



Průmyslová keramika, spol. s r.o.
Spešovská 627
CZ 679 02 Rájec-Jestřebí
(++420-516 432 197
++420-516 432 251
Fax ++420-516 432 273
e-mail: prumker@prumker.cz
www.prumker.cz

INSTALLATION OF DRY GUNNING MIXES ŽÁROBET TOR

STORAGE

Dry castable mixes are supplied in moisture-proof bags.

Store in a dry place and on a surface preventing penetration of moisture from the ground (concrete, asphalt).

PREPARATION

- q Use clean tools, any contamination may adversely influence the start of setting and reaching due strength of the castable.
- q Wall surface should be free from any dirt prior to gunning.
- q Use drinking water only.
- q Even speed and incessant feeding of material is essential, as well as continuous supply of water under the same pressure.
- q The most suitable ambient temperature for castable installation is 15-30°C.
- q If the castable is sprayed on old brickwork, this should be prewetted prior to gunning.

We recommend:

PRE-DAMPENING

Use a paddle-type mixer for mixture predampening. By predampening the castable mixture in the mixer for 30 s, you will prevent the mixture from dusting in the nozzle. Amount of water needed for predampening depends on the material used. Overmuch dampening may result in too heavy material and this can cause hose clogging.

In case of need, add a steel fibers and let it mix evenly in the mixture.

Start gunning as soon as possible, any mixing in excess can cause a drop in the castable strength.

GUNNING

- q Any hose or pipe in which the dry mixture is transported should be led straight or in bends with as large radiuses as possible (if possible – no changes in diameter).
- q If the flow of material is continuous, spray from below, making loops (60-90 cm wide, 30-60cm high). Spray gradually; making a base in the brickwork full thickness, this will prevent unwanted accumulation of any rebounded material at the wall foot.
- q Evenly apply layer by layer without interrupting bonding between sprayed castable. If you spray castable on a large surface, make regular expansion joints – in the middle between anchors, through the entire thickness of the brickwork, or spray smaller surfaces approx. 1x0.5m up to the whole brickwork thickness.

- q Keep a regular distance 0.8-1.5 m from the wall the spraying angle should be perpendicular to the wall. Failure to keep the recommended distance and diverting the nozzle angle will worsen quality of the castable compaction and will increase wastage. Select the air pressure in the nozzle depending on the sort of sprayed castable (250-330kPa for high-density castables, 100-170kPa for light-weight castables). Adjust pressure in the nozzle with regard to the distance from the mixer (pressure loss for 15m: 35kPa for dense castables and 25kPa for light-weight castables).
- q Do not gun over rebound.
- q Do not reuse any rebound.
- q Do not entrap rebound in the nozzle stream again.
- q If the brickwork surface is too rough, or excessively dusty, add water.
- q If the surface is sandy and gritty for more than 5s or the material keeps slumping from the wall, reduce water.

DRYING

The brickwork thickness should be treated immediately after gunning. Do not finish the surface too much using a trowel. A smooth surface prevents moisture from escaping from the brickwork during the drying process. The start of drying is as late as 24 hours following castable gunning. During this time keep the brickwork wet. Do not sprinkle surface with water. Material surface must not freeze during this time or be exposed to temperatures in excess of 45°C.