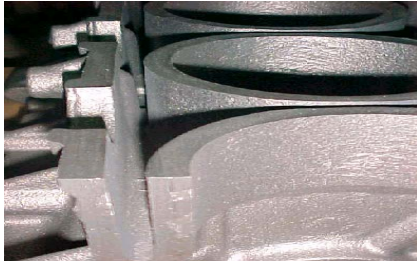
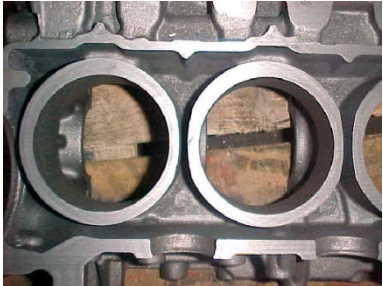
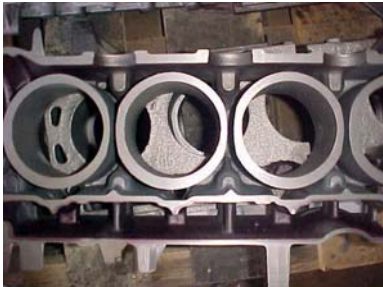




RESULTS
RECLAIMED SAND TESTS @ GREGG INDUSTRIES.

CHRYSLER MONOBLOCK

MIX	WATER JACKET			CYLINDERS		FINAL INSPECTION
SAND % RESIN PI % RESIN PII	40 % SAND 45/50 40% SAND 50/55 0.85% 0.75% 20% CHROMITE	100 % SAND RECLAIMED 0.85 % 0.75% W/O CHROMITE (A)	100% SAND RECUPERADA 0.75 % 0.65 % W/O CHROMITE (B)	100% SAND 45/50 0.75 % 0.65 % (B)	100 % SAND RECLAIMED 0.75 % 0.65% (A)	(A) 
IMMEDIATE TEST RESULTS (PSI)	331	305	261	226	261	
TEST AFTER 1 HR. (PSI)	417	399	320	315	334	(B) 
BENCH LIFE (PSI)	263	225	187	156	210	
HARDNESS (+GF+)	N/A	22	28	32	33	
REDUCTION BENCH LIFE IN 2 HRS.	21 %	26 %	28 %	31 %	20 %	

MIX	CATERPILLAR MONOBLOCK WATER JACKET.		FINAL INSPECTION
SAND % RESIN PI % RESIN PII	50 % SAND 45/50 1.1% 1.0 % 50% CHROMITE SAND	100% RECLAIMED SAND 1.1 % 1.0% W/O CHROMITE	
IMMEDIATE TEST (PSI)	443	385	
TEST AFTER 1 HR. (PSI)	496	417	
BENCH LIFE (PSI)	392	304	
HARDNESS (+GF+)	N/A	15	
REDUCTION BENCH LIFE IN 2 HRS.	12%	21 %	

APEX HEAD		
MIX	Intake and Exhaust Port	
SAND % RESIN PI % RESIN PII	50 % SAND 45/50 50% SAND 50/55 0.90 % 0.80 % 3.0 BLACK IRON OXIDE	100 % RECLAIMED SAND 0.90 % 0.80 %
IMMEDIATE TEST (PSI)	320	324
TEST AFTER 1 HR. (PSI)	371	424
BENCH LIFE (PSI)	205	249
HARDNESS (+GF+)	27	20
REDUCTION IN BENCH LIFE IN 2 HRS.	36 %	23 %

CONCLUSIONS:

Analysis of the Reclaimed sand:

- Particle Size: A.F.S. 51.05, FINES 0.51 %; OK.
- Oolitics: 2 % maximum; OK.
- A.D.V. : 5 – 9 ml. Ph 2; OK.
- PH: 7.71 – 8.41; OK.
- % LOI: 0.02; OK.
- % Moisture: 0.01; OK.
- Mix: OK.

Tests were done on the following parts:

Chrysler Monoblock. Water Jacket / cylinders.

For this case, proceeded to a test with 12.5% resin. Found satisfactory results. Casting was viewed inside and outside, there were clean walls, without inclusions, there was no deformation of the water jacket.

Caterpillar Monoblock. Water jacket.

Sintering was found in the jacket, no deformation in any of the pieces.

Apex Head. Intake and Exhaust ports.

The pieces did not show any defect.

The results obtained in inside/outside: according to spec.

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