GENERAL CHEMICAL CORP.

FoundryGeneral® No Bake Core Paste 1000

No Bake Core Paste

TYPICAL PROPERTIES

•Appearance and odor = Thick, pink paste
•pH = 11
•VOC (EPA 24) = 0 lbs/gal
•Density = 14.65 lbs/gal
•Flashpoint = None

SHIPPING

FoundryGeneral® No Bake Core Paste 1000 is shipped in plastic pails and metal drums.

Description

FoundryGeneral® No Bake Core Paste 1000 is a ready to use air drying paste that is silica free. It is ideal for automatic dispensing paste that is silica free. It is ideal for automatic dispensing systems since it does not contain material that will abrade or wear out the equipment. FoundryGeneral® No Bake Core Paste 1000 penetrates into the sand matrix to form a strong bond and is primarily used with no bake systems, but can also be used with core oil, hot box and cold box systems. FoundryGeneral® No Bake Core Paste 1000 can be used on oil sand, cold or warm (not hot) shells cores and molds as well as resin or sodium silicate bonded cores and molds. Once completely dry, an inorganic bond is formed which produces very little if any gas evolution on pouring. The set time can be reduced by heating the joining surface to about 250 °F

Recommended Application

1. FoundryGeneral® No Bake Core Paste 1000 can be used as supplied or can be thinned with water to achieve desired dimensional tolerance between glued parts.
   Additional water will slow down setting speed.
2. FoundryGeneral® No Bake Core Paste 1000 should be mixed until homogeneity is achieved prior to use.
   The mixer should be of variable speed, properly sized, and oriented in the mixing vessel to prevent vortexing.
3. FoundryGeneral® No Bake Core Paste 1000 can be applied by dipping, brushing, or with a paste gun.
   Preheating the surface to be glued for sodium silicate cores will result in maximum strength.
4. Be sure FoundryGeneral® No Bake Core Paste 1000 is fully dry before placing in molds.

Benefits

•No VOC
•High tensile strength
•Inorganic based
•Low gas evolution
•Fast air and oven dry properties

Material Compatibility

Avoid strong acids and nonferrous metals such as copper, aluminum and

their alloys.

Health & Safety

Please refer to SDS for complete health and safety information.

Storage

With proper storage, shelf life is 6 months from date of manufacture.
Please refer to SDS for complete storage information.

12336 Emerson Dr. | Brighton, MI 48116 | 248-587-5600
Fax: 248-587-5606 | www.gccdatasheets.com