

### COATINGS FOR SAND CASTING

The obtaining of a good surface finish of sand castings is often linked to the application of suitable coatings on moulds and cores. The principal purpose of the application of these coatings is the insulation of the surfaces in contact with the molten metal, in order to avoid defects that force to repair or, in the worst cases, reject the castings.

PROTECME offers a large range of coatings based on different refractory materials, diluted with water or alcohol, for application with different types of alloys.

The following table lists the principal products with their characteristics and field of application.

<i>PRODUCT</i>	<i>APPLICATIONS</i>	<i>DILUTION</i>	<i>REFRACTORY FILLER</i>
<b>FLAMCOTE 110/F</b>	Steel	Alcohol	Zircon
<b>FLAMCOTE 200/F</b>	Cast iron	Alcohol	Zircon and graphite
<b>FLAMCOTE 300</b>	Cast iron	Alcohol	Graphite
<b>FLAMCOTE 400</b>	Al alloys	Alcohol	Talc
<b>FLAMCOTE 410</b>	Mg alloys	Alcohol	Special composition with inhibitors
<b>AQUACOTE 100</b>	Steel, cast iron, Cu alloys	Water	Zircon
<b>AQUACOTE 185</b>	Cast iron	Water	Graphite

### DRESSINGS FOR GRAVITY AND LOW PRESSURE DIE CASTING

One of the most important points in the production of non-ferrous alloys castings by the permanent mould casting method is the use of suitable dressings. They are applied on the metal dies, and, according to their properties, accomplish different functions, that we can list as follows:

- Favour the flow of the molten alloy facilitating the filling of the mould
- Control the heat exchange improving the feeding of the castings
- Protect the surface of the die avoiding the welding of the molten alloy on the same and reducing the wear
- Permit to improve the surface finish of the castings

PROTECME supplies a range of dressings for gravity and low pressure die castings, whose characteristics are listed in the following table.

<i>PRODUCT</i>	<i>CHARACTERISTICS</i>
<b>ANTIAL 7140</b>	Very insulating
<b>ANTIAL 7320</b>	Insulating, resistant
<b>ANTIAL 7310</b>	Insulating
<b>ANTIAL 7340</b>	Good insulation, favours the filling of the die
<b>ANTIAL 7110</b>	Heat conductive, lubricating
<b>ANTIAL 7360</b>	Semi conductive, has some lubricating properties
<b>ANTIAL 7390</b>	Insulating, very fine finish