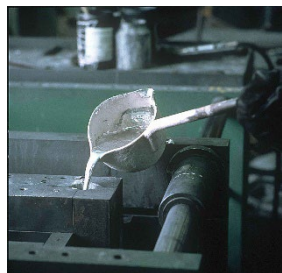




## TECHNICAL DATA SHEET

# METALCOTE 24 S

*Insulating coating for gravity dies in Aluminium foundries*



### DESCRIPTION

Metalcote 24 S is a newly formulated die-coating which consists of a blend of insulating mineral compounds, water, binder and additives. The coating is suitable for aluminium gravity foundries and finds its best application in coating die cavities when liquid aluminium, after being poured into the mould, starts to solidify. Its new formulation is the result of our experience and of modern technology additives improving wetting and dispersing capabilities of foundry coatings.

Recommended for all aluminium alloys poured in gravity dies with regular geometry and casting pattern. Particularly suitable, due to the insulating properties, for feeding heads to delay solidification time and extend feeding effect. Presence of sodium or strontium modifiers in the alloy will not affect its life.

**Superior insulating and resistance properties, ideal for risers, sprue, runners, gates and even die face.**

### PRODUCT PHYSICAL DATA

<b>Appearance:</b>	Soft paste	<b>Colour:</b>	Light grey
<b>Specific Gravity:</b>	1,9 g/cm <sup>3</sup>	<b>Casting finishing:</b>	Moderately fine

### METHOD OF USE

After dilution with water, spray the product on a pre heated and clean die using an air gun. Coating should be applied in thin layers. Each layer should be allowed to dry prior to application of a new layer. This technique ensures smooth shiny surfaces to castings produced.

### DIE TEMPERATURE

The die should always be pre-heated to a temperature of 160-200°C.

A higher temperature will compromise the adhesion of the product and will possibly cause cracking and peeling of the coating layer.

Use die heaters with soft gas torch and consult our die coating pre heating guide.

### DILUTION RATIO

For spraying application Metalcote 24 S needs a dilution of 1 part of product with 2 or 3 parts of water.

For brush application Metalcote 24 S needs a dilution of 1 part of product with 1 part of water (by weight).

### PACKAGING AND STORAGE

8 kg tins

Warning: The product is frost sensitive: Store at temperatures above 5 ° C and close the pails after each use.

It is possible that during storage some products containing mineral ingredients tend to precipitate.

This phenomenon is normal due to the specific density of the minerals.

It is important to mix the product carefully before use.

If properly stored the product shelf life exceeds 12 months.