SurfacePrep

Technical Data Sheet

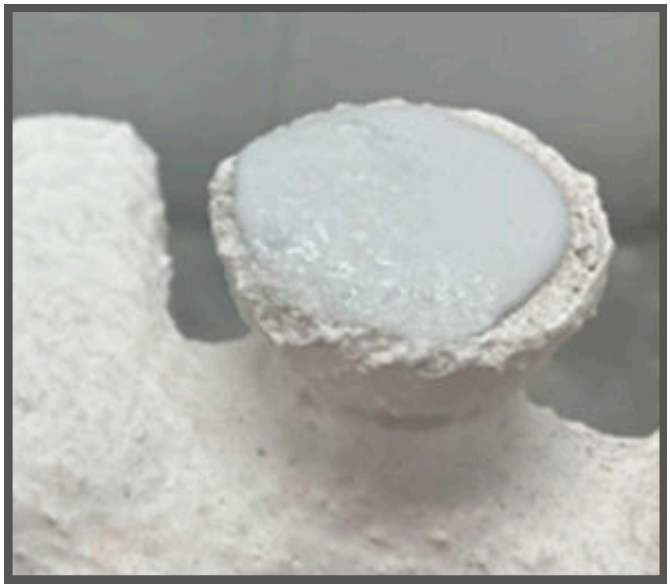
CCS CRACKATTACK® MAX

Product Description

An Enhanced High Temp Mold Repair Cement for use in Investment Casting Foundries and Forge Linings where EXTREME Temperature and Reactivity Resistance is Required. This dry powder binder refractory system that has >95% Alumina content. It comes with an engineered colloidal silica binder liquid system matched to the dry blend for optimized performance, strength and bonding to most types of refractories, especially investment casting shells.

Typical Applications

- Repairing mold cracks
- Gluing in vent plugs
- Plugging vent holes
- Filling down-feeds to prevent loss of metal
- Molding of non-reactive shapes that come in contact with molten alloy
- A good choice for rapid repair of furnace and forge linings



Advantages

- Rapid set-up time dramatically reducing ceramic production floor WIP
- High strength repair bonding
- Outstanding chemical resistance to the penetration of acid, neutral, and basic slags
- Extremely high temperature stability
- Applied successfully in all forms of investment casting (directional solidification, single crystal and equiaxed shells)
- Has successfully re-attached broken sections of shell allowing to salvage the casting

Directions For Use

- Prepare surfaces to be mended:
  - Clean all dust and debris from affected surfaces.
  - Prewet the surfaces with deionized water
- Mix CCS CrackAttack™ MAX powder with CCS CrackAttack™ Binder at a ratio of 4 or 5 to 1.
- Mix vigorously and thoroughly and apply quickly to the affected surfaces.
- Initial set will take place within 5 to 10 minutes.
- Best results result if the repaired mold sits for one hour prior to introduction into a preheat oven
- Repaired mold can be introduced into preheat ovens at temperatures up to and including 2200 °F

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(888) 873-1066
surfaceprep.com

For more information scan to visit our website

Testing Results: Trace Element Analysis

This material is free from any crystalline silica. Test results for typical aerospace trace elements are reflected on the trace element tables presented here.

CCS CrackAtttack® MAX

Element	Typical (ppm)
Lead (Pb)	<25
Bismuth (Bi)	<1
Silver (Ag)	<10
Antimony (Sb)	<25
Zinc (Zn)	<50
Tin (Sn)	<25
Iron (Fe)	<500
Arsenic (As)	<10
Selenium (Se)	<10

CCS CrackAtttack® Binder

Element	Typical (ppm)
Lead (Pb)	<25
Bismuth (Bi)	<1
Silver (Ag)	<10
Antimony (Sb)	<5
Zinc (Zn)	<50
Tin (Sn)	<25
Iron (Fe)	<100
Arsenic (As)	<1
Selenium (Se)	<1