

WATER BASED DIP COATING FOR THIN-WALLED CORES

INTRODUCTION

ACMEDIP-758 is water based mixed refractory graphite dip coating suitable for use on thin-walled water jacket and oil gallery cores of cylinder head & block castings. The use of special refractory fillers along with graphite makes the coating resistant to thermal stresses and thereby improves internal casting surface finish cleanliness and eliminates veining, finning and metal penetration defects in the water and oil passage area.

PROPERTIES

- Colour : Dark Brown
- Appearance : Creamy Liquid
- Baume : > 80
- Specific gravity : 1.5 ± 0.05

APPLICATION DETAILS

- The coating needs to be diluted with potable quality water to suit the application consistency (Baume 40 ± 2 units or B4 Cup Viscosity 15 ± 1 Sec) depending on the desired coating thickness of 250 ± 50 micron. About 35 ± 5 % water addition is required to arrive at dipping consistency. Uniform and drip-free coating can be obtained by either dipping or over pour application. The coated cores need to be dried using a suitable oven at 150 deg. C for 30 - 90 minutes

ADVANTAGES

- Excellent suspension and rheological properties
- Uniform coating coverage & adherence on core substrate
- Excellent casting surface finish
- Reduced veining, finning & metal penetration
- Reduce fettling time and cost

SHEL- LIFE : 4 – 6 months

PACKING : Available in 30 Kg. poly-buckets

STORAGE : Store in a cool, dry place and in unopened original packing.

PRECAUTIONS

Use gloves and nose masks to avoid continuous skin contact and inhalation of the vapors emanating from the coating.

Manufactured by:
ACME FOUNDRY FLUX CO.
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