



PA resins ab

Foundry resins

PA RESINS AB has an extended portfolio of products designed to achieve the highest requirements in foundries.

More than 30 years in the foundry business allow us to understand the modern foundry industries demands.





Foundry resins

Cold settings, furan products

Grade	Viscosity 25°C mPas	Nitrogen %	Free- formaldehyde %	Free- phenol %	Water Content %	Application
PA 1725F	30 – 100	c. 4	c. 0.5	0	c. 14	Medium to fast setting. Can be used together with organic as well as inorganic hardeners.
PA 1730F	10 - 60	< 2	< 0.5	0	c. 7	Medium to fast setting. Can be used together with organic as well as inorganic hardeners.
PA 1764F	30 – 100	c. 4	c. 0.5	0	c. 14	Medium to fast setting. Can be used together with organic as well as inorganic hardeners.
PA 1780F	5 – 40	< 1.5	< 0.2	0	c. 6	Medium to fast setting. Can be used together with organic as well as inorganic hardeners. Very high strength.
PA 1790F	5 – 40	< 0.5	< 0.1	0	c. 0.5	Medium to fast setting. Can be used together with organic as well as inorganic hardeners. Very high strength.
PA 5101F	200 – 400	0	< 0.7	c. 10	c. 14	Medium setting. Is recommended for heavy weight castings where high thermal strength is required.
PA 5710F	40 – 80	c. 0.5	c. 0.6	c. 0.6	c. 9	Fast setting. Hardener 9700F or 9755F is recommended. Suitable when low nitrogen content is required.
PA 5715F	40 - 80	< 0.7	c. 0.5	< 1	c. 8	Fast setting. Hardener 9700F or 9755F is recommended. Inorganic hardener not possible to use.
PA 5720F	20 - 80	< 0.6	c. 0.5	< 0.7	c. 7	Fast setting. Hardener 9700F or 9755F is recommended. Inorganic hardener not possible to use.
PA 5750F	100 - 200	c. 0.5	c. 0.6	< 1.0	c. 12	Fast setting. Hardener 9700F or 9755F is recommended. Inorganic hardener not possible to use.



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Hardeners for furan products

Grade	Application
PA 9600F	72% Benzene sulphonic acid. For very rapid settings. Have to be stored at temperatures above 0°C to avoid crystallization.
PA 9700F	65% Para toluene sulphonic acid. The acid contains maximum free sulphuric acid, 2 %. Can be used together with all kind of furan resins.
PA 9701F	65% Para toluene sulphonic acid. The acid contains maximum free sulphuric acid, 0.5%. Can be used together with all kind of furan resins.
PA 9750F	Blended acid with PTSA 65% and H3PO4 75%. 50/50 by weight. Is recommended for 1764F, 1725F, 1730F, 1780F and 1790F.
PA 9755F	55% Para- toluene sulphonic acid. The acid contains a minimum of sulphuric acid. Can be used together with all kind of furan resins. It is recommended when extended setting time is required or low sulphur content is required.

Hot-box products

Grade	Viscosity mPas	Nitrogen %	Free- formaldehyde %	Free- phenol %	Application
PA 5182F	500 - 700	< 6	c. 7	c. 6	Fast setting PUF product. Recommended to be used together the hardener 9142F. Core box temperature 200-240°C is recommended.
PA 9142F	< 5	0	0	0	Ammonium salt based product. Additional level is 5-10 % by weight of 5182F.



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Cold setting alkaline resin

Grade	Viscosity 25°C mPas	Nitrogen %	Free- formaldehyde %	Free- phenol %	Application
PA 5404F	50 - 90	0	< 1.0	< 0.5	Absence of nitrogen meet the highest demand for reclaimed sand. Potassium based product.

Ester based hardeners

Grade	Setting time Min.	Density g/cm ³	Appearance
PA 9603F	10	1.17	Colourless
PA 9604F	20	1.17	Colourless
PA 9605F	30	1.17	Colourless
PA 9606F	60	1.17	Colourless
PA 9607F	90	1.17	Colourless