

NO BAKE FURAN RESIN FOR FOUNDRY

No bake furan resin system is a high-strength and eco-friendly binding system widely used in foundry areas. It contains two parts of application, the resin liquid and the acid hardener, which are mixed with silica sand by a proper ratio for molding and core making of cast steel, cast iron and non-ferrous metals.

MAIN TYPES OF NO BAKE FURAN RESIN

| Type | Nitrogen | Formaldehyde | Viscosity(20℃) | Application | Picture |
|--|----------|--------------|----------------|--|---|
| FB-010 | < 1% | < 0.05% | ≤15 MPa·s | Steel castings, big nodular iron castings, alloy steel |  |
| FB-110 | < 2% | < 0.10% | ≤15 MPa·s | Steel casting, big nodular iron castings | |
| FB-200 | < 3% | < 0.30% | ≤30 MPa·s | Various iron casting | |
| FB-500 | < 5% | < 0.30% | ≤40 MPa s | Gray iron casting | |
| *Customized specification can be satisfied *Hardener is to be supplied according to actual resin specification and using condition. | | | | | |

METHOD OF APPLICATION

Mixing Ratio

Sand (or reclaimed sand): Resin: Hardener =100: 0.7~1.5: 0.3~0.6(weight of resin).

Blending process

First, add the hardener to the sand and blend in high speed sand mixer for 10~30 seconds or in low speed sand mixer for 30~60 seconds, then add resin to the mixer and blend for 30~60 seconds, the mixture should be uniform when stop blending.

When finish the blending, the mixture should be used to molding and core-making immediately in case the mixture turns to be sticky and low flow ability which makes the mixture useless.

PACKAGE AND STORAGE

Resin:

Use the 200L iron drum or 1000L barrel to pack the resin.

Airtight store in a cool dry place, prevent direct sun illuminate, and away from the heat and fire. The resin should not contact with the hardener or other acid to avoid the drastic reaction and even the explosion.

Hardener:

Airtight store in a cool dry ventilated place without fire.

Prevent the hardener from impact during the loading and unloading, transporting, and stocking. Make sure that the packages are packing sound and seal. The direct contact of hardener and resin is forbidden in case the explosion will occur.

The hardener has a strong acidity, you should ware labor protection appliances. If you contact the hardener directly, please washing with plenty of water and go to a doctor immediately if necessary.