

FoundryGeneral® Incast Clean 1900

Wax Pattern Cleaner and Etch

TYPICAL PROPERTIES

- Appearance and odor = Pale yellow liquid with a citrus odor
- pH = 9.5
- VOC (EPA 24) = 3.5 lbs/gal
- Density = 7.95 lbs/gal
- Flashpoint = 212 °F

SHIPPING

FoundryGeneral® Incast Clean 1900 is shipped in metal pails and drums.

Description

Wax preparation is an important step in the investment casting process. If the wax surface is not clean, the final casting surface will show defects. If slurry is unable to adhere to the wax surface, the final casting can have lifting defects, cracking and run-outs. A good wax cleaner will clean the surface of the wax, quickly drain off the wax and lightly etch the wax surface to provide a means of slurry adhesion.

FoundryGeneral® Incast Clean 1900 wax cleaner fits perfectly into any working environment where safety, environmental and performance are important goals. FoundryGeneral® Incast Clean 1900 is a microemulsion designed to optimize cleaning capabilities and product life while helping to reduce VOCs and personnel safety issues. The superior cleaning performance and pleasant citrus scent make FoundryGeneral® Incast Clean 1900 a natural solution to your wax cleaning needs.

FoundryGeneral® Incast Clean 1900 removes silicone oil or other release agents from wax patterns prior to application of the primary ceramic coat. FoundryGeneral® Incast Clean 1900 is biodegradable and also acts as an etching material for the wax pattern while it cleans off the release agent. This allows for better slurry adhesion during application of the primary coats, thus reducing opportunities for casting defects related to shell buckling or lifting.

Recommended Application

1

FoundryGeneral® Incast Clean 1900 can be used as received for difficult to release patterns that require a heavy coat of release agent or for patterns that have difficult part geometry.

FoundryGeneral® Incast Clean 1900 can also be diluted to 75% concentration for normal use.

2

Agitated immersion in FoundryGeneral® Incast Clean 1900 for 30 seconds.

This time may vary depending upon part geometry or the amount of release agent to be removed,

3

Agitated immersion in ambient temperature water for 15 seconds in an overflow tank.

4

Agitated immersion in ambient temperature water for 15 seconds in a second overflow tank.

Benefits

- Reduced VOC
- Pleasant citrus odor

- Effective over a wide range of concentrations to provide the desired pattern finish
- Easily mixes in water and remains stable with mild agitation for ease of use.
- Low viscosity allows fast drainage and easy rinsing of wax pattern.
- Formulated to be compatible with prime slurries.
- Concentrated product reduces shipping, handling and storage costs.
- An environmentally friendly product

Material Compatibility

Concentrate is compatible with Stainless Steel, PVC, Teflon, Buna-N, PVDF and Viton. Product is combustible, avoid heat, sparks and open flames. Avoid strong oxidizing agents (i.e. bleach) and acidic agents, including acidic clays. Product reacts explosively with iodine pentafluoroethylene.

Health & Safety

Please refer to SDS for complete health and safety information.

Storage

With proper storage, shelf life is 1 year from date of manufacture. Please refer to SDS for complete storage information.

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