



Hot melt adhesive for sand cores and foundry systems



foundrytec[®] core adhesives

Formulations specially developed especially for use in foundries

Foundrytec[®] hot melt adhesive can be used in sandcore, lost foam and lost wax foundries for mould and core assembly. Once assembled, cores and moulds can be moved, dipped and dried immediately, saving time and storage space.

Application is fast and accurate using tec industrial glue guns that ensure the correct amount of adhesive is applied at the right temperature. Foundrytec[®] hot melt can be used as an instant clamp in conjunction with water based and other slower curing adhesives. It is also available in granular form that has class-leading viscosity stability, for consistent results and reduced downtime in lost foam tank applications.

Benefits

Foundrytec[®] hot melts offer a range of advantages over other sealing methods:

- **Increased production and high speed of set:** foundrytec[®] hot melt adhesives offer fast (almost instant) setting speeds, helping to increase productivity
- **Improved accuracy:** foundrytec[®] hot melts offer very fast setting speeds, therefore reducing the risk of core movement
- **Risk of gassing is reduced:** foundrytec[®] adhesives offer low ash and low outgassing to protect the integrity of the core
- **No solvent:** foundrytec[®] adhesives contain no harmful chemicals or air-borne particles, negating the need for any PPE (personal protective equipment)
- **Unlimited shelf life:** the adhesives are clean to handle and can be stored for long periods without risk of expiry
- **Cost effective:** foundrytec[®] adhesives can be used sparingly to achieve a strong bond, in less time when compared to other bonding methods
- **Reduced downtime:** once the tool heats up there's no downtime waiting for the adhesive to melt - the glue will melt on demand as the trigger is pulled
- **Reduced storage:** with instant bonding, core assemblies can be moved immediately - reducing storage space



Top tips

- Slightly larger recesses in tooling helps accommodate the hot melt adhesive
- Use one hot melt to position breathers, vents and cores instantly
- Reducing drying oven temperatures allows more economical hot melts to be used
- Using foundrytec[®] lost foam adhesives in bulk tanks reduces charring and viscosity build up. It also results in less down time and tank cleaning

Foundrytec[®] adhesives

We offer a range of foundrytec[®] hot melts suitable for most foundry systems, enabling foundries to speed up all aspects of core production.

Foundrytec[®] hot melt 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 hot melt application.



Internal sand core shape, and finished pump casting



Sand cores showing recesses required for hot melt



Assembly of sand cores for cylinder blocks



Can be oven dried immediately



Typical cylinder head sand core assembly



Cylinder head sand core construction

! Foundrytec[®] hot melts do not affect sand reclamation.

Reference	Description	43mm (1 3/4")	15mm (1 1/8")
FOUNDRY-TEC-104	Long open time	■	-
FOUNDRY-TEC-301	General purpose – good on ceramics. Very low ash content	■	-
FOUNDRY-TEC-501	Low viscosity	■	-
FOUNDRY-TEC-601	Fast setting	■	-
FOUNDRY-TEC-701	High temperature resistance	■	■
FOUNDRY-TEC-705	Higher temperature resistance	■	■
FOUNDRY-TEC 5012LF-BK	Lost foam tank bulk adhesive	■	■

Tec™ glue guns

These advanced industrial bead glue guns can dispense foundrytec® hot melt glue at high output rates. Tec guns melt the adhesive on demand: as much as needed, when it's needed, with no downtime waiting for the glue to melt. Once the tool has heated up fully, you can work uninterrupted.

Optional nozzles available



tec 820-15

Adjustable temperature, heavy duty medium size 12mm (1/2") glue gun. Robust and easy to use, fast recovery, medium output, 2 minute warm up time & illuminated on/off switch.

Melt rate	2.5kg (5.5lbs)/hr
Glue size	15mm (5/8") glue stick
Voltage	120V and 230V
Wattage	300W
Heater	Cartridge
Temp Control	User adjustable thermostat
Hotmelt gun °C (°F)	Adjustable 130-200°C (265-390°F)
Lowmelt gun °C (°F)	Covered above
Power cable	3m (10 ft)
Weight	500g (18oz)
Packaging	Plain box (10 per ctn)

Air assisted piston



tec 6100

High output pneumatically assisted extrusion glue gun for industrial use. Air assisted output reduces operator fatigue. Power-on indicator light, requires air and electric supply. Maximum 7 bar (100psi), for best results set to 4-6 bar (60-90psi) dependent on output requirements.

Melt rate	4.1kg (9lbs)/hr
Glue size	43mm (1 3/4") 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)
Lowmelt gun °C (°F)	130°C (265°F)
Power cable	3m (10 ft)
Weight	1.4kg (3lbs)
Packaging	Plain box (5 per ctn)

Optional plug-in modules



tec 3400

High output, electronically controlled 43mm (1 3/4") glue gun made to withstand industrial environments. A powerful tool featuring patented ECOTEC® technology for exceptional temperature precision and eco-friendly standby operation.

Melt rate	3.8kg (8 1/2lbs+)/hr
Glue size	43mm (1 3/4") 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), 180°C (350°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 (2 1/2lbs)
Packaging	Plain box (5 per ctn)



Speedloader increases productivity



Speedloader
reduces downtime



tec 7100

Very high output pneumatically assisted extrusion glue gun for industrial use. Air assisted output reduces operator fatigue. Power on indicator and speed load design helps save time reloading. Requires air and electric supply. Maximum 7 bar (100psi), for best results set to 4-6 bar (60-90psi) dependent on output requirements.

Melt rate	5.0 kg (11lbs)/hr
Glue size	43mm (1 3/4") 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)

● The tec 6000 & 7000 series guns are also available fitted with 6m or 12m long extended leads - see back page for details.

Accessories

Nozzles



ADJ013

ANZ016

ADJ025

ADJ023

Standard fitted nozzles are shown in green.

Reference	Description	tec 820	tec 3400	tec 6100	tec 7100
ANZ016	2mm (0.080") orifice	■	■	■	■
ADJ013	3mm (0.120") orifice, 30mm (1¼") extension	-	■	■	■
ADJ025	2mm (0.080") orifice	■	-	-	-
ADJ023	3.5mm (0.138") orifice	-	■	■	■

Extension Variants



Extension lead sets are available in 6m (20ft) and 12m (40ft) lengths for use with special 'EX' versions of tec 6100, tec 7100 & tec 7200 tools.

Reference	Description	tec 820	tec 3400	tec 6100	tec 7100
ADD040-6M	6m (20ft) extension lead	-	-	■	■
ADD040-12M	12m (40ft) extension lead	-	-	■	■

Gun Stands



MDC009



Reference	Description	tec 820	tec 3400	tec 6100	tec 7100
MDC009	For 600 & most 800 series tools (can be wall mounted)	■	-	-	-
PA3096-SPARES	For heavy duty tools, 3000, 6000 & 7000 series (can be wall mounted)	-	■	■	■

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 820	tec 3400	tec 6100	tec 7100
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)	-	-	■	■

If you have any questions, or need any additional information about the foundrytec® system, just contact us using the details at the bottom of the page.



Europe's leading shaped hot melt adhesive specialist. Offering the largest range of performance adhesives and hand-held applicators.



40+ years' experience, offering specialist knowledge on all aspects of commercial gluing operations.



Advanced technology at our UK facility and a continuous programme of research and development ensures that we continue to meet the ever changing needs of industry.



Our adhesives are often formulated using raw materials harvested from sustainable managed forests. Our packaging is recyclable, and where possible, made from recycled materials.



Over 90% of our products are made in Britain, and we offer 12 months' warranty as standard on all equipment.