



**ACME**<sup>TM</sup>  
FOUNDRY FLUX COMPANY

ISO  
9001:2008  
Certified

# Mould and Core Dressings

(Mould Paint - Alcohol base)



Acme products include a number of dressings in the form of Powder, Paste, Semi Paste and Ready to Use applications. These dressings are based on high quality refractory material and are blended with sophisticated binders and suspension agents to give an excellent application properties, suspension characteristics and optimum penetration properties.

- **MP-25L IP:** This product is a Zircon based coating with excellent suspension and coverage properties. Product is specially formulated to ensure high refractory, non-meltable and non-reactive coating layer with optimum application properties to ensure an excellent coating finish.
- **MP-100 IP:** This is a Zircon based, high solids, thixotropic coating with excellent suspension properties and easily re-mixable manually. This coating is suitable for resinous binder backgrounds and gives very good surface finish. This coating has a higher filler content, which gives better surface coverage per Kg. of wash as compared to normal coatings. Due to high gel strength, spirit seepage in to the moulds and cores is reduced and hence chances of surface weakening is also reduced. This coating is therefore suitable for organic binder backgrounds. Organic content of M.P 100 is much less than other coatings hence generating lower gas.
- **MP-26L:** This is a general purpose ready to use Zircon based coating suitable for heavy iron, copper and steel castings. Due to its high refractoriness it prevents sand fusion and metal penetration at high pouring temperatures. Although generally used for steel castings it is recommended for integral cores surrounded by molten metal even for cast iron castings.
- **MP-26 P:** This is Zircon based MP-26L coating supplied in paste form, to be used after mixing with MP-101.
- **MP-21L:** This is a ready to use Graphite coating which can be applied to moulds and cores by spraying, swabbing or dipping. This is a general purpose coating for all types of Iron, Aluminium and Copper based Alloys. Being Alcohol / Spirit base they are particularly suitable for Sodium Silicate bonded moulds and cores for which water base dressings cannot be used.
- **MP-21 Paste:** This Graphite based coating in paste form to be used after diluting with MP-101.
- **Mouldex:** This is Graphite based coating in powder form to be used after mixing with MP-101.
- **MP-31L:** This is a spirit based ready to use Magnesite Coating which eliminates metal mold reaction on Manganese Steel Coating and gives excellent casting finish free from sand burns and fusion.
- **MP-20Z:** This is an Aluminium Silicate based product in liquid form with excellent suspension characteristic for Cast Iron application in Ready to Use form.
- **MP-101:** This is Alcohol based general thinner used for blending with paste and powder form of coatings.

Manufactured by:

ACME FOUNDRY FLUX COMPANY  
(An ISO 9001-2008 Certified Company)

264, Hadapsar Industrial Estate, Pune 411013, India

Tel: 020 - 3241 5374 | Telefax : 020 - 2687 2038 / 2687 2487 | E-mail: sales@acmefoundryflux.com | Web: www.acmefoundryflux.com

## Product Range

Product Name	Form	Filler / Carrier	Physical properties		Application details / method	Packing
MP25L IP	Liquid	Zircon / Spirit	Colour	Green	Apply by brush / swab method and ignite	30 Kg. Bucket
			Sp. Gr	1.60 – 1.62		
			Baume	60 – 64 Deg		
			Viscosity	15 – 18 Sec.		
MP25L IP(F)	Liquid	Zircon / Spirit	Colour	Green	Apply by brush / swab method and ignite	30 Kg. Bucket
			Sp. Gr	1.47 – 1.51		
			Baume	48 – 52 Deg		
			Viscosity	14 – 15 Sec		
MP25L IP (RFU)	Liquid	Zircon / Spirit	Colour	Blue / Green	Apply by brush / swab method and ignite	30 Kg. Bucket
			Sp. Gr.	1.55 – 1.57		
			Baume	54 – 55 Deg		35 Kg. Carboy
			Viscosity	15 – 17 Sec		
MP100 IP	Paste	Zircon / Spirit	Colour	Off white	Apply by brush after dilution with MP101 & ignite	40 Kg. Bucket
			Sp. Gr.	2.0 – 2.2		50 Kg. Carboy
MP26L	Liquid	Zircon / Spirit	Colour	Off white	Apply by brush / swab method and ignite	30 Kg. Bucket
			Sp. Gr	1.55 ± 0.02		35 Kg. Carboy
			Viscosity	16 – 18 Sec		
MP26 Paste	Paste	Zircon / Spirit	Colour	Off white	Apply by brush after dilution with MP101 & ignite	50 Kg. Carboy
			Dilution rate	2 : 1 (Pr : Al)		
MP21L	Liquid	Graphite / Spirit	Colour	Black	Apply by brush / dip / swab method and ignite	20 Kg. Bucket
			Sp. Gr	0.94+ 0.01		50 Kg. Carboy
			Viscosity	12 – 13 Sec		
			Settling rate	26% / hr		
MP21L(1)	Liquid	Graphite / Spirit	Colour	Black	Apply by brush / swab method and ignite	20 Kg. Bucket
			Sp. Gr	1.02 ± 0.02		50 Kg. Carboy
			Viscosity	14 – 17 Sec		
			Settling rate	5% per hr.		
MP21L1(xx)	Liquid	Graphite / Spirit	Colour	Black	Apply by brush / swab method and ignite	20 Kg. Bucket
			Sp. Gr.	1.02 ± 0.02		50 Kg. Carboy
			Viscosity	11 – 13 Sec		
			Settling rate	10% per hr.		
MP21 Paste	Paste	Graphite / Spirit	Colour	Black	Apply by brush after dilution with MP101 & ignite	50 Kg. Carboy
			Sp. Gr.	1.35 – 1.40		
			Dilution rate	2 : 1 (Pr : Al)		
			Settling rate	5% ± 2%		
Mouldex	Powder	Graphite	Colour	Black	Apply by brush after dilution with MP101 & ignite	25 Kg. Bag
MP31L	Liquid	Magnesite / Spirit	Colour	Off white	Apply by brush / swab method and ignite	30 Kg. Bucket
			Sp. Gr.	1.35 – 1.4		35 Kg. Carboy
			Viscosity	14 – 15 Sec		
			Settling rate	5% per hr.		
MP20 (Z)	Liquid	Alumina Silicate	Colour	Brick red	Ready to Use	25 Kg. Carboy
			Sp. Gr.	1.09 – 1.11		
			Viscosity	10 – 13 Sec.		
			Settling rate	Nil		
MP101	Liquid	Spirit	Colour	Pale yellow Colour-less	To be mixed with Mould Paint to get a particular viscosity applicable for coating on mould and cores	205 Ltr. Barrel
			Sp. Gr.	0.78 – 0.81		