

## Urethane Binders (Amine Cured)

Ref: SD 003

Urethane binders are still the most popular cold box binder system.

As part of our product portfolio Eurotek has produced a range of PERMACURE binders with several enhanced features. PERMACURE systems with either TEA or DMEA catalyst offers: -

- ◆ Excellent bench life
- ◆ Good humidity resistance
- ◆ Low resin wipe
- ◆ High tensile and out of box strength
- ◆ Good box release
- ◆ Very low smoke on pouring
- ◆ Very low carbon residues on permanent moulds

These features coupled with the low amine requirements make PERMACURE a versatile high quality cold box system for a wide range of applications.



With good resin wipe properties volume core making is obtained with reduced cleaning time for patterns

Low binder levels offers excellent flowability



**PERMACURE – COLD BOX BINDERS**

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Certificate Number 30614

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## Applications

The PERMACURE 705/ 905/ 920 Series is suitable for a wide range of applications. Small or large, moulds or cores, in high or low production runs. Most metals, including steel & iron castings can be produced with these products.

The Permacure 920 offers extended bench life properties with some sacrifice of storage stability.

As part of our increasing product range Eurotek has developed the PERMACURE 755/ 955 system specifically for use in aluminum casting applications, and Permacure 744 offering high hot strength, low odour and excellent bench life characteristics.

Typical addition rates would be 0.5–0.8% of Part I and Part II (BOS) but dependant upon type of sand, equipment in use and core box design.

## Application

Part 1	Part 2	Application	Notes
705	P 905	All Alloys	Good all purpose system
705	P 920	All Alloys	Excellent bench life
750	P 950	All Alloys	Very low fume system
755	P 955	Aluminum	Low smoke, good breakdown
744	P 905	All Alloys	Excellent hot strengths
Catalysts	Grade No	Cure time	
	TEA	Normal	General purpose catalyst, coupled with lower odour
	DMEA	Fast	Very reactive catalyst, though odour often higher.

## Packages

PERMACURE CB Part I Resin	-	25, 50 and 200 Litre drums, 1000 Litre IBC's
PERMACURE CB Part II Resin	-	25, 50 and 200 Litre drums, 1000 Litre IBC's
Amine Catalysts Part III	-	5, 10, 25 and 200 Litre drums

## Health & Safety

For further information refer to relevant Health & Safety Data Sheets.

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