



NAKAYAMA  
Co., Ltd.

## Surface Stabilizer for Green Sand Molds

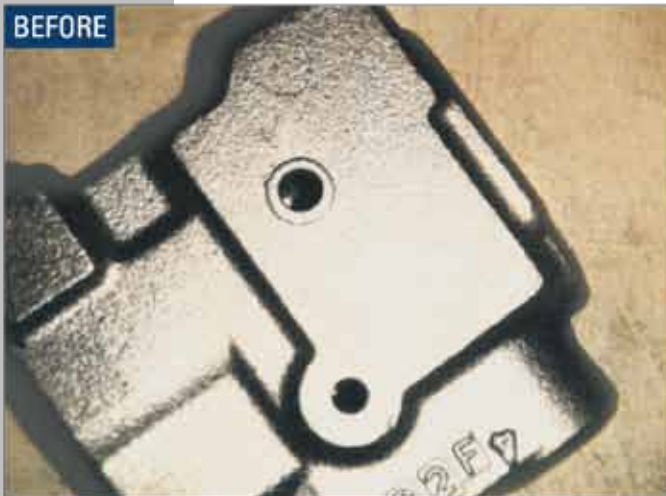
# T-MOLD

Reduces  
defects!

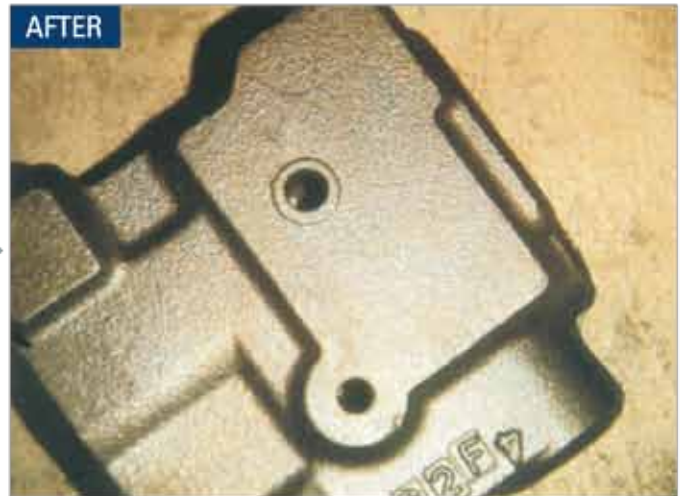
Outstanding  
effects!



BEFORE



AFTER



BEFORE



AFTER



**T-MOLD is an advanced surface stabilizer that consists mainly of sugar alcohol with moisture keeping capabilities. Conventionally, the casting sand failures have been caused by the fact that molten cast iron could not be poured immediately after molding.**

**This necessary waiting time changes the sand characteristics (moisture, rigidity, surface stability, air permeability, etc.) significantly.**

**In fact it is extremely difficult to control such changes in sand characteristics by adjusting the amount of primary and secondary binders. For this reason, this surface stabilizer has been developed to compensate for sand characteristics that may be insufficient at the time of pouring molten iron into the sand mold by preventing water vaporization, degradation of surface stability, mold shift, cracking, etc.**

## Features

- 1 Crumbling of sand, the major cause of sand mold failures is avoided and the surface stability is enhanced to prevent sand inclusion, erosion or penetration.
- 2 Better casting surface. Casting products such as manhole hatches, water pipe parts, art and handicraft objects that need letters, patterns or stripes in relief can be made with clear details.
- 3 Smooth textures are obtained on the as cast surface, facilitating finishing processes such as machining and painting.
- 4 T-MOLD is in liquid form and can be diluted with water for spraying.  
(Once diluted, the solution does not separate any more.)
- 5 T-MOLD does not contain nitrogen or sulfur.
- 6 According to the fire regulations T-MOLD is defined as a non-dangerous substance and is harmless.

## Directions

...The solution is prepared by diluting T-Mold by water with the volume ratio of one-to-one.

T-MOLD solution thus prepared can be used in two different methods.

**Method 1:** The solution is sprayed on a mold face just by a forward trip and a return trip of the nozzle. Both the cope and drag are treated similarly.

**Method 2:** The solution is mixed into the molding sand at mulling. The volume of the solution added is to be 0.01% to 0.05% of the sand volume.

### Characteristics

Component	Reduced starch sugar
Property	Transparent syrup-like solution
Concentration	70±1%
pH	4.0~6.5

### Packing form

24kg	5 Gallon-Can
250kg	Drum



5 Gallon-Can



**NAKAYAMA**  
Co.,Ltd.

■ **Head Office** 3-37-22 Kodama, Nishi-ku, Nagoya-City 451-0066 Japan  
Tel: +81-52-521-1171 Fax: +81-52-521-1180  
E-mail: [info@nakayama-meps.co.jp](mailto:info@nakayama-meps.co.jp)

■ **Website;** <http://www.nakayama-meps.co.jp/>

■ **Eastern Japan business office**

Tel: +81-24-545-6588 Fax: +81-24-544-6588

January, 2013 5th edition  
April, 2016 6st edition

Produced by

**Mitsubishi Shoji Foodtech Co., Ltd.**