



武汉建恒工业技术有限公司

Wuhan Jianheng Industrial Technology Co.,Ltd.

Full mold casting coating

致力于一流的工业服务

Devoting on best service for industry

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1. Application

Water-based coating for large and medium-sized castings by full mold casting. Suitable for resin sand, sodium silicate sand, cement sand and other self-hardening sand.



2. Composition & Features

The coating is in powder for easy transportation and storage.

Table 1 coating composition

SiO ₂ /%	Al ₂ O ₃ /%	Graphite/%	Binder/%	Water/%	Other/%
10-20	40-50	25-40	6-12	0.5-2	4-8

Table 2 coating parameter

Color	Density	Baume	Suspensibility 24h>%	Features
Red	1.4-1.6g/cm ³	67-90 Be	98	flow coating

3. Instructions

Dilution method:

Use the adjustable speed high-speed disperser to stir, the dilution ratio is about 1:1.0~1.4 (water: dry powder).



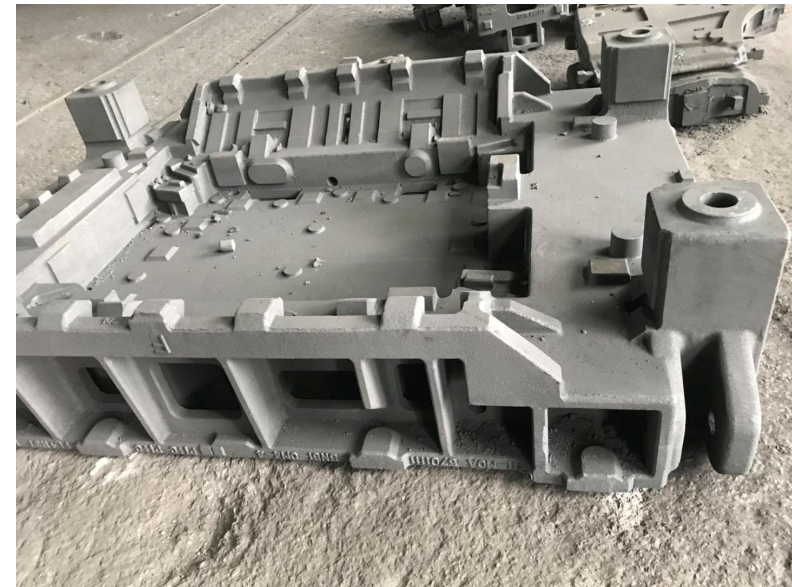
Use technical parameters

1. Brushing Baume degrees: 75-85Be.
2. Dip coating, flow coating Baume degree: 55-70Be.
3. It is recommended that the thickness of the coating is 0.5mm~0.8mm each time.
4. Thin-wall castings are applied twice and the coating thickness is 1.5 mm or more.
5. Thick-wall castings are applied three times and the coating thickness is 2 mm or more.



4. Product advantages

1. The coating has a good suspension, long-term storage does not precipitate.
2. The coating has good thixotropy, high refractory aggregate content, good brushing properties.
3. The coating has high strength and can provide strong protection to the foam model and can effectively resist the penetration of molten metal.
4. The coating has a reasonable particle size, good air permeability
5. The coating is made of high quality refractory aggregates with high refractoriness and excellent anti-adhesion properties.
6. The coating does not contain toxic substances, does not produce toxic gases.



5. Precautions

- 1** The foam model must not have oil or contamination from mold release agents during foam production.
- 2** The use of box-type drying ovens or tunnel-type drying ovens must ensure the uniformity of the hot air circulation and the stability of the temperature
- 3** The foam model should not contain moisture
- 4** The coating on the foam model must be thoroughly dried after being painted once.
- 5** During the modeling, the sand on the deep hole (weight reduction hole) and groove in the foam model should be compacted to prevent the generation of osmotic sand burning (iron packed sand)

6. Packaging and Storage

- 1. Packed in an inner film woven bag, 40 KG per bag.
- 2. The paint is stored and transported as non-dangerous goods.
- 3. Store at room temperature, pay attention to moisture and sun protection, shelf life of six months.



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