

## PRODUCT DATA SHEET

-----

### ZIRCON SPIRIT BASE

A premium Zircon filled high refractory spirit based liquid wash for application on green sand, silicate sand for moulds and cores to give excellent casting finish even on heavy steel casting. It consists of high quality Zircon refractory powder with excellent suspension and covering properties. When casting of high temperature alloys such as steel, cast iron, nickel and copper based alloys into green sand, CO<sub>2</sub> 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.

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

#### Specifications:

1. Color – Light Green
2. Specific Gravity – 1.6 +/- 0.02
3. Viscosity (B4 Cup) – 16 +/- 1 sec.
4. Solids – 62 +/- 2%

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, swabbing 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.