



FOUNDRY PRODUCTS: Technical Data Sheet

PRODUCT: Alkyd Urethane No Bake Binder – Resyd LF(W or S) / MR™

DESCRIPTION:

A two part alkyd foundry resin with a 'pre-set' catalyst component in the Part A resin. Available in summer and winter speeds.

FIELD OF APPLICATION

Cores and moulds for steel and iron castings. Designed to yield 25 to 50 minutes strip time for large moulding operations. Based on linseed oil, the LFW system was designed for winter curing speeds while the LFS is meant for summer applications.

PHYSICAL AND CHEMICAL PROPERTIES **

Specific Gravity @ 25°C	0.920-0.978 kg/l
Viscosity @ 25°C Ford Cup #4	20-40 seconds
Refractive Index @ 25°C	1.4980 – 1.5100
Oil Base	Linseed Oil
Non-Volatile Component	60 – 64 %

METHOD OF APPLICATION

Resin is generally used at 1.0 – 1.5% based on sand when using new sand or up to 80% reclaimed sand. Hardening is obtained with one of the following co-reactant:

Resyd MR - Isocyanate based co-reactant with an additive to maintain lower viscosity in colder weather.

SHELF LIFE: Storage stability @ 90 deg F 3 months. Do not store in direct sunlight.

SAFETY MEASURES

Resin and catalyst are to come in contact only in the presence of sand; without the sand a exothermic reaction takes place. Never store resins in containers that have stored catalysts or other resins 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.

TENSILE STRENGTH DEVELOPMENT:

AFS 55, Temperature 21 deg C, 1.4% Resin Resyd LFW, 25% Co-Reactant Resyd MR

Set Time for Dog bones: 29 minutes / Strip Time for Dog bones 45 minutes

Strengths in psi: 1 Hour 50 psi 2 Hours 89 psi 4 Hours 148 psi 24 Hours 300 psi

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