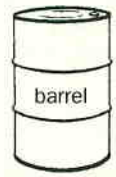
Mould sealer

417

additive for hardening the surfaces of natural or synthetic moulding sands; primarily used in light metal casting for treating wet sand moulds, prevent sand from being flushed out, prevents scabbing, improves dimensional accuracy, regulates the water content, hardens mould surface



a) in canisters of 35 kg **Item No. 417.001**
b) in barrels of 220 kg **Item No. 417.002**

Sodium silicate 37/40 °BE

418

binder for the CO_2-procedure f. ex.

a) in receptacle of 60 kg **Item No. 418.101**
b) in receptacle of 30 kg **Item No. 418.102**

Core adhesive in tubes of 1 kg

Item No. 419.001

419

(or in hobbocks containing 35 tubes)

multi-purpose adhesive for the CO_2, no-bake, cold-box and hot-box procedures, also for sealing mould halves, non flammable, odourless, cold setting, non-toxic, to be diluted with water

Fusion adhesive pistol MS 150

419A

heat and shockproof housing, low weight, non dripping tip, can also be used in almost inaccessible places, with integrated stand and suspension eye, short heating-up time, ergonomic shape, exact thermostat temperature control

a) with standard tip 1,75 mm dia. **Item No. 419.301**
b) with slotted tip 18 x 0,5 mm **Item No. 419.302**

Fusion adhesive SMK 26080 for cores

419B

for the above pistol
in 25 kg bags

Item No. 419.401

Core screws

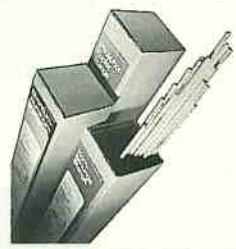
419C

cross slotted screw with **coarse thread** (pitch 4,6 mm)
a) dia. 5,5 mm x 70 mm long **Item No. 419.507** **b)** dia. 5,5 mm x 100 mm long **Item No. 419.510**
Max. quantity: 5000 pieces per dia.

Alloys in rods

420

environmentally friendly, easy to use, does not form scum, dissolving quickly, high yield, long survival time, remeltable (please ask for detailed information)



Item No.	Product	Composition-	Properties	Instruction for use in crucibles	Available in / addition per 100 kg melt
420.001	grain refiner AlTiB	5 % titanium, 1 % boron, balance 99,7 % aluminium	highly effective refining flux for aluminium alloys, such as G-ALSi5-12, G-ALCU4Ti, G-ALMgSi etc.	charge metal and melt, temperature 700 – 750°C, degas as required, add flux and skim, melt stir thoroughly modification process as required grain refining effect within 30 sec., effect over appr. 2 - 3 hrs.	in rods: 500 mm long 100 gr. add.: 2 – 5 rods
420.003	purifier AlSr 10 %	10 % strontium, balance 99,7 % aluminium	highly effective purification for hypereutectic AlSi-alloys	charge metal and melt, temperature 700 – 750°C, degas as required, add flux and skim, melt add grain refinement rods as required and stir (melt surface to be skimmed before) purifying effect within 1 min., effect over about 3 hrs. **Important:** When using Sr, **do not treat** melt with phosphor, fluoride or chloride	in rods: 330 mm long 70 gr. add.: 2 – 7 rods
420.004	phosphor-copper rods	6,8 – 7 % phosphor, balance pure electrolytic copper	highly effective purifying rods for a permanent grain refinement of Si in near or hypereutectic AlSi-alloys	charge metal and melt, temperature 780 – 840°C, degas, flux and skim, melt again, stir and degas melt effect within 20 - 30 min. effect over more than 12 hrs., (effect is influenced by sodium and strontium)	in rods: 500 mm long 130 gr. add.: 1 – 4 rods
420.005	ALCUP-phosphor-rods	19 % electrolytic copper, 1,4 % phosphor balance 99,7 % aluminium	highly effective purifying rods for a permanent grain refinement of Si in eutectic and hypereutectic AlSi-alloys	add after the usual purifying of the melt, immediately before casting at normal melt temp., effect over more than 2 hours (effct is influenced by Na, Sr and Ca)	in rods: 1200 mm long 300 gr. add: 1 rod

Fluxes in other shapes, f. ex. so-called waffle-plates, also available.