GENERAL CHEMICAL CORP.

FoundryGeneral® Green Sand Parting 104

Oil Based Green Sand Parting

TYPICAL PROPERTIES

•Appearance and odor = Clear, colorless to light amber liquid
•pH = NA
•VOC (EPA 24) = Not determined
•Density = 7.25 lbs/gal
•Flashpoint = 285 °F

SHIPPING

FoundryGeneral® Green Sand Parting 104 is shipped in metal pails and drums.

Description

FoundryGeneral® Green Sand Parting 104 is a highly concentrated green sand liquid parting designed to provide the maximum parting efficiency for foundry mold production. Generally, one application will last for ten molds and more. FoundryGeneral® Green Sand Parting 104 improves green sand casting surfaces and reduces the incidence of sand erosion, scabbing, and other surface gas defects due to the great reduction of solvent absorption into the molding sand surface resulting in a weakened sand-clay bond. FoundryGeneral® Green Sand Parting 104 is the most economical parting based on a per mold cost.

Recommended Application

1. FoundryGeneral® Green Sand Parting 104 is used as received.
   Prior to application, patterns should be well cleaned of previous release agents and dirt through the use of a solvent.
2. A light film of FoundryGeneral® Green Sand Parting 104 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 heat, sparks and open flames. Avoid strong oxidizing agents (i.e. bleach).

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