

FIBRAN TB PRESS

alpha type gypsum for ceramic industry

Technical Data Sheet



Description

TB PRESS is a very fine-grained alpha-type calcium sulfate hemihydrate. It is obtained by firing selected gypsum stone under special temperature and pressure conditions.

Packaging: 25 kg paper bags.

Fields of application

Due to its hardness and porosity characteristics, it is used **for forming ceramics by press process.**

Preparation and use

TB PRESS should be kneaded mechanically. The type of turbine (size, speed and shape), as well as the time of mixing, purity of water and mixing ratio, affect pouring time and porosity. Use only clean containers: impurities change the setting time of the product. Spread TB PRESS by spreading it evenly over the surface of the water and let it stand for about 2 minutes. Mix with a mechanical mixer for about 10 minutes, trying to choose a mixing speed such that no air is formed in the mixture. For the last 2 minutes, you may want to decrease the mixing speed so that any air that has seeped in can escape. The dough should be poured into the mold in the calculated processing time. The structure and order of magnitude of the micropores are defined according to the time at which air is started to be blown in. After pouring the product into the mold and flush pulling the excess material, the temperature should be checked by inserting a thermometer. The temperature difference between the start of mixing and the start of ventilation should be 10-14°C (with mixing ratio 3.0 kg/liter). Once the temperature is reached, compressed air at 0.5 bar should be started to be blown into the mold. Every 40 seconds, the pressure should increase by 0.5 bar, until it reaches 2 bar, after which you wait for 2 minutes and then start to rise by 0.5 bar again. Every half minute up to 4.5 ÷ 5 bar. When the maximum value is reached, maintain the pressure until the maximum temperature is reached. Before using the plaster molds in the press, it is advisable to wet them with water for 1 hour. In the case of prolonged interruption of production, it is advisable to moisten the molds every other day to prevent clogging of the pores.

Features	U. M.	Value
Size of particles	µm	< 200
Water / gypsum ratio	-	100/300
Casting time	min	20+
End of grip time	min	30
Grip expansion	%	0,1
Compressive strength	N/mm ²	35
Flexural strength	N/mm ²	12

Storage and Warnings

Store dry for a period not exceeding 9 months. The bags must be stored without any direct contact with the ground and protected from dripping. The product should be used at temperatures between 5 and 35 °C.

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