



DYLON DYGLAZE W SERIES PROTECTIVE GLASS FORGING/EXTRUSION LUBRICANT

DESCRIPTION:

Dyglaze W Series are water dispersions of selected high temperature glass frits and binders. They can be applied by spraying, brushing or dipping. Air drying or oven drying of the coating bonds the coating to the metal. The resultant coating provides excellent surface finish and effective lubrication at high forging and extrusion temperatures. When fused, the **Dyglazes** provide a protective barrier that minimizes oxidation on and gas absorption by the coated metal. They have high "green" strength to resist chipping and spalling of the dried coating during handling prior to firing. They contain no lead and are not flammable.

USES:

Dyglazes are designed to provide protection and lubrication in the 1600 - 2200°F (870 - 1200°C) range. They are specially designed for use during the forging and extrusion of titanium, high chromium steels and nickel based super alloys. They reduce die pressures by lubricating the part-die interface allowing easy metal deformation into difficult-to-fill deep die recesses. **Dyglazes** can be used with a Dylon Boron Nitride coating (**Grade BN-897**, for example) on the dies to prevent attachment and buildup of glass stringers.

DYGLAZE W SERIES:

GRADE

RECOMMENDED TEMP. RANGE

Dyglaze W 3685
Dyglaze W-3730
Dyglaze W-3739

1600 - 1800°F (870 - 980°C)
1800—2000°F (980 - 1090°C)
2000 - 2200°F (1090-1200°C)

APPLICATION:

Surfaces should be clean and free from oil, dirt and grease. Chemical etching followed by a clean water rinse or sandblasting with a ceramic (not metal) shot is excellent. **Dyglazes** are normally used direct from the container as supplied but may be diluted with plain tap water if required to produce a lower viscosity for spraying.

The entire contents of the as-received container should be stirred thoroughly to assure all constituents are uniformly in suspension. If dilution is required, add water slowly to the concentrate, stirring constantly. Avoid high speed stirring that would entrain air bubbles in the coating. Diluted solutions should be gently stirred during use to prevent settling. If settling should occur it may be easily re-suspended by stirring.

Airless or electrostatic spraying normally provides the most uniform coatings. Brush, roller and dip methods can also be used with proper care to assure uniformity of application. The coating should be allowed to completely dry before handling. Drying time is dependent on ambient air temperature and humidity and will vary from 1 to 16 hours. Drying time can be greatly shortened by preheating the part to 140 - 250°F (60-120°C) before coating. Residue remaining after metalworking is easily removed by sandblasting or using appropriate salt baths.

PACKAGING:

1 Gallon Cans

5 Gallon Pails

55 Gallon Drums



ISO 9001:2000 CERTIFIED

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