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Techniset® 6435 UNB Part 2

Product Features

Techniset 6435 UNB Part 2 Resin has been designed for general foundry use, as well as high hot strength. Techniset 6435 was designed for use with Techniset Part 1 Urethane Resins, and is suitable for ferrous and non-ferrous applications. Features available when using Techniset 6435 Pt2 with the appropriate Part 1 component include the following:

- High Tensile Strength
- Improved Hot Strength
- Low VOC Emissions
- Reduced Smoke

Product Description

Techniset 6435 UNB Pt2 is a polymeric MDI-type isocyanate resin that is used in conjunction with a phenolic resin, such as BioSet T8000, Techniset F6000 and other Techniset Part 1 resins, for ferrous and non-ferrous no bake applications. Typically, the Part 1 and Part 2 resin components are mixed with suitable sand, normally silica or lake sand, or reclaimed sand, in ratios ranging from 50/50 to 60/40, and at a total resin level in the range 0.8 to 1.5%, based on the weight of the sand. The sand mix also includes an amine catalyst, which is typically pumped into the Part 1 resin stream just prior to discharge into the sand. This catalyst is typically used at a level of from 2- 10% based on the Part 1 resin and is used to accelerate the formation of a urethane bond. A broad range of catalysts are available. The selection of an appropriate catalyst will allow a wide range of strip times to be achieved.

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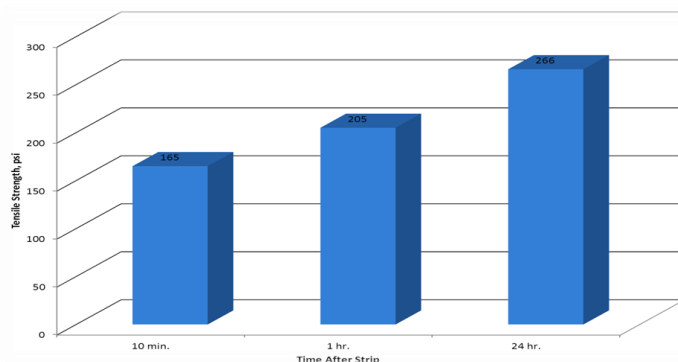
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Physical Properties

| TYPICAL PHYSICAL PROPERTIES | |
|-----------------------------|--------|
| Refractive Index | 1.5870 |
| Viscosity (cps) | 40 |
| Flash Point (°F TCC) | > 145 |
| Specific Gravity | 1.130 |
| NCO (%) | 23 |

Tensile Strength Development

Both strip time achieved and tensile strength development of the Techniset 6435 Pt2 Resin are dependent upon the catalyst chosen, as well as a number of other parameters such as sand quality, sand temperature, and catalyst level used. The graph given below indicates some typical tensile strengths achieved when used with BioSet T8000 UNB Pt1 and a typical catalyst at 1% binder - 55/45 Pt1:Pt2. The rate of tensile strength development can be increased or decreased based upon the catalyst selection.



Storage Guidelines

Recommended storage temperature is between 60 - 90 ° F. At lower temperatures, viscosity will increase, making pumping and mixing more difficult. At high temperatures, solvent loss can occur. Drum storage should be in a dry area, out of direct sunlight. Partially used drums should be tightly closed, to prevent contamination, primarily from water, which can adversely affect performance.

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Safe Handling

Chemically resistant gloves and eye protection should be used when handling or using chemical binders. Material Safety Data Sheets are available for all products. Drum labels also contain handling information. This material will react with the Part 1 component, without catalyst, in an exothermic reaction, to give a solid polymer. Do not mix Part 1 and Part 2 except on sand during use.

Technical Service

HA International is “The Best Total Solution” for your foundry by providing innovative products, in-depth technical assistance, and a diverse product line specially formulated for any foundry application. Both our in-house and field experts are available to assist you with your most challenging foundry applications. Please contact your HA International, LLC representative so that we may assist you in putting together a binder system and foundry team that will help you achieve your goals. Contact your sales representative for additional technical information.



**For Emergency Medical Assistance Please Call:
Health & Safety Information Services: 1-866-303-6949**

For additional health and safety or regulatory information, call
630-575-5722 or 630-575-5705.

Date: 4/11/2013 Author:ST

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