

# AQUADUR ASK – K

## COATING FOR MOULDS AND CORES

### DESCRIPTION

**AQUADUR ASK – K** is a water-based coating with high silicate content and carbon filling. Its characteristic is the high refractoriness.

Approximate composition:

- about 55 % refractory filler (carbon, silicates)
- about 3 % organic binder (polysaccharides)
- about 42 % water

### APPLICATION

The coating **AQUADUR ASK – K** is mainly used for cores and moulds being bound with furane and phenolic resins, for casting of grey-cast iron, nodular-graphite cast iron, malleable cast iron, and also of non-ferrous metals.

### ACTION

The coating **AQUADUR ASK – K** forms hard, compact layers which are insensitive for thermal shocks. It liberates only a small amount of gases and it does not crack.

### PREPARATION

The coating **AQUADUR ASK – K** is in form of a paste and it must be suitably diluted before the application:

- 0 - 5 % if swabbed or brushed
- 5 - 10 % for dipping

Applying paint with a pistol. Pistol can be air or airless. That you get a ready for paint spray pistol with the viscosity of the coating should be 13 -18 seconds (viscometer 4 DIN 53211) depending on the pistol.

The coating **AQUADUR ASK – K** can be dried in air, or even better, in a oven (dryer) at 80 to 150°C.

### STORING AND TRANSPORT

According to the regulations for railway and road transport, and for handling with poisons, the dressing is not a dangerous substance. It is to be stored in covered depots at temperature +5 to 30°C. If it is stored outdoors in summer, a bacterial fermentation of dressing can occur. Care must be taken that dressing does not freeze.

### PACKING

**AQUADUR ASK – K** is packed in plastic buckets at 25 kg each (16x25 = 400kg/palette) or in metal container .

### PROPERTIES

Physical appearance:	grey paste
Viscosity after 10 % water addition:	min.15 s 4 DIN 53211
Dry matter:	48% min.
Sedimentation in 24 hours:	5% max.
Density:	1.2 – 1.6 g/cm <sup>3</sup>