

## Characteristics

DGM / RAPIDE - T is a low sintering stoneware body, especially suitable for pressure casting.  
It is a low sintering body.  
Available as blended powder.

Firing Colour	cream
Recommended Firing Temperature Range	1000 - 1150 °C

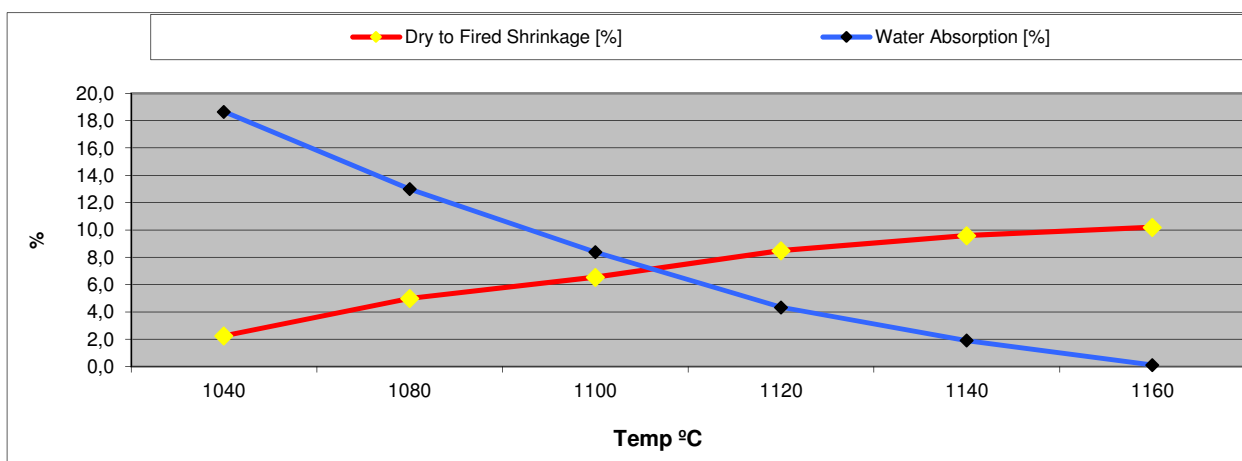
## Technical Data

### Unfired

Moisture	0,8% powder							
Chemical Analysis	SiO <sub>2</sub>	TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub>	Fe <sub>2</sub> O <sub>3</sub>	CaO	MgO	K <sub>2</sub> O	Na <sub>2</sub> O
	70,3%	0,80%	21,8%	0,80%	0,30%	2,00%	3,20%	0,80%
Loss of Ignition	6,2%							
Wet to Dry Shrinkage	2,2% casting							

### Fired

Specimen Firing Temperature [°C]	1100
Coefficient of Thermal Expansion [x10-6/°C]	
	20 - 400 °C
	20 - 500 °C
	20 - 600 °C
	6,8
	7,1
	7,8
Dry to Fired Shrinkage [%]	7,5
Water Absorption [%]	4,0



Dolaflux B 11 : Giessfix 162	1 : 2
Optimum Amounts	0,25% - 0,28%

First deflocculant and afterwards, add the powder under slow stirring to the water.

Specific Weight to Achieve	1770 - 1780 g / l
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DGM / Rapide - T needs about 42 l water per 100 kg powder to achieve s.w. of 1770 g / l.

Test the casting advice in own production first remembering the mentioned amounts are depending

- use the right amount of deflocculant to achieve optimum casting time
- if castthickness is too small, use less deflocculant.
- don't use more than 10 - 15 % of scrap ( above the fresh made slip )

The technical data quoted on this sheet is indicative only. Any sale is by sample and is governed by our general conditions of sale.



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