

Harbison-Walker
Mixing & Using Instructions
KAST-O-LITE 26 LI

----- *GENERAL INSTRUCTIONS* -----

Material should be stored in a dry place. For best results, material should be maintained at 50-70F prior to casting. Under these conditions, the maximum recommended storage life for this product is twelve months.

Porous back-up materials or wood forms should be waterproofed. Absorption of water can result in reduced flow for the product. **Forms must be stout and water tight.**

This product is designed to be mixed with water and then poured/handcast into place. **All equipment used to mix this product must be clean.**

Never mix less than full bags. **Add only clean water suitable for drinking with a pH value between 6.0 and 7.5.** For best results, water should be maintained at 50-70F.

----- *MIXING REQUIREMENTS* -----

Approximate Water For Installation
Pints (Liters)

<u>Bag Size</u>	<u>Poured/Handcast</u>
100 lbs. (45.5 kg)	19.0 (9.0)
55 lbs. (25.0 kg)	10.5 (5.0)
50 lbs. (22.7 kg)	9.5 (4.5)
Wt. % of dry solids	20.0

Mix for at least three minutes. For best results, wet mix temperature should be maintained at 60-75F. Minor adjustments to the amount of water are permissible to achieve desired flow. **Do not exceed 23.0% water under any circumstances.**

----- *INSTALLATION* -----

Place material promptly. Do not trowel to slick finish. At temperatures above 60F, air cure, keeping surfaces damp and/or covered, for 16-24 hours typically or until a hard set has developed. **Lower temperatures will increase the time before a hard set develops.** The best results are achieved at curing temperatures of 90-110F. Keep material from freezing during air cure and preferably until a dryout can be initiated. Freezing of this product prior to water removal can cause structural damage.

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----- *HEAT UP SCHEDULE* -----

Never enclose a castable in a vapor-tight encasement as a dangerous steam explosion may result. Typical dryout schedule for a single layer, 9" (229 mm) thick or less:

ambient to 250F (120C)	100F (55C) per hour
hold at 250F (120C)	1 / 2 hour per inch thickness
250F to 500F (120C to 260C)	100F (55C) per hour
hold at 500F (260C)	1 / 2 hour per inch thickness
500F (260C) to use temperature	100F (55C) per hour

For thicker or multi-layer linings, contact your Harbison-Walker representative for a recommended dryout schedule.

Review Material Safety Data Sheet & Warning Labels