



# Technical Data Sheet

## PLASTIFLAKE 1119

### Product Features:

Plastiflake 1119 Flake Shell Resin is a medium melt point, plasticized resin developed for use in general purpose applications. The following product features also characterize this flake resin;

- General Purpose Flake Resin
- Contains an Internal Release Agent
- Plasticized to Reduce Thermal Cracking

### Product Description:

Plastiflake 1119 is a medium melt point flake resin developed for use in the shell process (Croning Process) for producing foundry cores and molds. This resin is used to coat sand using the hot coating process. In general terms, this process involves the following steps;

- a) Sand is heated to 280 – 310 ° F.
- b) Flake resin is added and mulled for 60 – 90 seconds.
- c) The heated sand and resin mix is quenched with a water solution of hexamethylene tetramine (hexa).
- d) The hexa level used may be varied to impart specific properties to the coated sand, but is typically about 15% based on resin weight.
- e) Mull until sand dries out and breaks down.
- f) Discharge after breakdown. Normal discharge temperature is 150 – 170 ° F.

### Typical Properties

Typical Properties – Plastiflake 1119 Shell Flake Resin	
Appearance	Opaque Yellow-amber solid
Melt Point, deg. F	213 *
Hot Tensiles, 3 min.	375 *

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- \* Marked properties are tested on coated sand, using 3.0% resin on round grain, washed and dried silica sand. Results are obtained using Borden Chemical's equipment and test procedures. Actual results obtained may vary from these values, dependent upon the procedures and equipment used.

#### **Storage Guidelines**

Borden #1119 Shell Flake Resin has indefinite storage life when stored properly. Care should be taken to avoid high temperature and humidity in order to minimize caking during storage.

#### **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.

#### **Technical Service**

Proper selection of a binder system that meets your specific needs is key to achieving maximum performance benefits. Borden Chemical, Inc. provides in-depth technical assistance and a wide range of shell flake resins for your use in a variety of applications. Both our in-house and field experts are available to assist you with your most challenging foundry applications. Please contact your Borden Chemical, Inc. representative so that we may assist you in putting together a binder system and foundry team that will help you achieve your goals.

Plastiflake 1119 / 7-00

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