

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>
FLAMCOTE 110/F	Steel	Alcohol	Zircon
FLAMCOTE 200/F	Cast iron	Alcohol	Zircon and graphite
FLAMCOTE 300	Cast iron	Alcohol	Graphite
FLAMCOTE 400	Al alloys	Alcohol	Talc
FLAMCOTE 410	Mg alloys	Alcohol	Special composition with inhibitors
AQUACOTE 100	Steel, cast iron, Cu alloys	Water	Zircon
AQUACOTE 185	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>
ANTIAL 7140	Very insulating
ANTIAL 7320	Insulating, resistant
ANTIAL 7310	Insulating
ANTIAL 7340	Good insulation, favours the filling of the die
ANTIAL 7110	Heat conductive, lubricating
ANTIAL 7360	Semi conductive, has some lubricating properties
ANTIAL 7390	Insulating, very fine finish