



## Recommendation for deflocculation Body No. 411

100 % Dry powder  
 37 % Water  
 abt. 0.10 % Deflocculant Dolaflox SP 11  
 abt. 0.18% Deflocculant Gießfix 162

Percentages are  
 based on 100% dry powder body

1850 g Litre weight

Clay powder	1kg	5 kg	100 kg	500 kg
Water	0.37 kg	1.75 kg	37 kg	175 kg
Deflocculant Dolaflox SP 11	1 g	5 g	100 g	500 g
Deflocculant Gießfix 162	1.8 g	9 g	180 g	900 g

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

While stirring constantly, add the dry powdered body. Then stir the casting slip intensively for 30 minutes and then slowly for a while so that the necessary reaction between the body, the water and the deflocculant can take place.

Adjusting the casting slip: to ensure that the body is ready for casting, measure it.

Firstly the litre weight. If 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.)

If the litre weight is correct then 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% of every liquefier first, which is **0.1 g for every 1kg** 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 weight the deflocculant.

The required deflocculants can directly be bought at Goeg & Schneider.