



MT. SAVAGE SPECIALTY REFRATORIES COMPANY

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INSULATING REFRACTORY CASTABLES GENERAL RECOMMENDATIONS FOR CASTING

STORAGE

The material must be kept dry. Avoid storage in excessively humid areas. Shelf life for cement bonded refractory castables is 12 months under proper conditions. Castables should be stored at a temperature between 40°F and 90°F.

ANCHORS

Metallic or ceramic refractory anchors are required for walls and arches. There are many configurations and materials available. Consult Mt. Savage for specific recommendations.

FORMS

All formwork that will come in contact with castable should be thoroughly coated with form oil, grease, plastic or tarpaper to prevent water absorption and sticking. Leave forms in place for 24 hours after completion of casting. Remember to support forms as necessary to allow for the head pressure of the cast material.

TEMPERATURE

Air, water, forms and material must be between 40°F and 90°F. The completed lining must be kept above 40°F for a minimum of 24 hours after casting.

MIXING

Mix in a clean mixer using only clean cool drinking quality water. Use the amount of water recommended on the product data sheet. Significant deviation from the recommended water may result in changes in strength and density. Mix for 1 or 2 minutes after the addition of the water or as long as required to obtain a uniform mix. Avoid contamination from old castable or other foreign materials.

INSTALLATION

Insulating castables should be mixed to a wet ball in hand consistency. Vibration is not normally recommended and if used could result in excessive densification of the castable which will reduce the insulating value and may result in material shortages. Use conventional placement practices and avoid compaction.

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GENERAL RECOMMENDATIONS FOR CASTING

(continued)

GUN APPLICATION

Most insulating castables can be applied by gunning. Rebound losses and density control can be improved by using a gun mix formulation that carries the designation "GM" or "Gun Mix" after the brand name. Caution: Gun mixes should not be used for cast applications. All mixes should be pre-dampened before gunning to prevent dusting and to help material flow. Pre-dampening water ranges from 6 to 25 percent by weight for insulating castables.

CURING AND HEAT-UP

Keep the installed castable damp for 24 hours to permit the binder to set. This can be accomplished by covering with plastic, fine water spray or application of a curing compound. Avoid direct flame impingement on the castable and heat slowly to avoid steam spalling.

NOTE: Consult Mt. Savage Specialty Refractories for specific recommendations for your installation.