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# **INSTRUCTIONS**

## **FOR PROCESSING REFRACTORY MATERIALS APPLIED BY RAMMING SUPPLIED IN WET CONDITION**

These Instructions are to be followed when using RUDOPLAST fireproof materials applied by ramming that are supplied in wet semi-plastic condition in the consistency allowing direct ramming.

### **Packing and storage**

RUDOPLAST materials for application by ramming are supplied in polyethylene bags on pallets or in PE pails. The materials are to be stored in dry stocks protected against frost and direct sunshine. When observing these conditions, the shelf life in undamaged bags is 6 months from the date of production.

### **Material processing**

Semi-plastic RUDOPLAST materials should be rammed especially intensively using pneumatic rammers in order to achieve a compact and homogenous structure. Ramming should be performed in extra resistant shuttering that is able to withstand the pressure caused by ramming.

Ramming is to be performed continually in layers with the thickness of approximately 50 mm; the next layer should be poured only after perfect compacting of the previous layer.

### **Stripping**

Small and simple shapes may be stripped immediately after ramming. Larger and more complicated shapes have to be heated to at least 80°C in order to achieve their sufficient strength.

### **Drying and the first heating of the rammed shapes**

Good and safe drying and the first heating of the rammed shapes made of RUDOPLAST material is of a great importance for their next functionality. Discharge of water (vapour) that has been used for material mixing and, consequently, chemical and ceramic processes that lead to strengthening of the fire resistant shapes occur during this process. General specification of the rate of the first heating is very difficult as it depends on many circumstances, e.g. on the thickness of the rammed shape, initial humidity of the material, size of free areas, etc. Only approximately, the rate of heating of approximately 20 °C / hour up to reaching the operational temperature of the aggregate can be considered.

If the rammed shape will not be used for a certain time after completing, it is advisable to protect it against moisture by completely covering it with PE foil.