

Urethan (No-Bake)

Ref: SD 004

Low Emission Air-set System

The new PERMACURE systems are the latest 3-part no-bake development. Eurotek has produced this new range of products to offer the Foundry , low odour environmentally friendly technology. In addition to the low phenol & formaldehyde levels the system exhibits: -

- ◆ **Rapid pattern/core box turn around**
- ◆ **Low thermal expansion/shrinkage**
- ◆ **Excellent tensile strengths**
- ◆ **Good knockout**
- ◆ **Low emissions on mixing and casting**
- ◆ **Reclamation up to 80% with attrition methods**
- ◆ **Reclamation is total using Thermal methods**
- ◆ **Permacure is usable with all alloys**



Excellent Bench life to Strip time ratio gives high volume moulding capability.

Low binder additions on New & Reclaimed Sand



PERMACURE – NO BAKE BINDERS

EUROTEK FOUNDRY PRODUCTS LIMITED

Wistons Lane, Elland, West Yorkshire, England HX5 9DT.
Telephone: 00 44 1422 375550. Facsimile: 00 44 1422 375504
www.eurotek.eu.com Email: info@eurotek.eu.com



Certificate Number 30614

Urethane (No Bake)

Ref: SD 004

PERMACURE systems are suitable for a wide range of metals and applications. An iron oxide addition may be beneficial in certain applications.

Typical addition rates would be 0.4–0.8 % of Part I & Part II with 1–10 % Catalyst based on Part I.

Due to the small catalyst addition some foundries find it more convenient to pre-blend it with the Part I. This premix however is only stable for a day. A range of catalysts is offered to suit most needs, Permacure AS 10, 20, 30 & 40

Application

Part 1	Part 2	Application	Notes
AS 1	AS 2	Iron & Steel	Good all purpose system
AS 710	AS 2	Iron & Steel	Low fume system for Ferrous
AS 1000	AS 2000	Aluminium	Low fume system for Non Ferrous

Catalysts	Grade No	Cure time	
	AS 10	20 - 45 Mins	For maximum bench life
	AS 20	8 - 20 Mins	General purpose catalyst
	AS 30	3 - 8 Mins	High reactivity catalyst
	AS 40	< 1-3 Mins	Very reactive catalyst for rapid cure

Packaging

Permacure Part I: 25, 50 and 200 Litre drums, 1000 Litre IBC's
Permacure Part II: 25, 50 and 200 Litre drums, 1000 Litre IBC's
Catalyst Part III: 5, 25, 50 & 200 Litre drums.

Health & Safety

For further information refer to relevant Health & Safety Data

