



## FOUNDRY PRODUCTS: Technical Data Sheet

**PRODUCT: Refractory Coatings – Alcohol Based Products.**

### HIGH SOLIDS MAGNESITE BASED REFRACTORY COATING

**MAN - MA** IS A HIGH SOLIDS, 100% MAGNESITE COATING IN AN ALCOHOL CARRIER. IT IS SUITABLE FOR GRAY IRON, ALLOYED IRON, STEEL AND MANGANESE STEEL WHERE CASTINGS ARE PRONE TO METAL - MOULD REACTION.

**MAN - MA** HAS EXCELLENT SUSPENSION PROPERTIES AND WILL REQUIRE ONLY MODERATE REMIXING PRIOR TO USE.

#### SPECIFICATIONS

<b>SPECIFIC GRAVITY</b>	<b>1.60 – 1.70 (1.65 typical)</b>
<b>BAUMÉ AS SHIPPED</b>	<b>83° - 86°</b>
<b>VISCOSITY</b> (BROOKFIELD #4, @ 100)	<b>800 - 1200 cps</b>
<b>COLOUR</b>	<b>DARK TAN</b>

#### APPLICATION

**MAN - MA** SHOULD BE DILUTED TO THE FOLLOWING BAUMÉ PRIOR TO USE, USING ISOPROPYL ALCOHOL. BE SURE TO MIX WELL.

<b>SPRAY:</b>	<b>50° - 70° Bé</b>
<b>BRUSH:</b>	<b>60° - 80° Bé</b>
<b>SWAB:</b>	<b>60° - 80° Bé</b>

**MAN - MA** CAN BE LIGHTED OFF OR TORCH DRIED UNDER A SOFT GAS FLAME. ENSURE THAT THE COATING IS THOROUGHLY DRY BEFORE POURING.

### HIGH SOLIDS ZIRCON BASED REFRACTORY COATING

**MAN - ZA** IS A HIGH SOLIDS 100% ZIRCON REFRACTORY COATING BASED ON AN ALCOHOL CARRIER. IT IS DESIGNED FOR USE IN GRAY IRON, DUCTILE IRON AND STEEL FOUNDRY APPLICATIONS WHERE METAL PENETRATION MAY BE A PROBLEM.

**MAN - ZA** HAS EXCELLENT SUSPENSION PROPERTIES AND WILL REQUIRE ONLY MODERATE REMIXING PRIOR TO USE.

#### SPECIFICATIONS

<b>SPECIFIC GRAVITY</b>	<b>1.93 – 1.97</b>
<b>BAUMÉ AS SHIPPED</b>	<b>80° to 85°</b>
<b>VISCOSITY</b> (BROOKFIELD # 4, @ 100)	<b>400 - 500 cps</b>
<b>COLOUR</b>	<b>GREEN</b>



## FOUNDRY PRODUCTS: Technical Data Sheet

### APPLICATION

**MAN - ZA** SHOULD BE DILUTED TO THE FOLLOWING BAUMÉ PRIOR TO USE, USING EITHER ISOPROPYL ALCOHOL OR NAPHTHA. BE SURE TO MIX WELL.

**SPRAY:** 66 - 72° Bé  
**BRUSH:** 66 - 72° Bé  
**SWAB:** 66 - 72° Bé

**MAN - ZA** CAN BE AIR DRIED, LIGHTED OFF OR TORCH DRIED UNDER A SOFT GAS FLAME. ENSURE THAT THE COATING IS THOROUGHLY DRY BEFORE POURING.

### GRAPHITE IN ALCOHOL FOUNDRY COATING

**MAN - GA** IS A 100% GRAPHITE COATING IN ALCOHOL. IT IS DESIGNED FOR USE IN FERROUS AND NON-FERROUS FOUNDRIES.

**MAN - GA** COATINGS CREATE A REDUCING ATMOSPHERE IN THE MOULD DURING POURING WHICH ELIMINATES METAL PENETRATION AND YIELDS EXCELLENT SURFACE FINISH VIA GOOD 'PEEL' CHARACTERISTICS.

**MAN - GA** HAS EXCELLENT SUSPENSION CHARACTERISTICS AND WILL REQUIRE ONLY MODERATE REMIXING PRIOR TO USE.

### SPECIFICATIONS

<b>SPECIFIC GRAVITY</b>	<b>1.35 – 1.41</b>
<b>BAUMÉ</b>	<b>79° - 80°</b>
<b>VISCOSITY (BROOKFIELD #4, @ 100)</b>	<b>1300 cps</b>
<b>COLOUR</b>	<b>BLACK</b>

### APPLICATION

**MAN - GA** SHOULD BE DILUTED TO THE FOLLOWING BAUMÉ PRIOR TO USE, USING ISOPROPYL ALCOHOL. BE SURE TO MIX WELL.

**SPRAY:** 20° - 30° Bé  
**DIP:** 20° - 30° Bé  
**SWAB:** 30° - 35° Bé  
**BRUSH:** 30° - 35° Bé

**MAN - GA** CAN BE LIGHTED OFF OR TORCH DRIED UNDER A SOFT GAS FLAME. ENSURE THAT THE COATING IS THOROUGHLY DRY BEFORE POURING. **MAN - GA** SHOULD ALWAYS BE USED ALONE OR AS THE FINAL COAT OVER REFRACTORY COATINGS.

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