



## FOUNDRY PRODUCTS: Technical Data Sheet

**PRODUCT: RAPIDUR NO BAKE BINDER SYSTEM – C3, C4, C5 and C9 Series**

### DESCRIPTION:

All catalysts are designed to be used as the tertiary amine catalyst with the Rapidur PUNB systems. They can be used with any combination of the Part A and B resins that 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.

**C3** - series catalysts are the standard catalysts

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

**C5** – series catalysts are for anti-warp applications

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

### METHOD OF APPLICATION:

Recommended usage is usually in the range of 3-8% 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 will significantly affect performance. Shelf life: 2 – 3 years.

Speed 'Rating'	Product	Primary Use	Approx set time mins (30C)
1	3-301	For ultra hot sands or poor pump capacity	15-20 mins
2	3-302		
3	3-303, 3-300M	For hot sands and low volume mixers	12-15 mins
5	3-305		
7	3-307		
9	3-309, 3-300W		
12	3-300, 9 300	Standard strength catalyst for hot sands, large boxes	9-12 mins
15	3-350		
20	3-400	Standard strength catalyst for operation	5-8 mins
25	3-500, 5 514, 9 500	Standard strength catalyst for winter or fast applications (Carousel)	3-5 mins
35	3-510, 4-315, 5-526, 9-700		
50	3-550, 4-330, 5-530	Strong system for early morning start ups, acidic sands	2-4 ins
60	3-560		
75	3-575, 4-473, 9-595	Typically used with very cold sands	2 mins
80	3-595	Ultra Fast Catalyst	1 min
100	4-426	Fastest catalyst available; strip time of 30 – 50 seconds	30-50 secs

Technical Data

