



TECHNICAL DATA SHEET: **DRYBOND 01**

PRODUCT DESCRIPTION

DRYBOND 01 A is a reddish brown clay based binder for green sand hand moulding applications. The sand grains in the mould are bonded together due to the gelling action of this binder and the high strength is obtained due to the air hardening properties of the binder. Due to the air hardening nature, moulds made with **DRYBOND 01** develop very high compressive strengths, while retaining the excellent collapsible properties of green sand. The product can also be used to make simple cores.

HOW TO USE

Application of **DRYBOND 01 A** is similar to the use of Bentonite in regular green sand moulds. Clean dry sand has to be charged into a sand muller with rollers (a mixer will not be suitable for this product), muller for two to three minutes, after which **DRYBOND 01 A** has to be added @ 4 to 5% of the sand weight. After mulling for a further two to three minutes water has to be added @ 3.5 to 5% of the sand weight and the mulling continued for another three minutes. The sand should then be discharged and used for moulding/core making. The patterns should be stripped immediately after moulding and allowed to air dry for at least 18 hours, by which time the compressive strength increases substantially. The mould/core may then be painted with a spirit based refractory paint and made ready for closing/pouring.

INDICATIVE SPECIFICATIONS

PROPERTY	RANGE
PRODUCT NAME	DRYBOND 01 A
Colour	Reddish brown
Sieve grading	-80 mesh
Compressive strength of sand After Mixing with 5% Drybond & 4% water	5- 6Psi
Shelf Life	6 Months

PACKING DETAILS

DRYBOND 01 is supplied in 20kg HDPE bag, and should be stored in a cool and dry place.



MATERIAL SAFETY DATA SHEET: **DRYBOND 01**

1. **CHEMICAL IDENTITY**
 Chemical Name : Clay based binder
 Chemical Classification : Mixture of natural clays.
 Trade Name : DRYBOND 01A.
2. **PHYSICAL AND CHEMICAL DATA**
 Appearance : Reddish brown colour
 Physical state : Powder
 Odor : Odourless
3. **FIRE & EXPLOSION HAZARD DATA**
 Flammability : No
 Auto Ignition Temperature : None
 Corrosive Material : No
 Explosive Material : No
4. **REACTIVITY DATA**
 Chemical Stability : Stable
 Incompatibility with : Hygroscopic in water.
 Hazardous reaction product : None
5. **HEALTH HAZARD DATA**
 Route of Entry : Skin
 Effects of Exposure : Constant exposure and inhalation cause mild irritation to the nose, eyes and skin. Wash the affected area with lot of water and consult a doctor.
6. **PREVENTIVE MEASURES**
 Personal protective equipment : Avoid direct contact with hands, use gloves wherever possible.
 Handling & Storage precautions : Keep in a cool and dry place.
7. **EMERGENCY & FIRST AID MEASURES**
 Fire : Use water.
 Spillage : Sweep away the spilled material.
8. **HANDLING & DISPOSAL**
 Bags : Never use empty bags for storing food stuffs or other materials meant for human and animal consumption. Empty bags may be sold as scrap or to HDPE recyclers approved by the State Pollution Control Boards.
9. **MANUFACTURER / SUPPLIER DATA :**
 Name : Quality Technologies Private Limited
 Address : No.34, Rd. No.1, IDA Mallapur, Nacharam, Hyderabad – 500 076.
 Tel ephone : 040 27153888, 27155828
 Fax : 040 27152567
 e-mail : info@qtecindia.com
10. **DATE OF INFORMATION** : 01.01.2008.

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