



**THERMOCHEM**  
ISO 9001 Certified Company

## TWO PART PHENOLIC ESTER CURED NO BAKE BINDER SYSTEM

### CERASET

#### Product Data Sheet

**PRODUCT:** CERASET R-301 is a highly alkaline phenol formaldehyde resin cured by CERASET C-310 at ambient temperature. The process is also known as phenolic ester no bake or Alphaset process. The resin cures in two stages, in first stage partial curing takes place and in second stage when mould or core comes in contact with molten metal.

The CERASET R-301 offers high hot strength than any other process. The process is nitrogen and sulphur free.

CERASET R-301 Phenol Formaldehyde alkaline resin acts as a binder

CERASET C-310 Ester catalyst.

CERASET C-310 is available in three versions Slow, Medium and Fast. Type of CERASET C-310 decides bench life and strip time.

#### APPLICATIONS:-

CERASET R-301 along with CERASET C-310 is used for making sand moulds and cores for Steel, S.G. Iron, CI and non-ferrous castings. The process comparatively less sensitive towards sand quality.

The process offers excellent thorough cure and stripping properties from pattern. Easy release from pattern is because of two stage curing mechanism of the process.

CERASET can be used with fresh sand, reclaimed sand or olivine sand.

#### PHYSICAL PROPERTIES:

##### CERASET

PRODUCT	CERASET R-301	CERASET C-310
COLOUR	Reddish Brown	Colourless to pale yellow
APPEARANCE	Clear Liquid	Clear Liquid
SPECIFIC GRAVITY @30°C	1.20 – 1.30	1.05 – 1.15
VISCOSITY BY B4 CUP @30°C	25 - 50 second	--

### **THERMOCHEM PROCESSES PVT. LTD.**

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**SHELF LIFE:-**

CERASET R-301 – 2 months from date of manufacturing

CERASET C-310 – 6 months from date of manufacturing

**STANDARD PACKING:-**

CERASET R-301 – 200/225 kg MS drums.

CERASET C-310 – 25 /200 kg MS drums.

**STORAGE & HANDLING:**

CERASET R-301 and CERASET C-310 should be stored separately, away from direct source of heat, moisture and under roof at below 30°C.

Never mix CERASET R-301 and CERASET C-310 together in a container, without sand. Direct mixing of CERASET R-301 and CERASET C-310 cause violent exothermic reaction.

Handle CERASET R-301 and CERASET C-310 with proper care by using safety tools like chemical resistance hand gloves, safety goggles.

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