



PRODUCT DATA SHEET

PDS: 1-16

Current: June: 1995

Supersedes: August: 1994

### PMB 456

PMB 456 is a water extendable economy graphite/coke blacking designed for grey and ductile iron castings. It has been formulated to disperse readily in water and stay suspended with a minimum of agitation. It gives excellent finishes on light castings and is an effective coating for use on bail cores made from coated sands. As a trough wash it gives long trough life with easy removal of residual metal between pours.

**PREPARATION:** For general purpose core and mold coatings we recommend a master mix made by mixing equal quantities of water as a starting point. Generally where protection against severe thermal and erosive action is required a suspension with a Baume of around 45 is recommended. For heavier sections two coats may be needed.

**APPLICATION:** PMB 456 can be sprayed, brushed or swabbed. Coatings can be torch dried, baked or air dried to produce a uniform, semi-hard coating.

For spraying we recommend two light coats of about 35-45 Baume.

For brushing or swabbing a 45-60 Baume is recommended.

For use as a trough wash a light suspension with a Baume of 15 is recommended. The additional water serves to provide some cooling that is effective in prolonging trough life.

**CAUTION:** Always add powder to water while water is under agitation.

**PACKAGING** Standard 50 pound bags – 50/pallet.  
Fiber drums available on request with upcharge.

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PMB Blacking

# MATERIAL SAFETY DATA SHEET

**ASBURY GRAPHITE OF CALIFORNIA**  
 2855 Franklin Canyon Road  
 Rodeo, CA 94572  
 PHONE: 510-799-3636

**EMERGENCY TELEPHONE**  
**800-424-9300 CHEMTREC**  
 Revised 4/15/98....MSDS #21

## PRODUCT IDENTIFICATION

Chemical Family: Blend of graphite, pet. coke, clays, and an organic binder

Trade Name: Blackcoat 402, Blackcoat 426, Blackcoat 455 (455B),  
 PMB 456, Star Blacking 457, Tool Saver 458,  
 Blackcoat 475 & 476, Anode Stub Coating 477, Mold Wash

## CONSTITUENTS

% of Mix	Name	CAS #	Niosh	OSHA Pcl	ACGIH th
15-30	Flake Graphite	7782-42-5	2.5	2.5	2.5
50-70	Amorphous Graphite	7782-42-5	2.5	2.5	2.5
2-10	Clay	1332-58-57		15 <sup>1</sup> /5 <sup>**</sup>	10
> 1	Silica	14808-60-7	0.05 <sup>1</sup>	0.1 <sup>1</sup>	0.1
0-10	Talc	14807-96-6	2.0	2.0	2.0
1-10	Dextrin	9004-53-9			

values expressed in mg/m<sup>3</sup>

<sup>\*</sup> Total Dust

<sup>1</sup> Respirable dust

<sup>\*\*</sup> Respirable fraction

## PHYSICAL CHARACTERISTICS

Freezing point: N/D

Vapor Pressure: N/A

Melting point: N/A

Vapor Density: N/A

Boiling point: N/A

Density (g/cc): 2.679

Sublimes: N/A

H<sub>2</sub>O Solubility: 5 %

Evaporation: N/A

% Volatiles: 5 %

Appearance and odor: black to gray powder.....No odor.

## EXPLOSION AND REACTIVITY DATA

Flash Point: none

Flammable (explosive) Limits: V/V%

LEL: none

UEL: none

**Extinguishing Media:** This material is non-combustible. Use extinguishing media suitable for the surrounding fire.

**Special Firefighting Procedures:** If this material is involved in a fire-fighting situation, CO and CO<sub>2</sub> may be generated by the incomplete combustion of the graphite. A full-face, air-supplied, positive pressure, respiratory device is recommended to prevent possible exposure to carbon monoxide.

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**EXPLOSION AND REACTIVITY DATA (continued)**

**Unusual Fire or Explosion Hazards:** No unusual explosion hazards known.

**General Reactivity Information:** The product is a stable material

**Incompatibility:** Contact with strong oxidizers should be avoided.

**HEALTH HAZARD INFORMATION/EMERGENCY PROCEDURES**

One of the constituents of clay is Crystalline silica as quartz. **This material is listed as a carcinogen by IARC-2A and NIOSH-X.** It has not been determined at what level the crystalline silica as quartz resides in this product.

Dust in high concentrations may be irritating to eyes. **Flush with water and avoid prolonged or repeated contact. Consult a physician if irritation persists.**

Prolonged breathing of dust may cause cancer, pulmonary fibrosis, emphysema, corpulmonal as

**Skin:** Prolonged contact may cause irritation.

**Eyes:** Contact may cause irritation and/or abrasion.

**Ingestion:** Product is not normally ingested.

**Inhalation:** This product is normally present as dust. Use an approved respirator when dust concentrations exceed 0.10 mg/m<sup>3</sup>.

Local exhaust is recommended to keep dust to acceptable level.

**Carcinogenic References:** This product may contain chrystalline silica. Chrystalline silicas has been listed as a suspected human carcinogen.

NTP: Yes IARC: Yes OSHA Reg. No

**ENVIRONMENTAL PROTECTION INFORMATION**

State or federal regulations may require specific labeling, packaging, storage, transportation and disposal procedures.

**SPECIAL PRECAUTIONS**

Always wash thoroughly prior to eating or smoking.

This product must be handled accordingly to the size, shape and quantity of material involved. Drums may require use of hoists, cranes etc. **Store this material in a cool dry area. Keep away from contact with food or feed products.**

**DOT SHIPPING INFORMATION**

This material is not regulated by the DOT for land transportation.

The following is the most accurate description of the material for shipping purposes:

**"FOUNDRY COATING POWDER"**

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