

Glazura Ltd.

Bulgaria, Troyan 5600, 109 General Kartsov, phone/fax: +359 670 64016, mobile: +359 888 604108
e-mail: glazura@abv.bg web: www.glazura.bg

Recommendation for deflocculation Body G20-081 (Porcelain)

100 % Dry powder
30 % Water
0.2 % Deflocculant Glazurflux
1850 g/l Litre weight

Dry powder	1kg	5 kg	100 kg	500 kg
Water	0.250 kg	1.250 kg	25 kg	125 kg
Deflocculant Glazurflux	2 g (1.5 ml)	10 g (7.7 ml)	200 g (153 ml)	1000 g (770 ml)

1. Water and deflocculant. Fill the given amount of water into a suitable container. Carefully weigh the deflocculant and add it to the water. Stir the whole until the deflocculant is in solution.

2. Mixing.

For quantities up to 25 kg dry powder.
Add all the dry powdered body to the water. Let it stay for 20-30 minutes. Then stir the casting slip intensively for 10-30 minutes until the slip is homogenous.

For quantities above 25 kg dry powder.
While stirring constantly, add the dry powdered body. Then stir the casting slip intensively for 10-30 minutes until the slip is homogenous.

3. Slow stir. Then stir it slowly for a while so that the necessary reaction between the body, the water and the deflocculant can take place and the air bubbles can emerge.

4. Adjusting the casting slip (not obligatory). To ensure that the body is ready for casting, measure it.

Firstly, the litre weight. If the the litre weight is more than the above-mentioned value, then add more water. If the litre weight is less than the above-mentioned value, then add more dry powder. (As slips don't mix well with powder, you should try to avoid lower litre weights. A higher litre weight is easier to adjust with water.)

5. Test. Cast a test piece. If the cast wall is too thick, then the casting body is not liquefied enough. To adjust this, simply add deflocculant in small quantities. Try 0.01 % deflocculant first, which is 0.1 g for every 1 kg of powder.

Then stir the casting body for 15 to 30 minutes and cast another test piece.

As the deflocculants are dependent on temperatures and the kind of water used, we must stress that the above-mentioned adjustment of casting slips are merely hints and are without obligation.

Pay attention: Please, exactly weigh the deflocculant!

*For measuring smaller quantities, the usage of syringes is recommended!

The required deflocculant can directly be bought from Glazura Ltd.

6. Drying. The drying of the pieces can be done naturally or artificially. In the second case the dryers must be kept under controlled humidity and temperature conditions. It is recommended to carry out a good drying to avoid breakages, both in the critical drying phase of the material and afterwards during firing.