

# Technical Data Sheet

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## ***Oil-bonded molding sand***

### **Supplier**

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### **Product Description**

The oil-bonded molding sand is supplied ready for use and does not dry out due to its binding. Its high green strength ensures precise and dimensionally accurate castings.

### **Application**

Oil-bonded molding sand with standard grain size is mainly used for heavy metals and iron casting in parts with thin to medium wall thickness, while extra fine grain variants are primarily used in the light metal sector and for artistic castings of thin-walled parts.

### **Technical Data (Molding sand, extra fine grain)**

Compressive strength	g/cm <sup>2</sup>	1.250
Shear strength	g/cm <sup>2</sup>	400
Gas permeability		<18
Flowability	%	32
Grain fineness	AFS	220
Average grain size	mm	0,07

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### Technical Data (Molding Sand, Standard Grain)

Compressive strength	g/cm <sup>2</sup>	1.300
Shear strength	g/cm <sup>2</sup>	400
Gas permeability		18
Flowability	%	35
Grain fineness	AFS	140
Average grain size	mm	0,09

### Processing

When molding, the first layer of sand should always be sifted onto the pattern and lightly pressed down. The flask can then be filled with reclaimed sand without sifting and compacted firmly. Do not add water or use parting agents.

### Storage & Shelf Life

Shelf life of at least 1 year in airtight bags. UV light and exposure to air may cause color and material changes.

The molding sand can be reconditioned and reused with suitable oil and appropriate paste.

### Safety

This product is not classified as a hazardous substance or dangerous preparation due to its moist, oil-bonded condition. The product contains quartz (respirable crystalline silica) and is supplied bound with oil, which keeps dust levels low. However, during processing (e.g., mixing, separating, or grinding castings),

respirable quartz dust may be generated. Long-term inhalation can lead to silicosis. Avoid inhalation exposure above the occupational exposure limit (OEL).

#### Important Safety Notes

- Do not swallow.
- Not edible.
- Not a toy.
- Keep out of reach of children.

#### Disposal

Dispose of according to local regulations.

#### Test Run

Before use, we recommend a trial run to check material compatibility and achieve the desired results. We accept no liability for damage resulting from improper use.

#### **Note**

The molding sands are made from natural raw materials. All information is provided as a guideline at the time of production and is subject to product- and manufacturing-related tolerances. They are intended for descriptive purposes only and do not constitute guaranteed properties. We accept no liability for the results of further processing that are beyond our control.

*This data sheet does not constitute a guaranteed specification. Subject to change without notice.*