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**Keramikos
Mr Boonstra**



Technical data sheet

Raw material no. **600 (s)/G 12 (l)** Firing temperature: **1000-1150°C**

Name: **Steinzeug-Gießmasse schwarz**

	1000°C	1100°C	1200°C	1300°C
Firing shrinkage:	2,9 %	8,3 %		
Total shrinkage	6,0 %	11,3 %		
Water absorption:	15,5 %	3,7 %		

Firing colour: brown brown-black

Coefficient of thermal expansion at different firing temperatures in 10⁻⁶ m/(m x K)

	1000°C	1100°C	1200°C	1300°C
WAK _{20-400°C} :	6,1	8,6		
WAK _{20-500°C} :	6,6	9,2		
WAK _{20-600°C} :	8,2	11,1		

Chemical analysis (calcined)

SiO ₂	72,3 %
Al ₂ O ₃	16,5 %
TiO ₂	1,0 %
Fe ₂ O ₃	4,9 %
CaO	0,2 %
MgO	0,4 %
Na ₂ O	0,2 %
K ₂ O	2,9 %
GV	(4,2 %)

Dry shrinkage:	3,3 %	Viscosity (acc. to Lehmann) (s):	28
		Thixotropy (acc. to Lehmann) (s):	6
Modulus of rupture:	1,1 N/mm ²	Thickness of body after 15 min (mm):	5,3 after 45 min: 5,3
		Demoulding time after 15 min (min):	45 90
Need of water:	50,5 %	Litre weight (g):	1780

GROUND POWDER no. 600: 100 % Casting slip powder are stirred in ca. 38 % water that contains 0.1 % Dolaflux SP 11 and 0.2 % Gießfix 162. After homogenisation the body should stay for 2-3 h. In this time you could stir slowly. Impurities must sieved out.

LIQUID SLURRY no. G 12: The Slurry must be stirred before casting without stirring air bubbles inside. If the viscosity is too high you could add some deflocculant, e. g. LIQUI-FIX of WITGERT.

The body contains deflocculants.

The data are average values. Sale is carried out according to pattern and to our terms and conditions.

Tone und Fertigmassen in allen Naturfarben: geschnitzelt gemahlen gewalzt granuliert
Plastisch flüssig Kaoline Mangantone und -oxide Schamotten Sinterengoben

Fachberatung durch Keramik-Ingenieure
Eigenes Labor

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