

PRODUCT DATA

DIE KOTE[®] 7275-M

AN ECONOMICAL ALUMINUM DIE CASTING RELEASE AGENT

Die Kote 7275-M is a highly concentrated, water-based die lubricant developed for aluminum die casting. It has been formulated for use in central reservoir systems. **Die Kote 7275-M** is a balanced mixture of parting agents, anti-solder additives, corrosion inhibitors, and surfactants. It also contains a biocide.

Die Kote 7275-M will cast parts up to 75 pounds - channel plates, transaxle parts, transmission housings, finned cylinder heads, four and six cylinder engine blocks, low draft computer and aircraft parts, marine engines, valve bodies, etc.

FEATURES

- * Contains anti-solder and parting agents
- * Provides low foam stable mixture
- * Bright finish on cast parts

BENEFITS

- * Easily removed - alkaline cleaning systems
- * Improved surface finish
- * Improved pin lubrication
- * Overall cost-effective

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Appearance	Off-white emulsion
Odor	Bland
pH (neat)	9.0 - 9.5
Storage Stability	Six (6) months
Specific Gravity	0.98
Pounds per Gallon	8.1



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USE INSTRUCTIONS

Spray equipment should have adequate air pressure to ensure good atomization of the product. Be sure the entire die face is sprayed (suggest a minimum of 60 psi for air supply).

MIXING INSTRUCTIONS

Die Kote 7275-M disperses easily in water and forms a stable emulsion. It can easily be applied with hand spray guns, fixed nozzles or reciprocating units.

STARTING DILUTIONS

Medium size parts	70-90 to 1
Large parts with slides and cores	40-60 to 1

These dilutions can nearly always be extended further after the natural burnished coating provided by the lubricant has been established. This will normally take several hours.

SHELF LIFE

Six (6) months

SHIPPING CLASSIFICATION

Same as soap solutions

CLEANING

Die Kote 7275-M cleans easily in alkaline cleaning systems and will not interfere with subsequent finishing operations such as anodizing or painting.

STORAGE/HANDLING/DISPOSABILITY

No health or safety hazards exist when **Die Kote 7275-M** is stored, used and disposed of in accordance with instructions given on the Material Safety Data Sheet for this product.

WARRANTY

The information given here is considered to be correct and is offered for your consideration, investigation and verification. No warranties are expressed or implied since the use of our products is beyond our control. Statements concerning the use of Houghton products are not to be construed as recommending the infringement of any patent.

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