

PRODUCT DATA SHEET

GRAPHITE SPIRIT BASE

It is Graphite filled spirit based liquid wash for application on green sand, silicate sand for moulds and cores to give excellent casting finish . It consists of high quality Graphite powder with excellent suspension and covering properties. When casting of cast iron, nickel and copper based alloys into green sand, CO2 set and raisin bonded sand moulds. It is necessary to coat the sand surfaces which come into contact with molten metal. With our coatings, it prevents erosion, metal stroke mould reaction and sand burn on.

GRAPHITE SPIRIT BASE – It is a ready to use liquid coating. It is applied by spraying, or brushing.

Specifications:

1. Color – BLACK
2. Specific Gravity – 1.00 +/- 0.05
3. Viscosity (B4 Cup) – 13 +/- 1 sec.

It is essential to ensure that this product is thoroughly mixed to homogeneous consistency by stirring before use.

It is light off coating for use on sand moulds and cores in the casting of ferrous and non ferrous metals and alloys. In coating moulds and cores, the most important requirement is to obtain an even coating over the metal/sand contact areas. This is best achieved by spraying but can also be obtained by brushing, and in the case of cores, by dipping. When spraying good dense delivery is best since fine spray is likely to suffer from premature evaporation of the thinner and deposit of an unsatisfactory coating. It is essential always to ensure that coating is well mixed and suspended before application.