



FOUNDRY PRODUCTS: Technical Data Sheet

PRODUCT: POLYURETHANE NO-BAKE BINDER SYSTEM RAPIDUR™

ECONOMICAL, LOW ODOUR, HIGH STRENGTH, GOOD BREAKDOWN AND SHAKEOUT SYSTEM

DESCRIPTION:

This RAPIDUR™ NO-BAKE SYSTEM is made up of the following three components:

Part A: Low Formaldehyde Phenolic binder (less than 0.1% formaldehyde)

Part B: Isocyanate solution based on polymeric MDI

Part C: Amine based catalyst

It is an economical, high performance cold curing system that allows for fast, continuous production and has tremendous plasticity for large and small molds for core making. Its engineered design has been developed to optimize the upfront curing rates.

FIELD OF APPLICATION:

Ideal for large or small quantities of cores and molds, from floor molding through to high speed 'loop' and carousel operations for cast iron, steel, bronze, or light alloy castings. The Rapidur binder system exhibits very high front end strengths, a fast thru-cure, low odour, and low lustrous carbon. This system is suitable for use in all types of ambient conditions.

METHOD OF APPLICATION (standard):

100 parts in weight silica sand AFS 50 – 55

0.5 - 1.0 " " " RAPIDUR™ A- Rapidur A 733 is the main product code

0.5 - 1.0 " " " RAPIDUR™ B- Several part B's available

The RAPIDUR™ A and RAPIDUR™ B are designed to be used at a 55/45 ratio of A to B but can cover a range of 50:50 to 60:40. Curing depends on the strength of the catalyst used, sand temperature and quality of reclaimed sand. Work times from 3 – 45 minutes are available, as are equivalent strip times.

HANDLING:

RAPIDUR™ A and RAPIDUR™ B contain ingredients which could be harmful if not handled properly. Please see details in MSDS.

Packaging: RAPIDUR™ A and RAPIDUR™ B binder components are available in bulk, totes, 45 Gallon drums or small containers.

Storage: Optimum storage temperature is between 15°C - 30°C. Water can react with RAPIDUR™ B to form sludge as well as producing carbon dioxide gas.

SHELF LIFE:

If stored in a cool dry area, out of direct sunlight, it can be stored in unopened, sealed totes or metal drums for 2 years. Once opened driers attached to the totes or drums of the RAPIDUR™ B are strongly recommended to keep the product dry and free of moisture. Moisture will react with the RAPIDUR™ B to form crusting and sludge.

Technical Data



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MTDS RAPIDUR A / B v2 July 16, 2014



FOUNDRY – COATINGS – STEEL MILL - SULPHONIC ACIDS - PSA
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SAFETY MEASURES:

Safety glasses and rubber gloves must be used when transferring. Consult MSDS for further information.

BEFORE USE, ALWAYS READ AND FOLLOW THE DIRECTIONS CONTAINED ON THE LABEL, AND MATERIAL SAFETY DATA SHEET.

** The information presented, while not guaranteed, it is to the best of our knowledge true and accurate. No warranty or guarantee, express or implied, is made regarding the performance or stability of any product, since the manner of use and conditions of storage and handling are beyond our control. No suggestions for product use are intended as and nothing herein shall be construed as a recommendation to infringe any existing patents or to violate any government laws.



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