KES

Phenolresin for Coated Sand

KES R – C001B

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Additional Rule

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1. Scope of Application

This standard determines the import inspection for phenolresin for coated send (No block type).

2. Inspection Items and Inspection Method

The inspection items and inspection method are as table 1.

Table 1

Inspection items	Inspection method	Remarks
Weight	Coefficient adjustment type 1 time sampling inspection	Special inspection S-2, AQL : 1.0
External appearance	〃	〃
Liquidity	Checking inspection	
Hardening time	〃	
Water content	〃	
Hygroscopicity rate	〃	
Soffing point	〃	

3. Inspection Lot

Consider the all products of one time delivery as the inspection lot 1.

4. Method of Sample Picking

(1) Weight and External Appearance

You shall sample according to KS A 3151 (Random sampling method) from inspection lot 1.

(2) Liquidity, Hardening Time, Water Content, Hygroscopicity Rate, and Soffing Point

Sample 10% of sack from inspection lot 1 according to KS A 3151 (Random sampling method) and mix those well after picking up equally separated 200g of total sampling amount from each sack.

But, the sampled sacks shall be more than 2.

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5. Test and Inspection

5.1 Weight

You shall measure using 0 ~ 50 kg weighing instrument.

5.2 External Appearance

The inspection shall be done by eyes.

5.3 Liquidity

5.3.1 Instruments

(1) Balance : Range 100 ~ 200 g, scale 1mg

(2) Forming, Molding and Formingmachinery : It shall be able to form diameter 10 ± 0.1 mm, height 13 ± 0.5 mm test piece.

(3) Constant temperature chamber : Constant temperature and humidity chamber that has a equipment to maintain the plate glass of (4) with slope 30° ± 1° against the horizon.

(4) Plate Glass : size 200 × 200 × 3 mm polished standard glass shall not have a defect on its surface.

(5) Thermometer

5.3.2 Operation

The one that you shall insert 1.0 ± 0.05 g of a dry sample and give a steady pressure until its height becomes 13 ± 0.5 mm shall be the test piece.

And then, heat steadily the plate glass in the 125 °C ± 1 °C pot and put the above sample on the edge of the glass. About 3 minutes later incline 30° by lifting up softly the edge that attaches the sample.

Here, the resin shall be softened and flow and finally hardened.

The length that flows and becomes hardened from the original point is liquidity.

5.4 Hardening Time [Gelatinized time]

5.4.1 Instruments

(1) Steel Plate : The plate that can maintain 150 ± 1 °C of the surface temperature during this test, and is more than 100 × 100 × 10 mm big.

(2) Big Stainless Scoop

Size of 20 mm wide 1 mm thick.

(3) Thermometer

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