

Harbison-Walker
Mixing & Using Instructions
VERSAFLOW 60 PLUS

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

Material should be stored in a dry place. For best results, material should be maintained at 60-70F prior to casting. Under these conditions, the maximum recommended storage life for this product is nine 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 may be either vibra-cast, hand cast (poured) or pumped. **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 60-80F.

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

Approximate Water For Installing
Pints (Liters)

<u>Bag Size</u>	<u>Pumped</u>	<u>Hand Cast</u>	<u>Vibra-cast</u>
100 lbs. (45.5 kg)	6.4 (2.9)	5.9 (2.7)	5.5 (2.5)
55 lbs. (25.0 kg)	3.5 (1.6)	3.25 (1.5)	3.0 (1.4)
50 lbs. (22.7 kg)	3.2 (1.5)	3.0 (1.4)	2.7 (1.3)
Wt. % of dry solids	6.6%	6.0%	5.6%

Mix for at least seven minutes. Eight to ten minutes may be required for fully mixing vibra-cast and hand cast consistencies. For best results, wet mix temperature should be maintained at 50-70F. Minor adjustments to the amount of water are permissible to achieve desired flow.

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

Place material promptly. Do not trowel to slick finish. At temperatures above 60F, air cure, keeping surfaces damp and/or covered, for 24-48 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 70-100F. 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 use temperature

100F (56C) 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

Updated: June 5, 2002