

Instructions for use and storage

We recommend storing materials in a sheltered and dry place, at a temperature not below 5°C.
Pallets of soft materials (eg. castables with density < 1000 kg/m³) shall not be stacked one upon the other.

In order to obtain the best result; during application, we recommend:

- ◆ castables (eg: LICOFEST, LINAX, BAXOCAST, BAXOVIBRO, BAXOFIX ...) shall be mixed with water addition as shown in the relevant data sheet; use only clean, fresh, tap water. Suitable paddle mixers are preferable to mix castables; setting time is affected by ambient temperature: cold weather slows down setting, while hot weather quickens setting time; setting time can be adjusted by mean of tailored additives, which may be supplied by Linco Baxo. It's advisable to vibrate dense castables, and this is compulsory for low cement castables (eg: LICOFEST PL ... and BAXOVIBRO).
- ◆ mouldables and ramming-mixes (eg: LICOTON, LICO-CLAY, KERORAM ...) shall be compacted by pneumatic rammers.
- ◆ frost may damage fresh cast materials as water transformation into ice induces structural alterations.
- ◆ freshly placed lightweight castables are prone to a deteriorating condition called alkali hydrolysis (AH) or carbonation when are kept in a non-dried state for a sustained period of time in a dump and humid environment. The ideal recommendation is therefore to fully dry the concrete lining immediately after the curing has been completed. Another practical way to overcome this undesired situation, is to apply CURING MIX 106, a water base curing compound, which forms a membrane preventing the formation of "cationic hydrolysis" and then protecting the lining.
- ◆ Follow always a careful drying and heating up curve, which may be summarized as follows:

Setting and open-air drying	: 72 hours
From 20°C. to 200°C.	: 12 hours (15°C./hour)
Hold at 200 °C.	: 24 hours
From 200°C. to 350°C.	: 12 hours (12,5°C./hour)
Hold at 350 °C.	: 24 hours
From 350°C. to 500°C.	: 10 hours (15°C./hour)
Hold at 500 °C.	: 12 hours
From 500°C. to 750°C.	: 10 hours (25°C./hour)
From 750°C. to 1250°C.	: 10 hours (50°C./hour)

We underline the importance of first heating in order to ensure the complete evacuation of mixing water from hydraulic setting castables; and to avoid the potential transformation into steam; consequences may be structural alterations; and unexpected and undesired violent detachments; of lumps.

IN CASE OF NEW COMPLETE LINING AND/OR LARGE REVAMPING, IT IS STRICTLY RECOMMENDED TO FOLLOW THE TAILORED HEATING UP CURVE, PROVIDED TOGETHER WITH OWNER'S MANUAL AND DRAWINGS, WHICH MAY DIFFER FROM STANDARD HEATING UP CHART.

THE EQUIPMENT NECESSARY FOR A MATERIAL APPLICATION IS MARKETED BY OUR COMPANY. FOR ANY EXPLANATION, PLEASE FEEL FREE TO ASK FOR SPECIFIC DETAILED USE INSTRUCTIONS OR CONTACT OUR TECHNICAL STAFF (02-5520041), e-mail info@lincobaxo.com or visit our web page: www.lincobaxo.com/instructions/

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