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ENGLISH

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# FORMULA 8-G

*Thermbond Refractories use the patented Stellar Binder System™ for easy and accurate mixing, controlled setting, fast dry-out and heat up, thermal shock resistance and other unique properties. Thermbond chemically bonds to existing fired refractories. CHARACTERISTICS: - Silica - Dense - Fast Setting - Fast Curing*

PACKAGING		
Bag Weight*	26 lbs	11.8 kg
Jug Weight*	8 lbs	3.6 kg
Drum Weight*	400 lbs	181.4 kg
Unit Weight*	39 lbs	17.7 kg
Yield / Unit*	0.39 ft3	0.011 m3
Units / Ton*	51.28 short	56.53 metric
Board Feet / Unit*	4.7 bd ft	
Wet to Dry Ratio*	50% - 55%	
Liquid Activator	FORMULA	
Bags Per Pallet	72	
Drums Per Dry Pallet	2 (plus predampening jugs)*	

APPLICATION***	
Data based on	Gunning
Alternative Method***	Casting

BULK DENSITY**		
As Placed	100 lbs/ft3	1602 kg/m3
After 1500F (816C)	80 lbs/ft3	1281 kg/m3

MAXIMUM RECOMMENDED SERVICE TEMP**		
Hot Face	2800 F	1538 C

COMPRESSIVE STRENGTH**			
1500F (816C)	1500 psi	105 kg/cm2	10 N/mm2
2000F (1093C)	1200 psi	84 kg/cm2	8 N/mm2
2500F (1371C)	1200 psi	84 kg/cm2	8 N/mm2

PERMANENT LINEAR CHANGE**	
1500F (816C)	-0.55%
2000F (1093C)	-1.40%
2500F (1371C)	-1.30%

TYPICAL CHEMICAL ANALYSIS (After 1500F (816C))**	
Al2O3	15.55%
SiO2	60.00%
Fe2O3	1.07%
P2O5	14.19%
Other	9.18%
Total	100.00%

THERMAL CONDUCTIVITY**		
1000F (538C)	2.2 Btu-in/hr-ft2-F	0.32 W/m K
1500F (816C)	2.4 Btu-in/hr-ft2-F	0.35 W/m K
2000F (1093C)	2.7 Btu-in/hr-ft2-F	0.39 W/m K
2500F (1371C)	3.2 Btu-in/hr-ft2-F	0.46 W/m K

COLD MODULUS OF RUPTURE**			
1500F (816C)	250 psi	18 kg/cm2	2 N/mm2
2000F (1093C)	200 psi	14 kg/cm2	1 N/mm2
2500F (1371C)	180 psi	13 kg/cm2	1 N/mm2

\*Measures are approximate and may vary. For mixing partial units, contact Stellar Materials for specific wet-to-dry ratios. See Installation Guide for more detailed information.

\*\*Test data shown are based on averages subject to normal variation on individual tests, and therefore should not be assumed to be maximum or minimum specifications.

Due to the unique nature of the Stellar binder system, test procedures vary slightly from ASTM. Documentation of these variations is available upon request.

\*\*\*Application by alternative method may produce somewhat different results.

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