

Technical Data

TDNo. R-2E

Resitop for foundry

GCI provide phenolic resin to foundry market such as automobile parts. Phenolic resins, which have shorter mixing cycle or improved peel back property, which keep strength of the mold high level, are available.

【solid type】

Property Resitop	Softening point	Gel time sec/150	Flow mm/125	Cold-bending strength	Cure rate	Thermal expansion	Stick point	Peel back resistance	Note
PSM-6214	85	67	77	4	4	3	3	2	Standard resin
PSM-6267	89	81	58	4	3	3	4	2	Standard resin
PSM-4440	87	95	103	4	2	4	3	2	Low thermal expansion
PSM-6426	87	111	90	5	1	4	3	2	Low thermal expansion
PSM-4247	88	58	58	3	4	3	3	2	Rapid cure
PSM-4436	88	73	70	3	4	4	3	2	Rapid cure
PSM-6407	92	42	38	1	3	4	5	5	Peel back resistant
PSM-6415	90	50	45	2	2	4	3	5	Peel back resistant

Property Level	5	4	3	2	1	Unit
Cold-bending strength	8.0	7.0	6.0	5.0	4.0	3.0
Cure rate	rapid	standard	standard	standard	standard	slow
Thermal expansion	small	standard	standard	standard	standard	large
Stick point	110	105	100	95	90	85
Peel back resistance	better	standard	standard	standard	standard	worse

Cure rate is comprehensively evaluated by vending, hot-bending strength and internal cure rate.

RCS: Silica sand, resin 2.0BOS, hexamine15PHR, water1.5 BOS, Ca-St0.1 BOS

The above values are typical information and are not guarantee value.

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