



Product Information Ester

Description Highly fluid crosslinking agents for self hardening of waterglass bounded sands.

Esters are special mixtures of glycerol acetates.

Field of use Hand-moulding and large core production.
The so-called "water glass-ester method" is applicable to all types of casting.

Application The preparation of the sand mixture has to take place by appropriate mixing tools. It is possible to use continuous and batch mixers. The mixing time should be as short as possible.

The required addition levels in the mould and core production vary by quality of the sand and use. In relation to the sand itself **ester** amounts arise from 0,3 to 0,4 kg, and silicate quantities from 2,1 to 2,8 kg.

Depending on the cross-linker, the following properties of the sand mixture arise:

	<u>Ester B-41</u>	<u>Ester B</u>	<u>Ester D-41</u>	<u>Ester D</u>
cure speed	slowly	slowly	very fast	fast
processing time	10-20 min	8-15 min	3-10 min	5-10 min
stripping time	> 2,0 h	> 1,5 h	> 0,5 h	> 1 h

As **esters** are miscible with each other, the processing properties can be adjusted.

Technical data	<u>Ester B-41</u>	<u>Ester B</u>	<u>Ester D-41</u>	<u>Ester D</u>
Colour:	colourless	blue	colourless	green
Density (20°C):	always about 1,17 g/cm ³			
Flash point:	always about 145 °C			

Packaging Can á 30 kg and disposable drum á 240 kg

Storage Store **esters** tightly closed in a dry, well-ventilated place.
At storage temperatures < 10 °C it may possibly come in crystallization.
Shelf life 24 months when properly stored inside in original unopened container.

Regulations and information **Esters** are classified as non-hazardous according to the CLP regulation and therefore not subject to labeling.
They correspond to the current EC regulation.
Information about transport regulations, fire-fighting measures, accidental release, ecology and further information can be found in the material safety data sheet.

All information in this data sheet are based on our current knowledge and experience. A legally binding assurance of certain properties or suitability for a specific purpose cannot be derived. Each user of our products has to verify the usability for its specific purpose in his personal responsibility. Rights must be observed if required.