

QUALITY TECHNOLOGIES PRIVATE LIMITED

TECHNICAL DATA SHEET: **REFCOAT 08**

PRODUCT DESCRIPTION

REFCOAT 08 are a range of basic refractory spirit based coatings for green sand/ Co₂ moulds and cores, used in the manufacture of Hadfield manganese steel castings. Normally silica sand is used as molding medium for manganese steel castings. This sand is acidic in nature and reacts with manganese which is basic in nature. Since an acid–base metal mold reaction leads to poor casting finish, **REFCOAT 08** is formulated with basic fillers, which when coated on the mold forms an intermediate layer between an acid and a base, and protects from further reaction.

REFCOAT 08 B is specially formulated to reduce surface degeneration of spheroids in SG iron castings made in resin based moulds. The sulphur dioxide gases generated during casting react with the basic filler in the **REFCOAT 08 B** and prevent sulphur from reacting with the residual magnesium in the molten metal. Presently the following grades of **REFCOAT 08** are available in our range –

- **REFCOAT 08 A Spl** – Ready for use paint for direct application.
- **REFCOAT 08 A** – Ready for use paint for direct application.
- **REFCOAT 08 B** – Low cost Ready for use paint for direct application
- **REFCOAT 08 C** – Premium quality coating in powder form.

HOW TO USE

REFCOAT 08 A Spl, **REFCOAT 08 A** & **REFCOAT 08 B** are supplied in ready-to-use form. However depending upon the application it can be diluted with foundry solvent. **REFCOAT 08 C** is powder which have to be diluted carefully for brushing/ swabbing/ spraying applications. Direct addition of excess solvent into the powder, and mixing is not advisable. To obtain best results add little quantity of solvent first, make powder to paste and subsequently add suitable quantity as per the foundry requirement. The mould has to be coated with this paint, lit off and subsequently torch dried.

INDICATIVE SPECIFICATIONS

PROPERTY	RANGE		
	REFCOAT 08 A Spl. / REFCOAT 08 A	REFCOAT 08 B	REFCOAT 08 C
PRODUCT NAME	REFCOAT 08 A Spl. / REFCOAT 08 A	REFCOAT 08 B	REFCOAT 08 C
Appearance	Creamish White pasty liquid	Creamish pasty liquid	Creamish white powder
	READY FOR USE PAINT	READY FOR USE PAINT	PROPERTIES OF PAINT AFTER MIXING WITH SOLVENT
Quantity of solvent	Not Applicable	Not Applicable	900ml
Quantity of paint/powder	Not Applicable	Not Applicable	1 Kg
Specific gravity	1.5-1.55	1.5-1.55	1.45
Coverage	0.15gm/sqcm	0.15gm/sqcm	0.15gm/cm
Burning time*	60-65sec	35-40sec	60-65sec
B4 cup viscosity	13-15sec	13-15sec	12-15sec
Settling rate/hr	5-6%	15-18%	25-35%
Peel off	Nil	Nil	Nil
Shelf life	6 Months	6 Months	6 Months

* Burning time obtained from CO₂ mould of 169 sqcm.

PACKING DETAILS

REFCOAT 08 A Spl, **REFCOAT 08 A** and **REFCOAT 08 B** are supplied in 20 kg White Buckets/40Kgs. Plastic Carboy while **REFCOAT 08 C** is supplied in 20 kg HDPE bags. The products should be stored in a cool and dry place.

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MATERIAL SAFETY DATA SHEET: **REFCOAT 08**

1. PRODUCT IDENTIFICATION	
Trade Name & Use	: REFCOAT 08 A Spl., REFCOAT 08 A, REFCOAT 08 B, REFCOAT 08 C - Refractory Coating
Manufacturer / Supplier	: QUALITY TECHNOLOGIES PVT. LTD. No.34, Road No.1, IDA Mallapur, Nacharam P.O., Hyderabad - 500076. PH:040-271 53888, 271 55828 Fax: 040-271 52567, email : info@qtecindia.com Website:www.qtecindia.com
2. INFORMATION ON COMPOSITION	: Refractory fillers, Gellants and Solvents
3. HAZARDS IDENTIFICATION	
Flammability	: Yes
Auto Ignition Temperature	: 80°C
Corrosive Material	: No
Explosive Material	: Yes
4. FIRST AID :-	
At inhalation, ingestion and contact with skin	: Rinse with plenty of soap and water and if suspect symptoms persist seek Medical advice.
Eye Contact	
5. FIRE FIGHTING MEASURES	
Fire	: Flammable.
6. ACCIDENTAL RELEASE MEASURES	: Spillage should be washed away with water.
7. HANDLING & STORAGE	
Handling & Storage precautions	: Keep in a cool and dry place.
8. EXPOSURE CONTROLS / PERSONAL PROTECTION	
Route of Entry	: Skin
Effects of Exposure	: Constant exposure and inhalation may cause mild irritation to the nose, eye and skin. Wash the affected area with lot of water and consult a doctor.
Personal protective equipment	: Avoid direct contact with hands, use gloves wherever possible.
9. PHYSICAL AND CHEMICAL PROPERTIES	
Appearance	: Creamish white pasty liquid
Physical state	: Liquid
Odor	: Specific odour
10. STABILITY AND REACTIVITY	
Chemical Stability	: Stable
Incompatibility with	: Data not available
Other materials	
11. TOXICOLOGICAL INFORMATION	
On product	: No data available
On Ingredients	: No data available.
12. ECOLOGICAL INFORMATION	
On product	: No data available
On Ingredients	: No data available
13. DISPOSAL CONSIDERATIONS	
Empty Buckets	: Never use empty buckets for storing food stuffs or other materials meant for human and animal consumption. Empty buckets may be sold as scrap or to HDPE recyclers approved by the State Pollution Control Boards.
14. TRANSPORT INFORMATION	: Non-dangerous product for transportation by road, sea, air.
15. REGULATORY INFORMATION	: No data available
16. OTHER INFORMATION	: No data available

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