

CERAMIX – 72(MB)

[(HIGH STRENGTH BINDER FOR GREEN SAND MOULDING.)]

PRODUCT:

CERAMIX – 72(MB) is a reddish brown coloured powder binder for green sand moulding. setting properties.

PURPOSE:

It is also a very effective anti- scabbing agent in system sand. **It** is used for Gray Cast Iron/ Steel/ S.G. Iron/ Alloy Steel and Non Ferrous casting. **It** is a single shot binder easy to use for fresh or unit sand.

APPLICATION:**MIXING CYCLE :**

Fresh sand (AFS = 55 TO 60)	:	100 parts
CERAMIX – 72(MB)	:	5 parts
Water	:	3 to 4 parts
Mixing /Mulling Time	:	7 to 10 Min.

COMPRESSION STRENGTH DEVELOPMENT :

G.C.C.	:	5 - 8 PSI.
1 Hr.	:	15- 25 PSI.
2 Hr.	:	35 - 50 PSI.
4 Hr.	:	60 - 80 PSI.
24 Hrs.	:	150 - 200 PSI.

The above quoted figures may vary depending on sand quality, sand type, mixing efficiency & ambient conditions.

Discharge the mixed sand and cover it with wet cloth.

This prepared sand has got better flowability, hence can be used for any integrated shapes. Moulds can be stripped immediately as per Green Sand practice, since **CERAMIX – 72(MB)** has got good green compression strength. The stripped mould will show air hardening property, hence the dimensional accuracy of moulds will be excellent. This sand can also be used as facing sand backed by Green Sand/ Return Sand.

CERAMIX – 72(MB) is used in unit sand system in the range of 0.3 to 0.4% (After stabilizing the system) to improve the bonding efficiency & also to reduce scabbing and surface casting defects. The product improves the moisture retention properties of system sand.

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STANDARD PACKING: 50 Kg. HDPE. Bag.

STORAGE: Store in cool and dry place and away from direct heat.

SHELF LIFE: 12 months from date of manufacturing.