



ANH Refractories Europe Ltd

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Mixing & Using Instructions

ON-LINE 70 G

General

Material should be stored in a dry place. For best results, material should be maintained at 10 - 21°C prior to gunning.

This product is designed to be gun applied using standard dry gunnite equipment. All equipment used to mix and gun this product must be clean.

Predamping is recommended to achieve optimum properties and reduce dust.

Installation

As this product has a low cement bonding system and therefore a lower water content, minor adaptations to normal gunning practice are recommended.

Superior installation characteristics and optimum product performance will be achieved by using an extended nozzle arrangement, a 900 mm extension between the mixing chamber and the nozzle tip is recommended. Twisting or bending this extension during the gunning process will enable better mixing (rather than a straight line from the mixing chamber to nozzle tip).

Care must be taken to ensure there is sufficient volume of air available to gun this product. The material should be gunned with slightly higher air pressure than conventional gunning grades to ensure maximum compaction and improved properties. In some applications higher rebound figures can result and this should be taken into account when estimating quantities.

All equipment used must be clean. The material may be predamped if required. Water added at the nozzle should be clean and suitable for drinking. For best results, water should be maintained at 10 - 21°C.

For more information regarding suitable equipment, please contact our Engineering department.

Place material promptly. Do not trowel to slick finish. At temperatures above 20°C, air cure, keeping surfaces damp and/or covered, for at least 4 hours typically or until a hard set developed. Lower temperatures will increase the time before a hard set develops. Keep material from freezing during air cure and preferably until a dryout can be initiated. Freezing this product prior to water removal can cause structural damage.

Dryout maybe started immediately after material has set.



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Dryout Schedule

Heating and cooling refractory structures can be a complex procedure and where possible should be delegated to experts. Where this is done by the client they are themselves contractually responsible, and the following is given in good faith for guidance only.

Ambient to operating temperature 56°C / hour

Never enclose a castable in a vapour-tight encasement as a dangerous steam explosion may result.

For thicknesses greater than 230mm or for multi-component linings contact Harbison-Walker Refractories Ltd for further advice.

Please note, the position of the control thermocouples for the heating and holding phase is important and can be critical. Advice can be given in good faith on request.

