

## PLASTICS for FOUNDRY

### PHOS BONDED

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
CW BLU PAK PLASTIC	71	21.4	2.74 / 171	1705°C (3100°F)
MINRO-AL® PLASTIC A76	67.3	25.7	2.69 / 168	1650°C (3000°F)
MINRO-AL® PLASTIC A 91	87.4	7.1	3.04 / 190	1705°C (3100°F)
CW 85 HS PLASTIC	83.8	9	2.92 / 182	1760°C (3200°F)
CW 85 HS PLASTIC FINE	83.7	9.8	2.82 / 176	1760°C (3200°F)
CW 90 HS PLASTIC	89.1	6.2	3.09 / 193	1815°C (3300°F)
CW 90 HS PLASTIC FINE	89.9	6.3	2.88 / 180	1760°C (3200°F)
CW 388 PLASTIC	90.9	5.4	3.09 / 193	1760°C (3200°F)
CW 97 PLASTIC	89.4	3.8	2.88 / 180	1760°C (3200°F)
CW 86 PLASTIC	82.7	8.2	2.73 / 171	1760°C (3200°F)
CW 67 PLASTIC	64.1	27.8	2.40 / 150	1760°C (3200°F)
STEEL-PAK 86CR	75.5	11.9	2.92 / 182	1760°C (3200°F)
STEEL-PAK 90CR	73.1	12.3	2.93 / 183	1760°C (3200°F)
AC PLASTIC	83.3	3.6	3.17 / 198	1815°C (3300°F)

### AIR SET / HEAT SET

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
PS SUPER PLASTIC	44.3	49.6	2.45 / 153	1705°C (3100°F)
PHOS FREE PLASTIC FINE	88.2	10.2	2.90 / 181	1730°C (3150°F)
CW 366 PLASTIC FINE	73.7	21.9	2.85 / 178	1760°C (3200°F)

### VIBRATABLES - PHOS BONDED

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
VIB RAM 70	67.7	26.5	2.71 / 169	1760°C (3200°F)
VIB RAM 85	88	4.7	3.16 / 197	1760°C (3200°F)



## PLASTERS / SEALS / VENEERS - PHOS BONDED

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
CW 608 SEAL	84	10.5	2.40 / 150	1760°C (3200°F)
CW 620 SEAL	58.3	36.3	2.39 / 149	1705°C (3100°F)
TITAN SEAL	70.8	22.9	2.24 / 140	1760°C (3200°F)
MINO-AL® PLASTER A78	67.3	25.7	2.69 / 168	1650°C (3000°F)
MINRO-AL® PLASTER A93	87.4	7.1	3.04 / 190	1705°C (3100°F)
CW 55 HS SEAL	57.1	36.8	2.11 / 132	1595°C (2900°F)
CW 90 HS SEAL	91.9	5	2.85 / 178	1760°C (3200°F)
SCOTT RAM PLASTER A95	75.2	6.6	3.04 / 190	1705°C (3100°F)

## PLASTERS / SEALS / VENEERS - AIR SET / HEAT SET

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
LADLE WELL	11	64.5	1.91 / 119	1540°C (2800°F)
PHOS FREE SEAL	88.7	9.8	2.90 / 181	1730°C (3150°F)
SIL-PATCH SUPER	1.1	97.1	2.08 / 130	1640°C (3000°F)

## PHOS BONDED

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
RAM 482A-W	78.3	15.1	2.76 / 172	1760°C (3200°F)
MINRO-AL® RAM A60-W	95.3	0.4	2.96 / 185	1815°C (3300°F)
SCOTT-RAM A64-W	87.4		3.04 / 190	1815°C (3300°F)
OXAL 95 R	93.6	3.2	3.20 / 200	1815°C (3300°F)
AC RAM	84.8	2.9	3.28 / 205	1815°C (3300°F)

## AIR SET BONDED

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
MINRO-AL® RAM A51-W	91.8	1.8	2.96 / 185	1760°C (3200°F)
MINRO-AL® PATCH A53-W	93.3	3.7	2.40 / 150	1760°C (3200°F)
MINRO-AL® A54-W CM	98.0	1.2	2.96 / 185	1815°C (3300°F)
MINRO-AL® PATCH A59-W FINE	95.5	2.8	2.76 / 172	1760°C (3200°F)
HI AL RAM 80	83.6	10.4	2.95 / 184	1760°C (3200°F)



## HEAT SET BONDED

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
MINRO-AL® PATCH A31-W	88.6	7.0	3.13 / 195	1705°C (3100°F)
MINRO-AL® PATCH A34-W	75.9	9.0	2.56 / 160	1650°C (3000°F)
LADLE RAM	59.8	37.8	2.77 / 173	1705°C (3100°F)

## GRAPHITIC RAM

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
HI AL RAM G SUPER	79.8	5.7	3.00 / 187	1760°C (3200°F)
HI AL RAM G 410	73.5	9.6	2.79 / 174	1705°C (3100°F)
CW 467 RAM	69.0	9.4	2.80 / 175	1650°C (3000°F)
CW 469 RAM	67.9	1.7	3.15 / 197	1650°C (3000°F)

