

DATA SHEET

H-7

Ceramic Core Material

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Description

General core type with an intermediate particle size distribution and open pore structure for use in Equiax castings. Generally used for difficult to leach parts as well as aluminium castings where core removal is accomplished by water blast or a knockout operation.

Major Chemistry

Silica (SiO₂), % 98

Other, % 2

Trace Element Analysis

Iron (Fe), ppm < 900

Bismuth (Bi), ppm < 1

Lead (Pb), ppm < 25

Silver (Ag), ppm < 25

Antimony (Sb), ppm < 25

Tin (Sn), ppm < 25

Zinc (Zn), ppm < 50

Physical Properties

Modulus of rupture (4-point), psi 825

Length shrinkage (mold-to-fired), % 0.4

Chord shrinkage (mold-to-fired), % 0.6

Thermal expansion coefficient (25 - 1000°C), ppm/°C 1.0

Bulk density, g/cc 1.6

Apparent density, g/cc 2.2

Porosity, % 28

Absorption, % 18

Cristobalite content (after fire), % 3

Cristobalite content (after 15 min. at 1390°C), % 10

Leachability (30% boiling KOH, 30 g sample, 30 min.), % 100

Core – Metal Reaction Compatibility

Most nickel based and aluminium alloys.

Please note that all values quoted are based on test pieces and may vary according to component design. These values are not guaranteed in anyway whatsoever and should only be treated as indicative and for guidance only. Jul. 28, 2015