

**Topic: Plunger Lubricant for Aluminum Die Casting Process
(BLACK BEAD: RANDOCAST PLB1)**

Plunger Lubricant for High Pressure Die Casting (HPDC) Machine

Compose of:

PLUNGER LUBE BASE	TYPE	GOOD POINTS	BAD POINTS
Water Base		<ol style="list-style-type: none"> No fire Low smoke Environment Cheap 	Tool life (Tip & Sleeve) shot
Oil Base	Graphite	<ol style="list-style-type: none"> Good lubrication Anti friction Resistance to fire Good for old machine Help to decrease porosity in the parts 	<ol style="list-style-type: none"> Graphite remains on the parts. Work area dirty Sometime graphite separate Clogging in the filter pipe
	Non Graphite	<ol style="list-style-type: none"> Good lubrication Not dirty on surface Cheaper than graphite base 	<ol style="list-style-type: none"> Big machine > 800 ton and old machine don't recommend. Less fire resistance Air bubble between tip & sleeve that make porosity
Beads	Graphite	<ol style="list-style-type: none"> Good lubrication Friction to decrease. Resistance to fire Work area to clean 	<ol style="list-style-type: none"> Expensive than oil base Graphite remains on the parts.
	Non Graphite	<ol style="list-style-type: none"> Good lubrication Part surface to clean 	<ol style="list-style-type: none"> Lubricity lower than graphite also added more

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			dropping in sleeve for high lubrication
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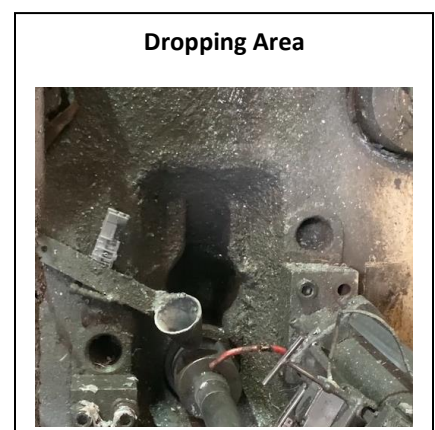
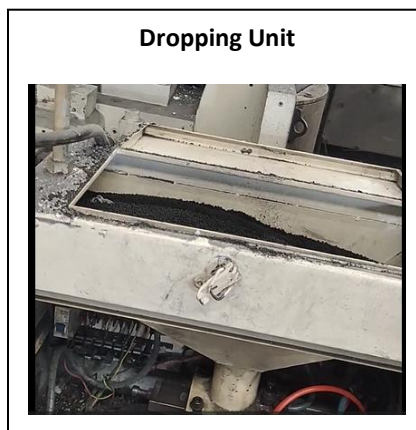
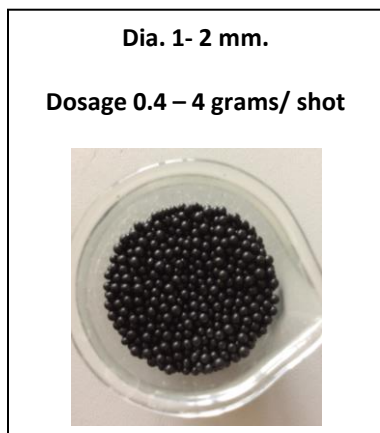
RHINOS PRODUCT	RANDOCAST PLB1 (Black Beads Graphite)
Applications	Plunger Lubricant for Aluminum Die Casting
Customer /Location	KIATA DICASTING CO., LTD/ Samutsakhon, Thailand
Previous Lube/Fluids	KERDOS CO.,LTD./source from CHINA
Process/Machines	Diecasting Process/ Toshiba 125-800 TON (Total 14 Machines)
Customer Requirements	Quality product

KIATA DIECASTING Requirement:

- Quality and Cost down.

RANDOCAST PLW1:

Machine : TOSHIBA 350 TON



Solutions :

- Dropping in diecasting machine sleeve
- Dropping quantity 2.5 Gram/Drop, 300 Kg./Month
- Total diecasting machine, 14 machine

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Summary :

- Low smoke
- Low fire
- Work area clean
- Good lubricant
- Casting surface also clean



No residue or graphite particle remains on surface.