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FORM SAND

DESCRIPTION:

Forming sand "E" is an oil-bonded forming sand that is delivered ready to use. Due to its binding it cannot dry out. The high green strength makes it possible to produce contour and dimensionally accurate castings.

APPLICATION:

Forming sand "E" is mainly used for heavy metals, as well as gray iron and spheroidal iron for castings with thin and medium wall thickness.

PHYSICAL ATTRIBUTES:

✓ Compressive strength [g/cm ²]	1300
✓ Shear strength [g/cm ²]	400
✓ Gas permeability []	<18
✓ Fluidity [%]	35
✓ Fineness of grain [AFS]	140
✓ Average grain size [mm]	0,09

PROCESS:

When applying the sand to the cartridge, the first layer should always be sieved and lightly pressed. Then the moulding box can be filled with unsieved moulding sand and compressed. Do not add water or use a coating.

PACKAGING:

Bags of 1 kg, 5 kg and 25 kg.

STORAGE:

Minimum 1 year in airtight bags. Physical or colour changes may occur due to solar radiation and/or the penetration of air.

The above information is correct to the best of our knowledge and careful consideration. OBB sand is made from natural raw materials. All data are estimated values at time of manufacture with product and production related tolerances. They serve only to describe and do not constitute guaranteed properties. We guarantee the flawless and consistent nature of our products, but we are not liable for subsequent processing results that usually occur beyond our control. Safety data sheets are available and can be requested from KBO.