



FOUNDRY PRODUCTS: Technical Data Sheet

PRODUCT: AROMATIC SULPHONIC ACIDS - *Catasol*™

Technical Data

Mancuso Chemicals Ltd., is one of the few foundry resin manufacturers to produce its own Sulphonic Acids.

Made from virgin solvent streams in fully glass-lined reactors with graphite condensers, using oleum rather sulphuric acid, means that the very highest quality of product can be guaranteed, especially when it comes to trace metal concentrations, and the all important free sulphuric acid content.

Using a sulphonic catalyst that has the lowest possible levels of sulphuric acid ensures a favourable operating environment in the foundry at both mixing and pouring, as well as significantly reduced wear and tear on pumps, valves and mixers.

Mancuso Chemicals Limited makes over 20 different catalyst formulations for our foundry end-users, and can make any custom formulation that is needed in order to make your foundry resin system perform optimally. Below are listed the most popular grades of product.

Toluene Based Catalysts – A wide variety of catalysts are produced with TSA as a base - designed to work with operations that have very hot sands, high and low ADV's, and different work and set time requirements. Our standard TSA grade is the *Catasol H 60* which is suitable for use with every furan resin produced by Mancuso Chemicals and is considered the environmentally superior choice by progressive foundries.

Xylene Based Catalysts – An excellent range of products designed specifically for faster curing, cold or very basic sand conditions. These are stronger catalysts that are especially useful in winter months or early mornings when cold boxes prevent acceptable strip times being obtained. A wise environmental / health and safety choice for foundries that can avoid using a Benzene based catalyst.

Benzene Based Catalysts – The strongest catalysts on the market, designed for very specific uses with furan resins or for use with *Resital*™ phenolic no-bake binders.

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MTDS *Catasol* Catalysts v2 Sep 30, 2006



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Product	Aromatic Base	Free H ₂ SO ₄	% Total Sulphonic Acid	Primary Use
H6PM3	Toluene	Low	N/A	Ultra Hot Sand Applications and/or Extremely Long Work Times
H6PM9	Toluene	Low	N/A	
H6PM12	Toluene	Low	N/A	
H6PM15	Toluene	Low	N/A	
HS69	Toluene	1.0% max.	44.0 – 48.0	<i>Weak TSA</i> ↓ <i>Standard TSA</i> <i>Enhanced TSA</i> <i>Strongest TSA – premium product</i>
H66	Toluene	0.95% max.	52.0 – 56.0	
H65	Toluene	0.95% max.	56.0 – 60.0	
H60	Toluene	0.95% max.	60.0 – 63.0	
H60N	Toluene	2.5% max.	60.0 – 63.0	
TM 80	Toluene	0.2 % max	66.0 – 68.0	
H4TM	TSA/XSA	0.95% max.	66.0 – 73.0	
H5TM	TSA/XSA	0.95% max.	68.0 – 75.0	
H720	Xylene	0.95% max.	75.0 – 88.0	<i>Standard XSA</i> <i>Low Viscosity XSA</i> <i>Strong XSA</i> <i>For extreme cold situations</i> <i>Highest XSA content catalyst</i>
H720M	Xylene	2.0% max.	75.0 – 87.0	
H720NF	Xylene	0.95% max.	75.0 – 87.0	
H720X	Xylene	6.0% max.	75.0 – 88.0	
XSA	Xylene	1.0% max.	83.0 – 91.0	
H 960	Benz. / Tol.	1.0 – 2.5%	Mixture	<i>Mixed BSA / TSA product</i> <i>Standard BSA</i> <i>“Winter” BSA</i>
H 962	Benzene	1.0 – 2.5%	68.0 – 71.0	
H 967	Benzene	1.0 – 2.5%	65.0 – 68.0	
<i>Weakest</i>	→→→	<i>To</i>	→→→	<i>Strongest</i>

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