



## FOUNDRY PRODUCTS: Technical Data Sheet

**PRODUCT: No-Bake Acid Cured Phenolic Resin – Resital 1996™**

### DESCRIPTION:

A phenol-formaldehyde based resin, clear and reddish-brown in colour with a low nitrogen content. A very low odour resin, used commonly for large and medium sized castings.

### FIELD OF APPLICATION

Cores and molds for steel and iron castings. It is particularly suitable for use with reclaimed foundry sands. Exceptionally good performance for very large, thick and heavy section castings. Exhibits superior thru-cure properties which makes it an excellent resin for core making operations. Contains a proprietary additive that helps in improved stripping and flexibility in mold handling.

### PHYSICAL AND CHEMICAL PROPERTIES \*\*

Specific Gravity @ 25°C	1.180 - 1.2075 kg/l
Viscosity @ 25°C	50- 150 cps
Free Formaldehyde	0.1 % max
Water Content	14.5 - 15.5 %

### METHOD OF APPLICATION

It is generally used at 0.9 – 1.6% based on sand. Levels of 0.8 % are obtained in foundries with good sand control. When using cold, dusty or new sand, levels of 1.5% may be necessary. Hardening is obtained with one of the following catalysts:

**Catasol** H 962 / N 960 are typically recommended

**SHELF LIFE:** Good for one months if not stored in direct sunlight. Do not let this product heat up over 30 deg C.

### SAFETY MEASURES

Resin and catalyst are to come in contact only in the presence of sand; without the sand a violent reaction takes place. Never store resins in containers that have stored catalysts or other acids and vice versa. It is recommended that the sand/catalyst/resin mixture be handled using rubber gloves to avoid loss of natural oils in the skin.

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