

# 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.

