



**THERMOCHEM**  
ISO 9001 Certified Company



**CERAFLUX**  
*Products Accredited By Foundrymen*

**CERAFLUX GROUP OF COMPANIES**

## PRODUCT DATA SHEET

### CERAFURAN

#### (FURAN ACID NO BAKE)

**PRODUCT:** CERAFURAN R-701 is Available in two versions, depending on applications. Nitrogen free suitable for steel castings and another is with various nitrogen content suitable for ferrous and non-ferrous castings.

CERAFURAN is a ideal process for large castings such as machine tools, wind mill, cylinder blocks of marine engine. It is a two part process, resin is either co-polymer of Furfuryl alcohol with Urea-Formaldehyde or Phenol-Formaldehyde and catalyst is Sulphonic acid.

This is best process for mechanical sand reclamation compare to other no bake processes. The reclamation level with CERAFURAN R-701 is more than 90-92%.

**APPLICATIONS:-**CERAFURAN R-701 along with CERAFURAN C-710 is used for making mould and cores by no bake process for ferrous and non-ferrous castings. CERAFURAN offers best thorough curing characteristics. Flask less moulding is also possible with CERAFURAN process.

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#### **THERMOCHEM PROCESSES PVT. LTD.**

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### PHYSICAL PROPERTIES:

| PROPERTIES                          | CERAFURAN R-701          | CERAFURAN C-710            |
|-------------------------------------|--------------------------|----------------------------|
| Appearance                          | Light brown clear liquid | Reddish brown clear liquid |
| Sp. Gravity @30°C                   | 1.15 – 1.25              | 1.20 – 1.30                |
| Viscosity by B4 cup@30°C            | 15 – 30 seconds          | 13 – 20 seconds            |
| Free formaldehyde                   | < 0.5%                   | -                          |
| Shelf life from date of manufacture | 6 months                 | 12 months                  |

CERAFURAN C-710 is available in wide range, to suit the seasonal demands of bench life, strip time and for metallurgical properties.

### SAND MIX PREPARATION:

Dry silica sand [AFS 50-60]

(free from carbonates and chlorides)

-100 parts

CERAFURAN R-701

- 1.2- 2.0% based on sand,

CERAFURAN C-710

- 30-60 % based on CERAFURAN R-701

Note:- For good quality reclaimed sand, addition level will be

CERAFURAN R-701

- 0.9- 1.5% based on sand

CERAFURAN C-710

- 30-60 % based on CERAFURAN R-701

Sand mixing can be done in either batch or continuous mixer, but one should ensure for no free resin lumps in sand mix.

Addition level of CERAFURAN C-710 controls the bench life and strip time.

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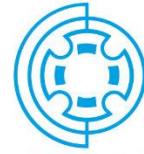
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### Mixing cycle:

Dry silica sand + CERAFURAN C-710 → mix for 1 – 1 ½ minutes

+ CERAFURAN R-701 → mix for 1 ½ - 2 ½ minutes

These are typical mixing times, which can vary with speed and type of mixer.

**Bench Life-** 5-20 minutes

**Stripping time**– 30 Minutes - 4 Hrs.

**STRENGTH COMPRESSIVE** (Resin-1.5% of sand, Catalyst-40% of Resin)

| Time | Strength in kg/cm <sup>2</sup> |
|------|--------------------------------|
|------|--------------------------------|

|      |        |
|------|--------|
| 1 Hr | 5 - 10 |
|------|--------|

|       |         |
|-------|---------|
| 4 Hrs | 20 - 25 |
|-------|---------|

|        |     |
|--------|-----|
| 24 Hrs | >30 |
|--------|-----|

Strength will vary with quality of sand and ambient atmospheric conditions.

**Mould & Core Wash:** We recommend water base refractory wash.

### SHELF LIFE:-

CERAFURAN R-701 – 6 months from date of manufacturing

CERAFURAN C-710 – 1 year from date of manufacturing.

### STANDARD PACKING:-

CERAFURAN R-701 – 225 kg MS/ HDPE drums.

- 1200 KG IBC TANK

CERAFURAN C-710 – 50/100/225 kg HDPE carboy/drum.

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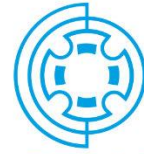
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### **STORAGE & HANDLING:**

CERAFURAN R-701 and CERAFURAN C-710, should be stored separately, away from direct source of heat, moisture under roof at below 30°C

Never mix CERAFURAN R-701 and CERAFURAN C-710 together in a container, without sand. Direct mixing of CERAFURAN R-701 and CERAFURAN C-710 causes a violent exothermic reaction.

Handle CERAFURAN R-701 and CERAFURAN C-710 with proper care by using safety tools like chemical resistance hand gloves, safety goggles

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