



Installation Information

THERMBOND® CASTABLE REFRACTORY

Preparation

1. Thinly coat all forms with a release agent. Steel forms must be painted prior to treating with a release agent. Sulfur free grease can be used as a release agent.
2. Use a paddle or pan type mixer. Check that equipment is clean and in proper working condition.
3. Use high frequency vibration equipment. Check that equipment is clean and in proper working condition.

Mixing

1. Only mix as much material as you can place immediately.
2. Mix dry material and liquid activator together for between 45 seconds and 2 minutes depending on the mixer. The material is mixed properly when it is homogeneous and folds upon itself.
3. Thermbond® castable material must be vibrated into place.

Placing

1. When using pneumatic vibrators, use sufficient air pressure to operate the vibrators at full capacity. With internal vibration beware of the vibrator forming rat holes in the material.
2. When casting Thermbond® onto Thermbond® make sure the surface being cast against is rough (do not trowel smooth).

Curing

No curing is required after setting.

Please contact Stellar Materials LLC for:

- Specific information regarding your application.
- Extreme weather conditions, below 40° F (5° C) or above 90° F (32° C).

For more information please consult our complete [Thermbond Installation Guide](#).

