

TECHNICAL DATA SHEET

COLD-BOX PROCESS



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Sigmacure 126M UCB Pt 1

Sigmacure 126M (SC 126M) Phenolic Urethane Part 1 Resin, has been designed to offer improved tensile strengths and good bench life performance. SC126M also provides excellent release characteristics performance and compatibility with all refractory coatings.

FIELD OF APPLICATION

The SC 126M contains no reportable formaldehyde and can be used with several different Part 2 Isocyanate components, chosen depending upon the desired performance features. Features available when using SC 126M with the appropriate Part 2 component include the following:

- High tensile strength development
- Lower VOC as compared to standard PUCB systems as tested by OCMA
- Superior release and low resin wipe off
- Excellent resistance to aqueous coatings (enhanced dip and dry strengths)
- Good hot strength
- Excellent humidity resistance

PRODUCT CHARACTERISTICS

Relative Density	9.0	Flash Point, F ^o , TCC	176
Viscosity, cps	90		

PROCESSING / NOTES ON USE

Sigmacure 126M is a phenolic resin used in conjunction with an MDI-type isocyanate resin, such as Sigmacure 215. Both the Part 1 and Part 2 resin components are mixed with a new silica or lake sand, or a reclaimed sand, in ratios ranging from 50/50 to 60/40, and at a total resin content in the range of 0.8 % to 2.0 % based on the weight of the sand. The resulting sand mix is then blown into a core box and subsequently cross linked by passage of a vaporized tertiary amine catalyst such as, dimethylisopropylamine (DMIPA) or dimethylpropylamine (DMPA), to produce a urethane bond.

TRANSPORT AND STORAGE

Recommended storage temperature is between 60 - 90°F. At lower temperatures, viscosity will increase, making pumping and mixing more difficult. Freezing temperatures should be avoided. At high temperatures solvent loss can occur. Drum storage should be in a dry area, out of direct sunlight. Partially used drums should be tightly closed to prevent contamination, primarily from water, which can adversely affect performance. The recommended stock rotation is six months when properly stored.

PACKAGING

Pail	Drum	IBC (Tote)	Bulk Tank
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CORRESPONDING PRODUCTS

Sigmacure 215 UCB P2

Sigmacure 126M P1

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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. Drum labels also contain handling information. Part 1 will react with the Part 2 component, without catalyst, in an exothermic reaction, to give a solid polymer. Do not mix Part 1 and Part 2 except on sand during use. Please refer to the Material Safety Data Sheet for additional information.

**FOR EMERGENCY MEDICAL ASSISTANCE PLEASE CALL: Health and Safety Information Services
1-866-595-5738**

TECHNICAL SERVICE

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Sigmacure 126M P1

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