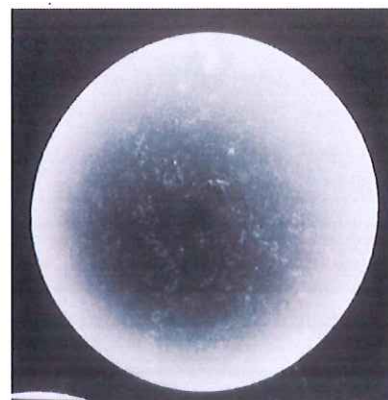


Synthetic spherical
sand for Casting

LUNAMOS MS



Features

Spherical / smooth surface...

- High mold strength
- Good fluidity / filling

Mulite composition...

- Low thermal expansion
- High Hardness

Effect

Reduce

- Gas defect
- Binder cost
- Burn defect

Reduce

- Burn defect
- Dust

◆ Chemical composition (Typical value)

Composition	Al ₂ O ₃	SiO ₂	TiO ₂	Fe ₂ O ₃	Cr ₂ O ₃
%	63	32	2.5	1.3	N.D

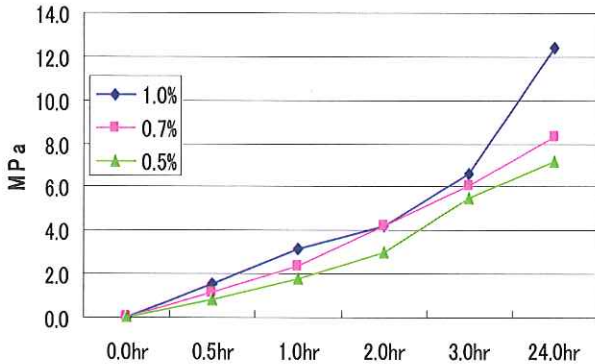
◆ Physical properties value (Typical value)

LOI (%)	pH	ADV (ml/50g)	Bulk density (g/cm ³)	True density	Repose angle (°)	Refractriness
0.0	8.9	2.7	1.68	2.84	27.8	SK37 over (1825°C)

◆ **Compressive strength (Example)**

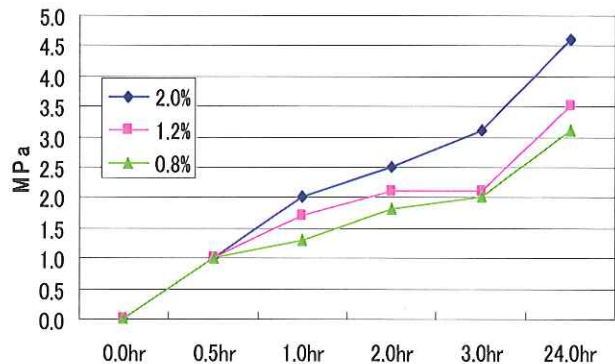
1. Furan Resin

Condition: 25°C / 55%RH
 Resin: EF-5302 0.5, 0.7, 1.0% (B.O.S)
 Catalyst: TK-3 40% (B.O.R)

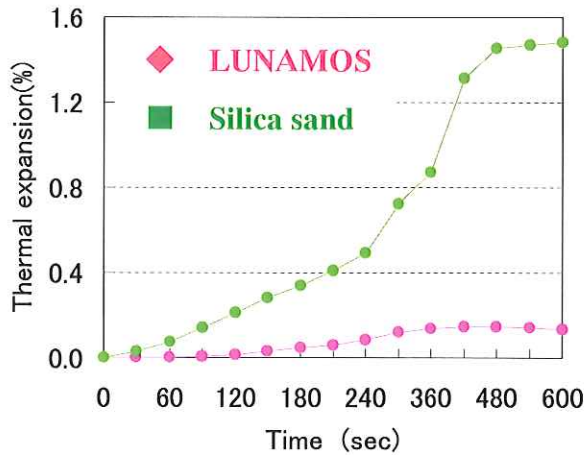


2. Alkaline Phenol Resin

Condition: 25°C / 55%RH
 Resin: SL-6010 0.8, 1.2, 2.0% (B.O.S)
 Catalyst: DH-25 20% (B.O.R)

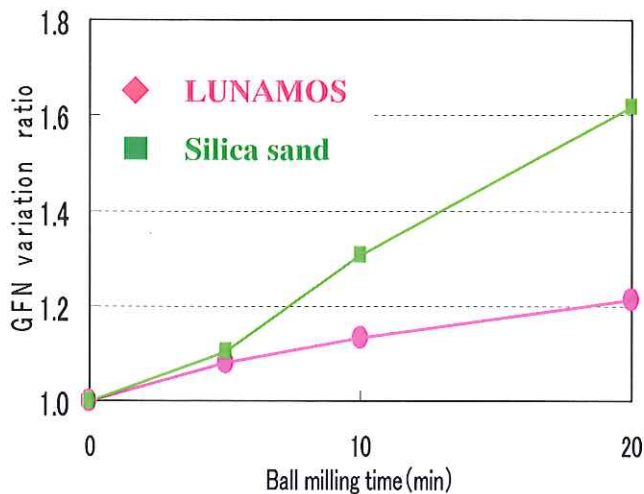


◆ **Thermal expansion**



LUNAMOS MS # 80
 Temperature: 1000°C
 Mold: Alkaline Phenol Resin 1.2% (B.O.S)
 Testing Method : JACT M-2

◆ **Evaluation of hardness**



LUNAMOS MS # 80
 Testing Method : JACT S-6