



FOUNDRY PRODUCTS: Technical Data Sheet

PRODUCT: Rapidur No Bake Binder System C9, C4 and C3 Catalysts

DESCRIPTION :

All 3 series of catalysts are designed to be used as the third part amine catalysts for the Rapidur Phenolic Urethane No Bake binder systems. They can all be used with any combination of the Part A and B resins that are marketed.

FIELD OF APPLICATION :

It is important to understand that every foundry has different operating variables and so may require a specific product. The charts below are for guidance purposes only, and any strength of catalyst can be customised for your operation.

C4 - series catalysts: are for ultra fast strip operations; or extremely cold sand

C3 - series catalysts are the standard catalysts originally developed

C9 – series catalysts are a lower cost, direct 1:1 replacement for C3 catalysts

METHOD OF APPLICATION :

Usually in the range of 1-4% based on quantity of Part A used. It is important to have efficient mixing of sand in order for the catalyst to work properly. Please note that sand temperature, binder content and sand type also affect performance. Shelf life : 2 – 3 years.

Speed 'Rating'	Product	Equivalent C9-	Primary Use
10	C4 -615 M	N / A	<i>Fastest catalyst available; strip time of 30 – 50 seconds</i>
9	C 4-426	N / A	<i>Ultra Fast Catalyst</i>
8	N/A	C9-999	<i>Economic Ultra Fast Catalyst</i>
7	C3-595	C9-595	<i>Typically used with very cold sands</i>
5.5	C3-575	C9-575	<i>Strong system for early morning start ups, acidic sands</i>
5	C3-500	C9-500	<i>Standard strength catalyst for winter or fast applications (Carousel)</i>
3	C3-300	C9-300	<i>Standard strength catalyst for operation</i>
2	C3-300 W	C9-300W	<i>Standard strength catalyst for hot sands, large boxes</i>
1	C3-300 M	N/A	<i>For ultra hot sands or poor pump capacity</i>