 B	Aluminium Magnesium	Smoother modification of Isolat TM 201.
ISOLAT P22	Aluminium Magnesium Zinc	Transparent release agent, primarily recommended for zinc castings, but it can also be used on aluminium instead of silver grease.
ISOLAT UP 27 Paste	Aluminium Magnesium Zinc	Light coloured paste for the formation of a permanent die release coating.
TREWA S	Aluminium	High acidic anti-welding grease, which is capable of dissolving aluminium residues sticking to the die surface.
TREWA RA	Aluminium	Anti-welding grease with reduced acid.

SPECIALITY PRODUCTS

Product	Type	Appearance	Application
ISOLAT® CU Paste	Copper PTFE (copper paste)	Copper	Injector pin lubrication, assembly lubricant.
ISOLAT® MBO	Grease	Dark grey	All moving parts of the die-casting machine.
SUPRA COATE Aqueous	Aqueous product	Light grey	Ceramic ladle coating for the prevention of metal sticking. This product can be diluted with water.
ANTIBACT	Liquid	Brown	Protection of aqueous systems against bacteria.

HIGH PRESSURE PLUNGER LUBRICANTS

OIL- BASED PRODUCTS

Product	Type	Application
ISOLAT® 108 SP	Thin graphite oil.	Dosing pump
ISOLAT® 208 SP	Viscous graphite oil.	Dosing pump
ISOLAT® 308 SP	Soft graphite grease.	Manual
ISOLAT® 128 PP	Thin, light coloured ester oil.	Dosing pump
ISOLAT® 228 PP	Viscous ester oil.	Dosing pump
ISOLAT® 218 PL	Light coloured mineral oil of medium viscosity.	Dosing pump

WATER-BASED PRODUCTS

Product	Type	Application
ISOLAT® WPL	Concentrated emulsion-type lubricant, milky colour.	Application by spray; product can be diluted with water.
ISOLAT® G	Emulsion-type lubricant with graphite added.	Application by spray. Product can be diluted with water.

PLUNGER BEADS

The FOCHEM INTERNATIONAL plunger beads are made from ultra- pure, high melting point synthetic waxes. The globules are perfectly round, free flowing, anti-static and dust-free.

FOCHEM INTERNATIONAL'S beads effectively protect the shot sleeve against aluminium erosion. Due to the exceptionally high graphite contents, the quantities used per application are considerably less, and subsequently casting porosity is minimized.

WE strongly recommend in use the TRIBO-CHEMIE "Beads Dispenser 3D". This guarantees a precise and reliable application at all times, and the overall amounts of beads can be reduced.

Product	Graphite Content	Beads Sizes	Properties
ISOLAT® 80 G	19 -20 %	0.2 – 0.5 mm 0.5 – 1.0 mm 1.0 – 1.6 mm 1.6 – 2.0 mm 2.0 – 3.0 mm	Dry beads lubricant with very high graphite content.
ISOLAT® 70 G	10 – 12 %	0.2 – 0.5 mm 0.5 – 1.0 mm 1.0 – 1.6 mm 1.6 – 2.0 mm 2.0 – 3.0 mm	Standard type of beads.
ISOLAT GW 80	30 – 40 % %	0.2 – 0.5 mm 0.5 – 1.0 mm 1.0 – 1.6 mm 1.6 – 2.0 mm	Mixture of graphite and white solid lubricant; Building up of a ceramic coating on the face of the shot sleeve.