



REFCOTEC
542 Collins Blvd.
Orrville, OH 44667

Telephone (330) 683-2200
Facsimile (330) 683-8200
email: customerservice@refcotec.com

OPTIMULL

A Revolutionary Green Sand Additive

OPTIMULL is a highly engineered liquid green sand additive, used to help foundries improve sand properties and reduce clay levels in prepared molding sand. A very small addition of OPTIMULL modifies the clays surface chemistry allowing nearly 100% activation of available clay and greatly reducing the latent clay. The increased effectiveness of the clay results in significant reductions in both clay and water. Lower water and clay levels lead to several other improvements. These improvements include; greater muller efficiency, enhanced flowability, improved mold densities (mold hardness), better water: clay ratios, reduction of water related defects such as penetration, expansion and gas.

OPTIMULL's unique blend of water soluble organic and inorganic materials also reduces the surface tension of water. This property will create a noticeable improvement in bonding of core sands entering your green sand system. When OPTIMULL is added at the muller; it allows for a better clay bonding mechanism onto the core sand surfaces in the prepared green sand. OPTIMULL reduces the negative affect of core sand contamination in the green sand system and could result in reduced cost with less new sand addition requirements.

OPTIMULL can provide the following benefits to your green sand system:

- Lower clay requirements (10% to 35% reduction)
- Reduced required moisture for targeted compactabilities
- More consistent sand properties
- Better sand flowability
- Enhanced mold definition & detail
- Less stickers & scrap molds
- Less gas, blows & pinholes

OPTIMULL is pumped directly into the muller in conjunction with the water addition, during the mixing cycle. The foundry provides power to the pump and a signal from the flush solenoid to start the timers on the OPTIMULL pump. The addition rate depends on the individual molding process, but is typically 0.5 ounces (14 grams) per pound of clay addition.

Packaging: 275 gallon poly tote - 2,400 lb 55 gallon steel drum - 500 lb.