

841 CORE OIL

Typical Product Data

*These values are not intended for use in preparing specifications.

Appearance: Dark Brown Liquid

Density (lbs./gal.): 7.6

Viscosity: 1000 cps @ 68°F

Flash Point (C.O.C): 100°F Minimum

841 CORE OIL is a solvent containing core oil formulated with alkyd oils, petroleum resins, solvents and drying agents and is used in operations that require high strengths fairly quickly. An added benefit of **841 CORE OIL** is the lowered viscosity that allows a shorter mixing time or the use of a less efficient mixer.

| Baking Strengths | Sand Mix (Based on 720 Sand) |
|------------------|------------------------------|
| Sand | 93.40% |
| Cereal | 0.93% |
| Core Oil | 3.34% |
| Water | 2.33% |

Mix all dry ingredients for one (1) minute
Add the water and mix for one (1) minute
Scrape down mixer
Add the core oil and mix for one (1) minute
Scrape down
Mix for five (5) minutes

After making core samples, bake for 2 hours at 400° F.

| Time (Minutes) | Tensile (P.S.I.) |
|----------------|------------------|
| 20 | 20 |
| 40 | 100 |
| 60 | 200 |
| 90 | 275 |
| 120 | 275 |

USE RECOMMENDATIONS:

841 CORE OIL can be used with any type of mixer as long as the mixing efficiency is high enough to allow proper dispersion of the oil. Specific sand mixes are not recommended here due to the variety of applications for this product.

PACKAGING:

Totes
Drums
Pails

