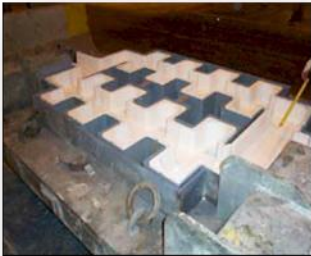


## Permotech Precast Billet Casting Table Refractory Suggested Installation Procedure

Many end users and OEM's have developed and implemented their own systems and methods of installing refractory and insulation systems for Billet Casting tables. These instructions are not intended to supersede these, but are intended to be used as a general guide and reference only.



1 – Line entire bottom and sides of interior of table with refractory paper. RCF or Non-RCF containing paper may be used ( ¼” thickness 12pcf) use adhesive (glue) to keep the paper in place if necessary.



2 – Dry fit precast refractory shapes on to table.

3 – Insert gaskets between joints of precast shapes. This can be done by using refractory paper 9 1/8” thickness 12 pcf) on both sides of the joint with moldable in between or by using refractory moldable alone between the joints.



4 – Place insulation between steel shell and precast shapes filling all voids. This can be done with *\*Permotech's R745 Foam Insulation* or dry granular insulation such as Matrix Refractory's Dri Lite 65 A. Follow manufactures specific instructions for each product.

5 – Caulk all joints with refractory moldable and then smooth out with water.



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*\*R-745* is a 90% alumina foam insulation for use as back-up behind working linings of troughs and other vessels used in the transportation and handling of molten aluminum alloys. This two component product is mixed at the installation site and is pumped or poured into irregular areas where solid forms of insulation cannot fit and castable forms cannot reach. R-745 Foam Insulation is resistant to reaction by molten aluminum alloys.