Deflocculation-Recommendation
Creaton Body No. 245

100 % dry powder
36 % Water
0,13-0,16 % Deflocculant Dolaflux SP neu
0,13-0,16 % Deflocculant Gießfix 162

the % given are based on 100 % dry powder

1810 g Literweight
3-4 mm Formation rate of the wall in 30 min

dry powder	**1kg**	**5 kg**	**100 kg**	**500 kg**
water	0,36 kg	1,8 kg	36 kg	180 kg
Deflocculant Dolaflux SP neu	1,3 g	6,5 g	130 g	650 g
Deflocculant Gießfix 162	1,3 g	6,5 g	130 g	650 g

Fill the given amount of water in a suitable container. Weigh exactly the deflocculants needed and give them into the water. Stire well until the deflocculants are dissolved.

Now add carefully dry powder while stiring the slip. It is to stire about ½ h intensively. Continue stiring slowly in order to allow all necessary reactions between the body, the water and the deflocculants taking place and to cause the airbubbles coming out.

Adjustment of the slip:
First of all to be sure that the slip is ready for casting, measure the literweight. Is the weight higher than given above, adjust it by carefully adding water. Is the value too low, add further dry material (as it is very difficult to add futher dry material to a slip, please avoid having a too low weight. It is far easier to correct a too high weight by adding water).

Is the literweight well adjusted and the slip seems being fluid enough, cast a small item. Within 30 minutes a wall-thickness of **3-4 mm** should be obtained.

If the wall is thicker, the slip isn´t fluid enough. In order to adjust it to the optimal point, more deflocculant should be added in small quantities. Start with the addition of 0,01 % of each deflocculant, these are **0,1 g on 1 kg** dry material. Stire the slip for further 10 to 15 minutes. Cast again a sample and measure the wall thickness. If the thickness is as desired the slip can be used. If the result is not satisfying, add again 0,01 % of both deflocculants and go on as discribed above.

Beside other influences which can be neglected, the deflocculation depends very much on the temperature and on the kind of water used. That´s the reason the above given deflocculation instruction is to be seen as an approach and it isn ´t obligatory.

Pay attention: Please weigh the deflocculant exactly. We added some more deflocculant.