



TECHNISCHE DATASHEET Klei poeder porselein wit/transparant

Technical data sheet

Firing temperature: 1250-1300°C

Name: **Weichporzellan-Gießmasse weiß**

	1000°C	1100°C	1200°C	1300°C
Firing shrinkage:	1,6 %	6,0 %	9,8 %	9,9 %
Total shrinkage	3,3 %	7,7 %	11,4 %	11,5 %
Water absorption:	24,2 %	12,9 %	0,2 %	0,1 %
Firing colour:	white	white	white	white

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

	1000°C	1100°C	1250°C	1300°C
WAK _{20-400°C} :			6,8	6,6
WAK _{20-500°C} :			6,8	6,6
WAK _{20-600°C} :			7,0	6,7

Chemical analysis (calcined)

SiO ₂	63,3 %
Al ₂ O ₃	31,2 %
TiO ₂	0,4 %
Fe ₂ O ₃	0,4 %
CaO	0,3 %
MgO	0,2 %
Na ₂ O	2,8 %
K ₂ O	1,4 %
GV	(7,7 %)

Dry shrinkage:	1,8 %	Viscosity (acc. to Lehmann) (s):	42
Modulus of rupture:	2,2 N/mm ²	Thixotropy (acc. to Lehmann) (s):	5
Need of water:	53,0 %	Thickness of body after 15 min (mm):	4,0 after 45 min: 5,3
		Demoulding time after 15 min (min):	45 90
		Litre weight (g):	1690

POWDER: 100 % Casting slip powder is stirred in ca. 45 % water, which contains ca. 0.05 % Dolafix SP 11 and 0.10 % 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 52: The Slurry must be stirred before casting without stirring air bubbles inside. If the viscosity is too high you could add some deflocculant.

The body contains deflocculants.