

PERFORMANCE SHEET

DIE SLICK® 1850 SERIES

Background

The DIE SLICK® 1850 Series is designed for excellent release and a bright cosmetic casting finish. These synthetic, petroleum-free formulations are blended specifically to meet customers' production environments.

DIE SLICK® 1850 Series Industry Applications:

- Automotive
- Heavy equipment
- Lawn & garden
- Electronic
- Consumer goods

Smart Polymer Technology

The formulations in this series incorporate Smart Polymer technology and high molecular weight alkane cross-linking agents. Uneven protection caused by temperature variation on a die surface is a long-standing challenge in the die casting industry. Temperature variation is caused by the wide-range of die size, design, complexity, parts produced, and heat profile of each system. Traditional die lubricants, unable to adapt to the disparity in die temperatures, can be suitable at protecting hot areas of the die but can cause residue build up in cooler, less demanding areas. This costly dilemma causes solder, lost production time and extra die maintenance. DIE SLICK® 1850 Series lubricants with heat activated Smart Polymer technology evolved from these challenges. These polymers were developed to form a tough protective die coating when exposed to hot areas of the die while not leaving residue build up in cooler areas.

Series Benefits

- Forms a tough thermodynamically activated die film that resists soldering on hot die areas while not building on cooler die areas. This translates to decreased downtime due to reduced die maintenance, improved part quality, and prolonged die life
- Castings are extremely bright and clean
- No staining improves production by reducing scrap and rework, and reduces the cost per part produced
- Does not cause downstream paint or coating problems
- Exhibits excellent emulsion stability when diluted, lowering consumption
- Minimal smoke provides a cleaner working environment and improves air quality for operators

Effective Product Recommendation

Since die casting production trials typically require significant equipment and resources, and involve time investments and casting loss, Quaker Houghton has established a 4-part laboratory test method for chemical testing to evaluate die lubricants and generate product recommendations. This chemical testing method is an effective approach to obtain baseline data, which is used in context of the customer's objectives to determine an appropriate replacement product.

Quaker Houghton's testing methodology greatly streamlines the lubricant selection process, assists in optimization, and can be completed within hours. This eliminates the need for extensive, time-consuming process surveying. This lab evaluation method consists of four tests including solids content, visual analysis, thermogravimetric analysis, and infrared spectroscopy.

- **Solids content** – Determines amount of active content in die lubricant
- **Infrared Spectroscopy (FTIR)** – Indicates what the functional components are in the lubricant



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- **Visual analysis** – Reveals what a lubricant will look like on the die face, demonstrating if it will stain or build up

Visual Comparison of DIE SLICK® 1850 Series vs. Competitive Product



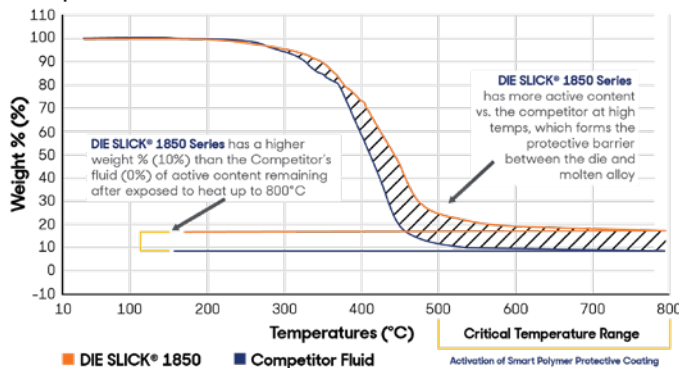
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Competitive Product

The visual comparison shows the cleanliness of the lubricant after it has been exposed to high temperatures on the die surface. Products that turn brown when exposed to high heat may result in stained castings.

- **Thermogravimetric analysis (TGA)** – Presents how much protection a die lubricant will offer at critical temperatures

TGA Curve Comparison of DIE SLICK® 1850 Series vs. Competitive Product



TGA is used to evaluate the thermodynamic stability of the active content (non-water material) of a die lubricant. This is a measurement of how much heat a lubricant can tolerate before decomposition, which is graphed as weight percent versus temperature.

Case Study: Reducing Spray Time and Improving Biological Resistance

Challenge: One of the world's largest manufacturers of small gasoline engines was looking to improve productivity within their die casting operation and optimize their process by:

- Eliminating solder and quality issues
- Improving biological resistance to minimize related maintenance

Solution: Quaker Houghton visited the manufacturing facility and worked closely with the customer to better understand their die casting production process. Quaker Houghton performed the comparative 4-part laboratory test method including FTIR spectroscopy, a visual residue evaluation, Thermogravimetric analysis (TGA) and solids content testing, as well as a thermal imaging study.

From the results, Quaker Houghton recommended a DIE SLICK® 1850 Series product with Smart Polymer Technology. Over the course of an extended trial, the product showed significant improvements in biological management, part quality, and process including:

- Improved appearance, brighter and cleaner castings
- Reduced change in temperature of die before and after spray, which means less thermal shock over the life of the die
- Increased dilution ratio by 40 points resulting in lower consumption
- Reduced spray times by up to 25%
- No smoke or staining issues, no build-up in machines or clogged spray heads

