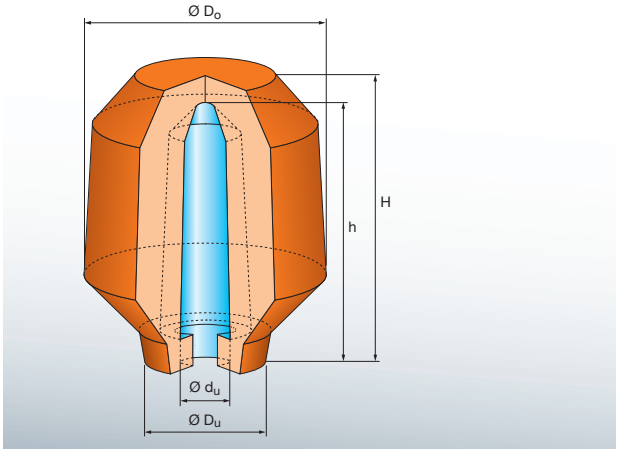
ASKCHEMICALS

EXACTCAST FDS (EX / EXF)

Silicate-bonded, highly exothermic, fiber-free mini-risers for iron and cast steel

Riser Types & Dimensions



- Developed for high-pressure molding lines when used with spring pins
- The exothermic riser throat is considerably constricted, thereby reducing finishing costs
- Using the spring pin can help to reduce feeder contact surfaces, surface flaws and pattern wear

EXACTCAST FDS are available in the following dimensions and packaging:

Type	Module	Riser Capacity		Riser dimensions					Packaging
	exoth. cm	Volume dm³	Weight kg	Ø D_o mm	Ø D_u mm	H mm	h mm	Ø d_u mm	pcs./ pal.
FDS 50	1.30	0.07	0.50	78	45	114	106	20x30	1,216
FDS 63	1.70	0.09	0.62	87	55	121	116	20x30	960
FDS 70	1.90	0.11	0.74	109	55	128	116	20x30	400
FDS 81	1.80	0.12	0.81	109	55	128	116	20x30	400
FDS 111	2.20	0.16	1.11	130	85	132	115	20x30	392
FDS 133	2.50	0.19	1.34	140	90	157	145	20x30	288
FDS 140	1.90	0.19	1.34	89x112	50x75	130	115	20x30	504
FDS 142	2.20	0.19	1.34	100x120	60x80	132	117	20x30	408
FDS 150	2.50	0.25	1.78	140	72	125	100	20x30	288
FDS 193	2.80	0.28	1.93	140	90	157	145	20x30	288
FDS 237	3.20	0.35	2.45	150	88	162	134	20x30	288
FDS 250	2.70	0.38	2.68	140	72	150	134	20x30	240

The information contained herein is based on the present state of our knowledge (dimensional tolerances based on DIN EN ISO 8062-3 DCTG 11) and therefore does not guarantee certain properties. Liability for product advice and product-related information within the limits of obligations arising from the collateral contractual agreements, if not expressly agreed upon therwise. (01 / 2023)

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EXACTCAST FDS (EX / EXF)

Technical & Ecological Advantages

- Suitable for gray iron, ductile iron, malleable metal and cast steel
- Improved yield thanks to lower liquid metal content
- Smaller contact areas compared to riser sleeves and natural risers
- Reduced fettling and blasting costs
- Suitable for horizontal molding lines when used in combination with spring pin
- Free of organic binders, low-emission, neutral CO_2 footprint
- Minimal riser residues in the used sand thanks to improved separability
- Available in fluorine-free (EXF) and low-fluorine (EX) formulations
- Reduced graphite degradation with fluorine-free mini-riser types
- By using fluorine-free risers, the sand system is free from fluorine contamination

Product Storage Conditions

- 9 months (if stored in dry conditions and intact original packaging)
- Protect from moisture
- Keep away from open flames and other ignition sources
- Read the Material Safety Data Sheet

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