

## O.B.B.- Sand Reclamation

Increasing environmental awareness and last but not least cost reasons (disposal) led in recent years to an ever-increasing regeneration of the starting materials. **All our O.B.B.- Sands can be regenerated, a precondition for this is, that they have been used as a unity sand (sand circulation) and not being mixed with normal moulding or core sand.**

### Regeneration of oil-bonded sands:

The regeneration of oil-bonded sands depends on how much burn out has taken place. In most cases the sand is only used once therefore regeneration is not necessary: In this case sand aerator should be used to improve workability. If the sand is used several times, depending upon wall thickness of castings, it will lose its plasticity and/ or its compression strength. In this case the sand should be regenerated in pan mill or intensive sand mixer.

To recover **plasticity**: add **approx. 0,1 % O.B.B.- Oil**  
To recover **compression strength**: add **approx. 0,1 % O.B.B.- Paste**

Use a short mixing time in the pan mill or intensive sand mixer: approx. 2 min. An optimum loosening results from additional use of a sand aerator.

### Regeneration of emulsion-/ water-bonded sands:

The above statements apply analogously also to the regeneration of emulsion-/ water-bonded OBB- Sands:

**O.B.B.- Sand "EW 30"** add **approx. 2 % special-emulsion "W"**  
**O.B.B.- Sand "A 25"** add **approx. 0,5 % bentonite / lustrous carbon (10:1)**

The amounts added are "approximate", depending on the requirements of the sand, the addition amount can slightly increase or decrease. Use regenerant sparingly: too much additions produce casting defects.

If you do not have a pan mill or intensive mixer is a regeneration in a simple mixer by the addition of a fat new sand possible, please contact us, we help you!

### Packing:

O.B.B.- Paste	buckets	5 kg / 10 kg
O.B.B.- Oil	cans	5 kg / 10 kg
O.B.B.- Emulsion	cans	5 kg / 10 kg

The above information is correct to the best of our knowledge and careful consideration. 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.

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