



## Modern Mold Sealing: Foundries Move Beyond Cope-Rope with REFCOSTIX 3400

**Product:** REFCOSTIX 3400 Mold-Seal | **Application:** Gray & Ductile Iron Foundry (no-bake molding)

### Customer Overview

Data used for this study comes from two large U.S. iron foundries producing complex gray and ductile iron castings in flask and flask-less molds. The foundries previously relied on traditional cope-rope for sealing parting lines.

### Challenge: Inefficiency and Scrap from Cope-Rope

- **Excessive flashing:** Cope-rope often failed to compress evenly, causing parting-line flash.
- **Runouts & leaks:** Older tooling and thin mold sections led to frequent runouts.
- **Labor burden:** Twisting and cutting rope around sprues increased cycle time and ergonomic strain.
- **Cost impact:** Higher scrap, rework, and extended cleaning increased operating costs.

### Solution: REFCOSTIX 3400 Mold-Seal

#### Implementation Highlights

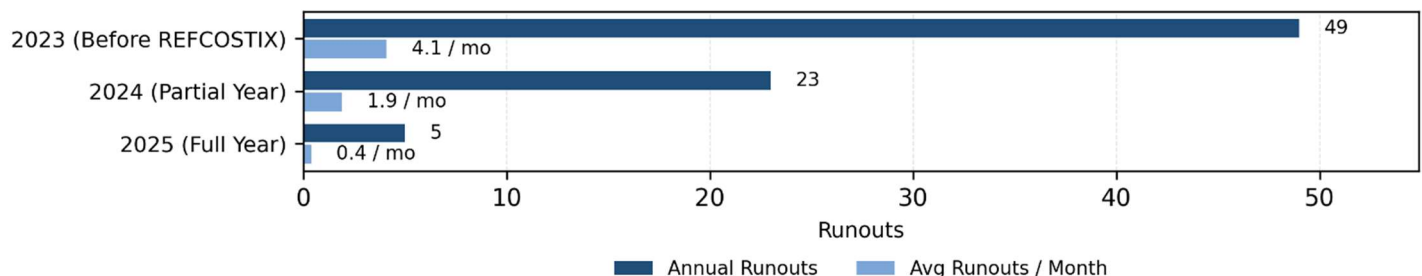
- Liquid/pumpable seal applied with battery-powered caulk guns
- Drum-to-cartridge refill station with pressure plate
- Standard 1/2" - 3/4" bead nozzle (1/2" effective for most molds)

*This eliminated manual rope handling, improved uniformity, and simplified operator workflow.*

### Measured Results

Following implementation, both monthly and annualized runout events declined sharply and remained low.

#### Runout Reduction Over Time



### Additional Performance Gains

- **50 % reduction** in overall **flashing** (thickness and area)
- **30 % reduction** in overall **cleaning / finishing times**
- Runout molds cut by > 80% within first 12 months of use

### Economic & Operational Impact

- **Reduced scrap & rework** from cleaner parting lines
- **Faster throughput** due to less flashing
- **Improved operator efficiency** – no rope twisting or cutting

### Conclusion

REFCOSTIX 3400 has proven to be a superior alternative to traditional cope-rope, delivering measurable performance improvements, labor savings, and significant financial return. Modern mold sealing isn't just cleaner — it's smarter.

*Seal Smarter. Cast Cleaner.*