

FoundryGeneral® Green Sand Parting 101

Oil Based Green Sand Parting

TYPICAL PROPERTIES

- Appearance and odor = Clear, colorless to light amber liquid
- pH = NA
- VOC (EPA 24) = Not determined
- Density = 7.1 lbs/gal
- Flashpoint = 270 °F

Description

FoundryGeneral® Green Sand Parting 101 offers excellent release with all types of automatic molding machines. A single application will last a number of cycles without loss in parting strength. This provides good economics as less total material is required for consistent results. In some applications, up to 50% has been effectively used. FoundryGeneral® Green Sand Parting 101 has an extremely low cloud point which gives it excellent cold weather properties.

Recommended Application

1

FoundryGeneral® Green Sand Parting 101 is used as received.

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2

A light film of FoundryGeneral® Green Sand Parting 101 should be applied by spraying a mist onto the pattern.

Avoid using too much, as it will eventually lead to a sticky film.

3

Reapply as needed.

Benefits

- Inhibits corrosion of metal patterns
- Will not build up on metal patterns unless too much is used
- Will not attack the sand clay bond when used as recommended
- If sprayed every mold cycle, less parting is needed per mold

Material Compatibility

Avoid strong oxidizing agents (i.e. bleach), strong reducing agents, strong bases (i.e. ammonia) and soft metals such as aluminum.

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.

