

ACMECOAT LF-120M**A COATING SUITABLE FOR POLYSTYRENE PATTERNS USED
IN LOST FOAM & FULL MOULD PROCESS****INTRODUCTION:**

ACMECOAT-LF 120M is water based refractory coating which contains alumino-silicate fillers. It is designed to have optimal permeability to suit application on polystyrene patterns for producing CAST IRON castings with good surface finish by lost foam process / full mould process.

PROPERTIES

1	Colour	Reddish Brown
2	Appearance	Creamy Paste
3	Baume	> 90 deg. C
4	Sp. Gravity	1.70 \pm 0.05

APPLICATION DETAILS:

The coating can be used for BRUSH application in as supplied condition. If required, a small quantity of water can be added to suit the consistency. We recommend dilution with water to **65 \pm 5** Baume for DIP, FLOW and SPRAY applications. The coated patterns need to be dried below 60 deg. Centigrade. For heavy and critical castings, higher coating thickness can be built by repeating above procedure.

PRODUCT FUNCTION**The function of ACMECOAT LF-120M:**

- To provide adherent and resilient refractory barrier between polystyrene and the metal.
- To facilitate smooth, non-turbulent mould filling.
- To allow easy escape of gases generated during casting process.
- To absorb the liquid tar produced.
- To minimize lustrous carbon defects.

STANDARD PACKING: Available in 30 Kg. Poly buckets / metal pail

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

SHELF LIFE: Six months

Manufactured by:

ACME FOUNDRY FLUX CO.

(An ISO 9001-2015 Certified Company)

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