

# FoundryGeneral® Foundry Adhesive 250

Hot Shell Core Adhesive

## TYPICAL PROPERTIES

- Appearance and odor = Thick, yellow to orange paste
- pH = NA
- VOC (EPA 24) = Not determine
- Density = 8.55 lbs/gal
- Flashpoint = 428 °F
- Viscosity = 25,000 cps

## Description

FoundryGeneral® Foundry Adhesive 250 is a ready to use hot shell core and mold paste. When applied to the hot drag of a shell mold, FoundryGeneral® Foundry Adhesive 250 does not boil or dry out quickly, allowing the operator sufficient time to properly position the hot cope half of the mold. After 45 seconds of curing under pressure in the mold press, FoundryGeneral® Foundry Adhesive 250 develops an extra strong bond which eliminates metal run outs at the parting line and provides casting dimensional accuracy across the parting line.

## Recommended Application

1

FoundryGeneral® Foundry Adhesive 250 may have a slight separation when received. Mechanical agitation is required to thoroughly remix the paste to a uniform consistency.

Five minutes when first put into service and one minute at the start of each shift is recommended.

2

Application of FoundryGeneral® Foundry Adhesive 250 can be done through a normal foundry type paste bulb or by liquid paste pump.

3

Another application includes dispensing the liquid from the liquid applicator by a wiper blade traveling over a perforated template.

4

FoundryGeneral® Foundry Adhesive 250 can also be accurately printed onto the shell by an appropriately contoured fixture with or without a vibrator.

## Benefits

- Ready to use
- Low smoke evolution
- Extra strong bond
- Reduces metal run out while pouring shells

## Material Compatibility

Avoid heat, sparks and open flames. Avoid strong oxidizing agents (i.e. bleach).

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