

# foundrytec core adhesives

**DANLUBE A/S**

*"så ved du det holder"*

Tune Parkvej 5  
4030 Tune  
Tel. + 45 70 25 12 80  
info@danlube.dk  
www.danlube.dk

Hotmelt for sandcores



# foundrytec<sup>®</sup> core adhesives



**1** Internal sand core shape, and finished pump casting.



**2** Sand cores showing recesses required for hotmelt.



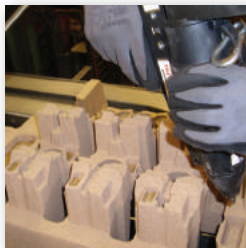
**3** Assembly of sand cores for cylinder blocks.



**4** Can be oven dried immediately.



**5** Typical cylinder head sand core assembly.



**6** Cylinder head sand core construction.

Simple adjustments to the tooling can be made to create the required recesses in the sand cores needed for the hotmelt bond.

Cores can be coated/dipped and then oven dried immediately. Oven temperatures and the time the cores spend in the oven vary. Sometimes the oven drying temperatures are unnecessarily high attempting to improve throughput. However, the insulation properties of the sand together with our higher heat resistant hotmelts can resist these high temperatures. On larger assemblies both hotmelt and water-based adhesives can be used together. The hotmelt acts as an instant clamp, allowing the cores to be moved and dipped immediately, with the water-based adhesive then giving very high temperature resistance.

Foundrytec<sup>®</sup> hotmelts do not affect sand reclamation.

**EPS/Lost Foam** processes can also benefit from our hotmelts and equipment.

**Wax/Investment** foundries would use our hotmelt foundrytec 501 with its low ash content.

Although the basic processes of forming a casting have many similarities, there are significant process variations. Different foundrytec<sup>®</sup> hotmelts are available to cater for these different processes.

## Foundrytec<sup>®</sup> Adhesive

Power Adhesives offer a range of foundrytec<sup>®</sup> hotmelts suitable for most foundry systems, enabling foundries to speed up all aspects of core production.

Foundrytec<sup>®</sup> hotmelt gives excellent adhesion where cold processes are used such as 'Cold Box', 'Alpha Set' and 'Beta Set'. They can also be used on 'Warm Box', 'Hot Box' and 'Shell' but these have to cool before hotmelt application.

Advantages of foundrytec<sup>®</sup> hotmelts over other fixing systems such as water-based glues:

- » Increased production
- » Improved accuracy
- » Risk of gassing is reduced
- » No solvent
- » Speed of set
- » No waiting
- » No shelf life
- » Reduced storage
- » Cost effective

Foundrytec<sup>®</sup> high-performance adhesive cartridges formulated for foundries and specially designed for use in the **tec 3400**, **tec 6100**, **tec 7100**, **tec 7200** industrial glue guns.

Reference	Description	43mm (1 3/4")
FOUNDRY-TEC-104	Long open time	■
FOUNDRY-TEC-301	General purpose – good on ceramics	■
FOUNDRY-TEC-501	Low viscosity, low ash content	■
FOUNDRY-TEC-601	Fast setting	■
FOUNDRY-TEC-705	Higher temperature resistance	■
FOUNDRY-TEC-708	Very high heat resistance	■
BULK HOT MELTS AVAILABLE FOR TANK DISPENSERS		





tec 3400

High output, electronically-controlled 43mm (1¾") glue gun for Industrial use. A powerful tool featuring patented ECOTEC® technology for exceptional temperature precision with eco-friendly phased standby operation.



Optional plug-in temp modules



Melt rate	3.8kg (8½lbs+)/hr
Glue size	43mm (1¾") glue cartridge
Voltage	120V and 230V
Wattage	400W
Heater	Cartridge
Temp Control	Electronic plug-in temperature modules
Hotmelt gun °C (°F)	195°C (380°F) fitted, Lowmelt 130°C (265°F), 160°C (320°F) and 215°C (420°F) modules included (additional modules available)
Lowmelt gun °C (°F)	Covered above
Power cable	3m (10 ft)
Weight	1.15kg (2½lbs)
Packaging	Plain box (5 per ctn)

tec 6100

Extremely robust 43mm (1¾") pneumatic glue gun for Industrial use. Reduces operator fatigue, power-on light, 8 bar (120psi) 14 l/min (0.5 cfm) air supply required.



