

Starch based additives

Complete range of starch and starch/bentonite blends ready to use, formulated to solve some typical problem in green moulding process :

- we can work with low bentonite tax sands (4-5%) with consequent lower humidity and higher permeability; therefore casts with a better superficial aspect and minor tendency to pin-hole phenomenon;
- we can increase cohesion with the creation of a strong superficial crust in case; in this way we succeeded in producing even very big cast parts with the green moulding process
- we can work with high wet tensile strength avoiding a lot of superficial defects
- keep an high level of sand

- no sand inclusions thanks to deep painting operations

The use of **PRETAP**, **QUELL MELL** and **GELAMID** increases considerably the sand plasticity and allows to improve the accuracy of the dimensions and the cohesion, specially the edges. The **PRETAP** slows down the humidity's evaporation and it avoids the formation of dust. This peculiarity simplifies the problems of hot moulding sand, and it reduces the arise of superficial imperfection

		Pretap	Quell mell	Gelamid	Gelamid 10	Stahlsec
Moisture Umidita' Humidité	%	12 max	12 max	12 max	12 max	12 max
pH	%	6-7	8-9	8-9	8-9	13-18
Ashes Ceneri Cendres	%	0,35	65 max	50 max	80-85	70 -75
Bulk density Peso specifico apparente Poid spécifique theorique	kg/dm ³	0,55	0,6-0,7	0,6-0,7	0,6-0,7	0,5-0,6
First adds Aggiunte iniziali Premières ajoutés	%	0,5-0,8	0,5-0,8	0,5-0,8	0,5-0,8	0,8

