SurfacePrep

Technical Data Sheet

CCS CRACKATTACK® NOSIL

Product Description

An enhanced high temp mold repair cement for use in investment casting foundries where extreme temperature and reactivity resistance is required. This pre-mixed refractory paste has >98% Alumina content, thus the name, NoSil...contains no silica. It comes as an engineered liquid ceramic system comprised of typical shell materials for optimized performance, strength and bonding to investment casting shells.

Typical Applications

- Repairing mold cracks
- Gluing in vent plugs
- Plugging vent holes
- Core fill



Advantages

- Workable no-settling paste
- High strength repair bonding
- Outstanding chemical resistance to the penetration of acid, neutral, and basic slags
- Extremely high temperature stability
- Applied successfully in all forms of investment casting (directional solidification, single crystal and equiaxed shells)
- Sold in two gallon pails

Directions For Use

- Prepare surfaces to be mended:
  - Clean all dust and debris from affected surfaces.
  - Prewet the surfaces with deionized water.
- Mix vigorously and thoroughly to ensure uniformity of paste.
- Apply a ¼ inch thick layer of CCS CrackAttack® NoSil to shell surface.
- Initial soft-set will take place within 30 - 60 minutes.
- A hard set will take place within 5 to 12 hours.
- Best results are experienced if the repaired mold sits for one hour prior to introduction into a preheat oven.
- Repaired mold can be introduced into preheat ovens at temperatures up to and including 2200°F
- CCS CrackAttack® NoSil will maintain its strength throughout the casting process even up to DS/SC temperatures

(888) 873-1066
surfaceprep.com

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Testing Results: Trace Element Analysis

This material is free from any crystalline silica. Test results for typical aerospace trace elements are reflected on the trace element tables presented here.

CCS CrackAtttack® NoSil

Element	Typical (ppm)
Lead (Pb)	<25
Bismuth (Bi)	<1
Silver (Ag)	<10
Antimony (Sb)	<5
Zinc (Zn)	<50
Tin (Sn)	<25
Iron (Fe)	<500
Arsenic (As)	<1
Selenium (Se)	<1

CCS CrackAtttack® Binder

Element	Typical (ppm)
Lead (Pb)	<25
Bismuth (Bi)	<1
Silver (Ag)	<10
Antimony (Sb)	<5
Zinc (Zn)	<50
Tin (Sn)	<25
Iron (Fe)	<100
Arsenic (As)	<1
Selenium (Se)	<1

