

Technical Data Sheet



Product Name: Alumina Core Paint

Product Number: PL268

Product Description: To prevent 'canalling' defects on DS (Directionally Stable metal 'crystal') castings using performed cores made with a pure thin alumina coating applied by brush. A pure aluminium poly-hydroxy nitrate binder (mentioned in Russian literature as early as 1960's) in which is suspended very finely fused 5 micron alumina and other additives.

Approvals/Specifications: RR Code 138180

- Performance:**
- Ask for PL 268 Aid for help in spray application specified by Rolls Royce in helping production of parts
 - This material is used on designated areas where metal does not flow properly
 - Used for performing ceramics for the investment casting industry
 - PL 268 contains less than 1 part per million lead, 0.5 parts per million bismuth, 1 part per million silver, 10 parts per million tin, 20 parts per million zinc, 10 parts per million antimony and less than 900 parts per million iron.
 - In addition, there is no magnesium, calcium or silica.
 - Used by Rolls Royce and Lake Erie Design on preformed ceramic cores
 - Used at temperatures up to 1,350°C (2,462°F)
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Components: Single Pack Product. May be thinned for application using PL268-Aid

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Application:

Surface Preparation:	Ensure all surfaces to be applied to are dirt, grease and oil free
Paint Preparation:	Materials tend to settle so please ensure that it is agitated or rolled prior to use
Application Method:	<ul style="list-style-type: none">- Apply to core surface with a small camel hair brush or by dipping- If necessary, add water to suit individual paint to style- Cores must be painted in the unimpregnated condition, before urea or resin treatment.
Drying Curing:	Allow to dry for approximately 2 hours then fire to 550 to 600°C (1,020-1,120°F) for 30 minutes to decompose the Organic ingredients in the paint. Cores may be then impregnated and used as usual

Technical Properties:

Supply Viscosity:	ISO5 Cup
Flash Point:	N/A
VOC Content:	N/A
Colour:	Light green
Pack Size:	500ml containers
Density:	1.515 +/- 0.015kg/l
Gloss:	Matt
Thinner:	PL268 - Aid
Solvent/Clean Up:	Water
Catalyst:	N/A
Theoretical Coverage:	-

Storage:

Water based; affected by frost. Store between 5°C -35°C

Shelf Life: 12 months temperate; 6 months tropical

Before use, refer to Product Safety Data Sheet

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Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

Tel: +44(0)121 702 2485

Email: sales@indestructible.co.uk