



FOUNDRY Cobra

Plaster casting for tyre moulds

COBRA™ is a specialist plaster designed for the casting of aluminium moulds for tyre manufacturing.

COBRA™ offers the following benefits to the tyre foundries:



- COBRA™ contains only the purist closely graded raw materials to give utmost consistency in addition to high green and fired strengths.
- COBRA™ mixes easily to give a creamy consistency with minimal air entrapment. The product can be adjusted to suit individual customer requirements
- COBRA™ is designed to be used without a flask
- COBRA™ gives an excellent surface finish with high definition and close dimensional accuracy.
- COBRA™ is highly resistant to surface breakdown reducing fettling costs after casting. It can be used for different tyre qualities as well as castings for remoulds.
- COBRA™ can be packed in either 25kg bags or bulk bags up to 1500kg.

Complete quality control tests on setting times, flow and dimensional accuracy ensure trouble free production from batch to batch. A full Certificate of Conformity is supplied with every delivery.

Technical Information - COBRA™

Powder/water ratio	45%
Work time @ 22°C	10 minutes
Initial set time	13 minutes
Thermal expansion @ 750°C	0.1%
Setting expansion € 2 hours	0.38%





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MIXING INSTRUCTIONS

1. Accurately weigh out the correct proportions of powder and water. COBRA™ is mixed at 100 parts powder to 45 parts of water.
2. Mix for 3 minutes
3. Vacuum the slurry until it rises and falls to remove the air. 4. Pour around the rubber patterns using vibration if possible to remove all the entrapped air.
5. The moulds can be stripped after 30 minutes.

DRYING CYCLE

Place the moulds into a cold oven and increase the temperature to 150°C in 2 hours. Hold the temperature at 150°C for 2 hours and then increase to 300°C and hold for 5 hours. Reduce over 1 hour to 260°C and cast the metal.