Air assisted piston



Melt rate	4.1kg (9lbs)/hr
Glue size	43mm (1¾") glue cartridge
Voltage	120V and 230V
Wattage	500W
Heater	Cartridge
Temp Control	Interchangeable thermostat (Contact distributor)
Hotmelt gun °C (°F)	195°C (380°F), High temp polyamide version 215°C (420°F) also available
Lowmelt gun °C (°F)	130°C (265°F)
Power cable	3m (10 ft)
Weight	1.4kg (3lbs)
Packaging	Plain box (5 per ctn)

tec 7100

Extremely robust, very high output 43mm (1¾") pneumatic glue gun for industrial use. Reduces operator fatigue, speed loader to save time and power-on light. 8 bar (120psi) 14 l/min (0.5 cfm) air supply required.



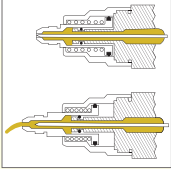
Melt rate	5.0 kg (11lbs)/hr
Glue size	43mm (1¾") glue cartridge
Voltage	120V and 230V
Wattage	1000W
Heater	Cartridge
Temp Control	Interchangeable thermostat (Contact distributor)
Hotmelt gun °C (°F)	195°C (380°F)
Lowmelt gun °C (°F)	130°C (265°F)
Power cable	3m (10 ft)
Weight	2.3kg (5lbs)
Packaging	Plain box (5 per ctn)

tec 7200

1000 watt, 43mm (1¾") glue gun with air assisted piston and nozzle for precise adhesive flow and instant cut off. It is also fitted with a speed loader to reduce down time.



Air assisted nozzle



Melt rate	5kg (11lbs)/hour
Glue size	43mm (1¾") glue cartridge
Voltage	120V and 230V
Wattage	1000W
Heater	Cartridge
Temp Control	Interchangeable thermostat (Contact distributor)
Hotmelt gun °C (°F)	195°C (380°F)
Lowmelt gun °C (°F)	130°C (265°F)
Power cable	3m (10 ft)
Weight	2.3kg (5lbs)
Packaging	Plain box (5 per ctn)

Stands



For heavy duty tools, 3000, 6000 & 7000 series (can be wall mounted, 3000 series only)

Reference	Description	tec 3400	tec 6100	tec 7100	tec 7200
PA3096-SPARES	Metal gun stand				

Extension variant



Reference	Description	tec 3400	tec 6100	tec 7100	tec 7200
ADD040-6M	6m (20ft) extension lead	-			
ADD040-12M	12m (40ft) extension lead	-			

# Nozzles



The **tec 3400**, **tec 6100**, **tec 7100** & **tec 7200** are supplied with a 2mm orifice nozzle. Standard fitted nozzles are shown in green ■

Reference	Description	tec 3400	tec 6100	tec 7100	tec 7200
ANZ016	2mm (0.080") orifice	■	■	■	-
ADJ013	3mm (0.120") orifice, 30mm (1¼") extension	■	■	■	-
ADJ002	2mm (0.080") orifice	-	-	-	■
ADJ023	3.5mm (0.138") orifice	■	■	■	-

# Spring Balancer



The SB/1200 spring balancer is a tool support system with an easily adjustable tension with a maximum cord length of 1.6 metres (5ft). It minimises operator fatigue, increases productivity and prevents tools from being dropped.

Reference	Description	tec 3400	tec 6100	tec 7100	tec 7200
SB/1200	Spring balancer for tools up to 1.5kg (3lbs)	■	-	-	-
SB/3000	Spring balancer for tools from 1.5 up to 3kg (3-6.5lbs)	-	■	■	■

# Silicone rubber drip mat



Reference	Description	tec 3400	tec 6100	tec 7100	tec 7200
TEC MAT	Silicone rubber drip mat protects work surface. Size 200mm x 200mm x 1.75mm	■	■	■	■



Europe's leading shaped hot melt adhesive specialist, offering the largest range of high quality, performance adhesives and hand-held glue applicators.

Over forty years experience has placed us in a unique position to offer industry specialist knowledge on all aspects of commercial gluing operations using thermoplastic adhesives.

Advanced technology at our modern UK production facility enables us to maintain the high level of quality which has become the hallmark of our products. A continuous programme of research and development ensures that we continue to meet the ever changing needs of industry, which includes the tecbond® system.



To reduce our impact on the environment our adhesives are often formulated using raw materials that have been harvested from sustainable managed forests.

Our packaging is recyclable and where possible made from recycled materials.

## Power Adhesives Limited

1 Lords Way, Basildon, Essex, SS13 1TN ENGLAND

Tel: +44 (0)1268 885800 Fax: +44 (0)1268 885810  
sales@poweradhesives.com www.poweradhesives.com

12 months warranty on all equipment



Over 90% of our products made in Britain