

## O.B.B.-Sand "S"

oil-bonded moulding sand

**O.B.B.-Sand "S"** is an oil-bound moulding sand which is delivered **ready to use**. Due to its binding it cannot dry out. Its high green strength allows producing contour and dimensionally accurate castings.

### Application:

**O.B.B.-Sand "S"** is mainly used for **aluminium** as well as **art castings** with thin wall thickness.

### Features:

Beside the standard quality **O.B.B.-Sand "S"**, it is possible to produce sands with either a higher or lower flowability. For higher flowability grade **O.B.B.-Sand "SM"**, or lower flowability grade **O.B.B.-Sand "SF"**. There are two different ways for using the **O.B.B.-Sand**. The sand is used only for the first layer, then it will be mix with the usual moulding sand and cannot be recovered. Or our **O.B.B.-Sand** is used as system sand. Then it is possible to recycle the sand with **O.B.B.-Oil and -Paste**.

### Physical Properties type:

|                      |                      | "S"  | "SM" | "SM 45" | "SF" |
|----------------------|----------------------|------|------|---------|------|
| Compressive strength | [g/cm <sup>2</sup> ] | 1250 | 1200 | 1380    | 1300 |
| Shear strength       | [g/cm <sup>2</sup> ] | 400  | 400  | 430     | 400  |
| Gas permeability     | [ ]                  | <18  | <20  | <20     | <16  |
| Flowability          | [%]                  | 32   | 40   | 45      | 23   |
| Fineness of grain    | [AFS]                | 220  | 220  | 220     | 220  |
| Average grain size   | [mm]                 | 0,07 | 0,07 | 0,07    | 0,07 |

### Processing:

When applying the sand on the pattern, the first layer should **always be sieved** and lightly pressed. Thereafter, the moulding box may be filled with unsieved moulding sand and compressed. **Do not add water** and **do not use any coating**.

### Packing:

25 kg bags

### Storage:

At least 1 year in airtight bags. Physical or colour alterations may occur by solar radiation and or admission of air.

The above information is correct to the best of our knowledge and careful consideration. OBB-sands are produced from natural raw materials. All data are approximate values at the time of production with product- and production- related tolerance. They serve only to describe and does not constitute guaranteed properties. We guarantee the faultless and consistent nature of our products, however, we are not liable for further processing results that usually arise beyond our control. Safety Data Sheets are available and can be requested from KBO.