

AQUADUR ZG

COATING FOR MOULDS AND CORES

DESCRIPTION

AQUADUR ZG is a zircon-graphite water-based dressing. Its characteristic is a high refractoriness.

Approximate composition:

- ≈ 70 % refractory filling (zircon, carbon, silicates)
- ≈ 2 % organic binder
- ≈ 28 % water

USE

Coating is specially developed for dipping, overpouring, and spraying hot and cold Croning and Hot-Box cores and shell moulds.

ACTION

Dressing gives compact layers insensitive for thermal shocks. Dressing gives uniform layers also if silicone parting agents for cores are applied. Further it does not form foam during stirring.

PREPARATION

Coating is manufactured as paste which must be diluted, and then we stir it well, add 25% of water and stir again to obtain a dressing for dipping.

Stirring is done with a powerful fast-rotating agitator. Dressing should not contain unbroken aggregates of the paste.

With hot cores the dressing is dried on air, while with cold cores it is dried in drying chamber at 100 to 150°C.

PACKING

AQUADUR ZG is packed in plastic buckets at net 40 kg each (16 x 40 kg = 640 kg per pallet) or in metal containers at approx. 1.200 kg.

STORING AND TRANSPORT

It must be stored in covered stores at + 5 to 25°C. If it is stored outdoors in summer, a bacterial fermentation can occur. Care must be taken that it does not freeze.

According to European agreement for international road transport of dangerous goods, **AQUADUR ZG** is not a dangerous substance.

PROPERTIES

Physical state	thick grey paste
Relative density (water = 1):	1,5 – 1,7 g/cm ³
Dry matter	77 - 81 %
Viscosity after addition of 35 % water	13 s min 4 DIN 53211
Sedimentation in 24 hours	2 % max