

AQUADUR M-15

COATING FOR MOULDS AND CORES

DESCRIPTION

AQUADUR M-15 is a water-based ceramic dressing in pasty form. Its characteristic is a high refractoriness.

Approximate composition:

- about 60 % refractory filling (Al and Mg silicates, Fe oxide)
- about 6 % organic binder
- about 34 % water

USE

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

ACTION

Dressing enables compact layers insensitive to thermal shocks. Dressing gives uniform layer also if silicone parting agents for cores are applied. Further, it does not form foam during stirring, and its sedimentation is very slow.

PREPARATION

Coating is manufactured as paste which must be diluted in two stages before the application: At first it is well stirred with 10 % water to obtain a thin paste, and then another 10 % water is added to obtain dressing for dipping. Stirring is made with a powerful fast-rotating agitator. Dressing should not contain unbroken aggregates of the paste. With hot cores the dressing is dried in air, while with cold cores it is dried in drying chambers or ovens at 100 to 150°C.

STORING AND TRANSPORT

According to the regulations for railway and road transport, and for handling with poisons, coating is not a dangerous substance. It must be stored in covered stores at +5 to 25°C. If it is in summer stored outdoors a bacterial fermentation can occur. Care must be taken that it does not freeze.

PACKING

AQUADUR M-15 is packed in plastic buckets at net 25 kg each.

PROPERTIES

Dry matter:	54% min.
Viscosity (Krebs):	2000 – 3000 cPs
Sedimentation in 24 hours:	bellow 5%
Physical state:	pink paste