



KC608

POLAR WHITE

Casting Powder

Bisque cone 04-03 / Glaze cone 06-05

MIXING INSTRUCTIONS

TOOLS/INGREDIENTS

- 25kg Polar White casting powder
- 20L bucket with lid (clean)
- Mechanical mixer
- 11kg clean water
- Accurate scales
- 70g Sodium Silicate N42 grade*
- 80g to 120g Dispex N40 grade*
- 2 clean plastic cups to weigh the deflocculant

METHOD

1. Accurately measure 11kg of clean water into mixing tank/bucket.
2. Measure out the 70g (50ml) of Sodium Silicate and dilute 1:1 with warm water.
3. Measure Dispex and dilute 1:1 with warm water. We recommend 80g (63ml) of Dispex as a starting point.
4. Turn on mixer and add diluted Sodium Silicate to the water.
5. With the mixer running, gradually add half the clay powder.
6. As slip thickens, add the diluted Dispex and remaining powder a little at a time, so as to keep the slip fluid. You do not have to add all the Dispex if not required.
7. Check the litre weight. It should be 1725g/litre. If it is more than 1725g/litre, add water. If it is less than 1725g/litre add more dry powder. If litre weight is correct and the slip is still thick, adjust by adding the remaining Dispex drop by drop.
8. Mix slip continuously for 2 hours.
9. Age slip for 24 hours.
10. Sieve slip through an 80-mesh sieve. If you wish to produce quality greenware this step is essential.
11. Always thoroughly re-mix the slip before use. If necessary, adjust the fluidity with a little Dispex to obtain the desired pouring consistency.

NOTE ON TARGET WEIGHT: Different studios may use different litre weights ranging from 1700g/litre to 1750g/litre. This depends on personal preference, the size of the moulds, water quality, etc. For instance, small fine moulds may require a lighter litre weight than larger open moulds. We recommend a target litre weight of 1725g/litre.

For density, the desired fluidity and thixotropy are quite personal and will be governed by the work being made.

NOTE: Recycling scrap is not recommended.

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