Sial art

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PROCEDURE

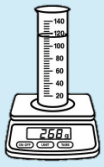
CASTING
SLIP ADJUSTMENT

For best results, please adjust your slurry before use according to the parameters in the chart.

1. **Always measure DENSITY first**
    a. Density is the "concentration" of particles in a liquid. Measured by weight, you need a 1000ml graduated cylinder and a precision scale to check it. Fill the cylinder to 1000 ml and weigh it, having taken care to tare your scale beforehand.
2. **Measuring VISCOSITY After Adjusting Density**
    a. Viscosity is the resistance of a liquid to flow. Fill a LEMMER paint viscometer to the brim and calculate the liquid flow time.
    b. If the slip takes too long to drain, add a little deflocculant at a time, too much deflocculant will have the opposite effect and the slip will thicken.
    c. We suggest stirring for 5 minutes before adding any more sodium silicate to allow it to maximize its effect.
3. **DEFLOCCULANT**
    a. The deflocculant used to adjust the viscosity is sodium silicate. NEVER ADD UNDILUTED SODIUM SILICATE to the slip. You should always dilute it with a like amount of water.

High Density	Add water
High Viscosity	Add Sodium Silicate

Practical tip : Always adjust little by little

	 **Density**	 **Viscosity**
Slip	**± 5 g/l.**	**± 5 sec.**
05M	1763	33
124M	1765	30
A1	1780	32
B1	1780	33
Semi-Stoneware	1775	33
Terra-Cotta	1763	33