

EXOTERM 140/4

EXOTHERMIC MATERIAL AND COVERING COMPOUND

DESCRIPTION

EXOTERM 140/4 is a fast burning light gray material with high content thermal calorific value. It contains binder which can be well shaped and it has good insulating properties. It can be successfully used even as an exothermic covering compound.

USE

EXOTERM 140/4 is applied for making linings for feeders up to 200 mm diameter in casting copper alloys and gray cast iron.

PURPOSE OF USE

As an exothermic covering compound it can be used for powdering feeders above 200 mm diameter in casting copper alloys and gray cast iron. It is also applied for casting cast steel up to 150 mm diameter. Using this covering powder mass of the feeder is reduced and better yield in casting is reached.

ACTION

EXOTERM 140/4 is a fast burning material. Ignition temperature is between 340°C and 350°C. It develops the required temperature for melt heating in places where the process is to be taken. At the same time a good insulating layer is formed, porous for gases. During the use of **EXOTERM 140/4**, a 50 % rising of compound occurs.

INSTRUCTIONS

MASS PREPARATION

We add up to 5 % of water to the powdery mixture and stir it for 2 minutes. Then we add 7 to 8 % of water glass and stir it again for 2 minutes. We ventilate the shaped mass with CO₂ to required strength. We dry the obtained shaped material at temperatures up to 170°C. Dried shaped material has a required strength. Exothermic covering compound **EXOTERM 140/4** must be powdered on the surface of the melt just before the end of the casting. The melt must be completely covered with covering powder. It is recommended to use 1 - 1,5 kg of **EXOTERM 140/4** per 1 dm³ of the upper surface of the metal in a feeder.

PACKING

EXOTERM 140/4 is packed in natron bags with PVC bags inside at net 40 kg each. 1000 kg per pallet, wrapped with PVC foil.

STROING AND TRANSPORT

We store **EXOTERM 140/4** in tightly closed containers. No open fire or smoking is allowed in its surrounding.

According to the European regulations for international road transport of dangerous goods, **EXOTERM 140/4** is not a dangerous substance.

PROPERTIES

Physical state	grey powder
Dry compressive strength	40kg/cm ² min
Burning time on 3 cm	80 – 90 s
Permeability	150 GF min
Moisture content	1,5 % max