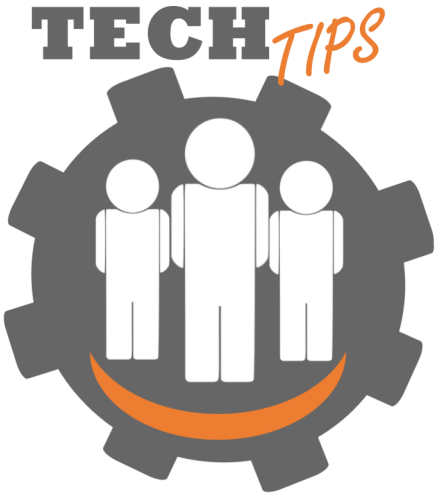
# SuspendaSlurry® materials FAQs




### Is SuspendaSlurry material compatible with super alloys and stainless steel?

SuspendaSlurry ZR material should be used for super alloys and stainless steel.

### What is typical for the number of dip layers for SuspendaSlurry material?

Depending on the size and complexity of your parts, the number of dips can vary. SuspendaSlurry material does not require any additional coats over your current system.

### What is typical for dry times for SuspendaSlurry material?

SuspendaSlurry material comes complete with a drying indicator to eliminate guesswork and will dry similarly to any colloidal based system.

### What is the MOR data for SuspendaSlurry materials?

SuspendaSlurry ZR material is only a prime and therefore does not have MOR values. SuspendaSlurry FS material's MOR data is shown in the table below.

| | Standard BU System | SuspendaSlurry FS material |
|---|---|---|
| Viscosity | 11/#5 | 12/#5 |
| Thickness | 8.3 | 5.63 |
| Green MOR | 411 | 603 |
| Green AFL | 12.84 | 9.25 |
| Hot MOR 1000 | 626 | 1785 |
| Hot AFL 1000 | 24.43 | 22.12 |
| Hot Deflection 1000 | 2.28 | 1.37 |

### When using SuspendaSlurry material, will there be a problem with sand in the slurry?

No, this will settle in the bottom of the container as it is introduced due to its weight. This is the same as what happens in a standard slurry tank and you should not see a difference in this slurry.

### Can I add SuspendaSlurry material on top of a Primcote® slurry?

While the material is fully compatible with Primcote® binder, diluting it will impact the suspension characteristics of the slurry. We recommend that at least 80% of the tank be SuspendaSlurry material. In this case, you will still see some separation until the tank is turned over to 100% SuspendaSlurry material. We recommend that you keep mixing it overnight if you are not in a 100% SuspendaSlurry material tank.

### What stucco do you recommend using with SuspendaSlurry material? We currently use foundry sand with our colloidal silica. Would this work the same, or is a different stucco required?

For non-ferrous castings, using SuspendaSlurry FS material for the complete shell, we recommend using fused silica stucco. For a 60 pound pail of slurry, you would need 1 bag of A and 1 bag of B (fine and slightly coarser). For a 400 pound slurry, you would need 3 bags of A and 9 bags of B. For ferrous castings, using SuspendaSlurry ZR material for the primary coats, we recommend using zircon sand. For a 100 pound pail of slurry, you would need 1 bag of zircon. For a 600 pound slurry, you would need 3 bags of zircon.

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### For SuspendaSlurry material, what is the maximum suspension time recommended? Will the slurry remain in suspension indefinitely, or would it need to be stirred after 1, 3 or 6 months?

We recommend a quick re-stir every time you open the container before dipping. There will be some separation visible on the top of the container, this should be mixed in. The material will remain suspended for >1 month. It is recommended to briefly mix the slurry if not in use for longer than 1 month.

### Do any additional refractory materials need to be added to SuspendaSlurry material; such as zircon or alumina?

No additional flours need to be added prior to use.

### Does SuspendaSlurry material generate a quicker build on the shell because of a higher viscosity?

There will be a little more build, but not enough to really cut coats from your normal process.

### How do I test the slurry?

The slurry will need regular viscosity checks. Water is added when the viscosity increases by more than 2 seconds.

### How do I store the material?

SuspendaSlurry material is provided in resealable containers that can be used as your dipping tank but must be resealed between use. If you would like to use your own tank, the viscosity must be monitored closely in order to replenish any evaporated water.

### What volumes do you sell SuspendaSlurry material in?

SuspendaSlurry FS material is available in 60 pound (5 gallon) and 400 pound (30 gallon) slurries. SuspendaSlurry ZR material is packaged in 100 pound pails (5 gallons) and 600 pound drums (30 gallons). All are ready-to-use as tanks, if desired. Alternatively, if you have a rotating tank, you can put the material in the rotating tank as well. Mix first, then use in either situation.

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