

Eurotek Alkaline Phenolic Technology

Permabind (No Bake)

Ref: SD 005

As the demands of the environment become more stringent on the operation of the foundry, there is a need to reclaim higher levels of sand bonded with alkaline phenolic resins. Following on the success of its PERMABIND 400 series of resins, Eurotek have developed a new range of high reclamation binders & hardeners. The PERMABIND PLUS SYSTEM not only offers a major improvement in reclamation levels but maintains existing benefits of alkaline phenolic resins, such as excellent casting finish and environmental conditions.

LOW EMISSIONS - HIGH RECLAMATION - LOW COST

- Excellent casting finish
- Excellent pattern strip
- Water soluble binder system
- No Sulphur
- Low fume on mixing & casting
- Can be used for core & moulding
- Reclaim levels of 80%



Hand mould heavy section
core making



Box or Boxless Moulding in
Reclaimed Sand



PERMABIND – LOW ODOUR BINDERS

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Certificate Number 30614

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Application

PERMABIND resins can be used for the production of a wide range of castings in a wide range of alloys. Suitable for both cores and moulds, resin additions are typically in the region of 1.0–1.5 % on an 80–90 % reclaimed sand system. To achieve optimum environmental and molding properties, the PLUS Hardeners are recommended, often with the use of a water additive at the mixing station. The PERMABIND PLUS Hardeners used at 20 % additions (based on resin weight) offer a variety of strip time options to suit the needs of most foundries.

Grade	N2 (%)	Application	Notes
PB 404	< 1.5	Aluminium	Low Fume Binder
PB 408	< 0.5	Steel	For very low N2 applications with key steel grades
PB 410	< 0.8	Steel & Iron	General purpose binder
PB 415	< 1.0	All Alloys	High Reclamation levels

Hardeners	Bench Life	Strip time
PBP 1	1 min	2 mins
PBP 2	2 mins	4 mins
PBP 3	4 mins	7 mins
PBP 4	6 mins	10 mins
PBP 5	12 mins	20 mins
PBP 6	15 mins	30 mins
PBP 7	20 mins	45 mins
PBP 8	30 mins	60 mins
PBP 9	45 mins	90 mins

Packaging

PERMABIND Resins	-	200 Litre steel drums,
	-	1000 Litre returnable IBC's
	-	7–20,000 Litre bulk road tankers.
PERMABIND Hardeners	-	200 Litre steel drums & 1000 Litre returnable IBC's.

Health & Safety

For further information refer to relevant Health & Safety Data



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