

## ***Technical Information***

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### **APPLICATION GUIDELINES 22 CAULK**

22 CAULK is used to repair cracks in refractory linings that have already been heated or in service. This product is supplied in standard size caulking tubes. For best results, use the pneumatic 22 caulk gun kit with clean out nozzles.

1. Scrape away or break off any loose edges along the length of the crack with a screwdriver or other prying type tool.
2. Blow out any dust that has accumulated in the crack with the hand held air valve and reduced nozzle found in the kit. Clean the sides of the crack. This will aid in bonding the caulk to existing refractory surface and allow the 22 CAULK to penetrate the crack.
3. Dampen the sides of the crack with water using a spray bottle or other suitable means. This will lubricate the existing refractory surface and allow the 22 CAULK to penetrate deeper into the crack.
4. For best results, cut off the tip of the caulk tube to give about a 1/16 in (1.5 mm) opening. For larger cracks a larger opening can be used. Protective goggles and gloves should be worn during application.
5. The pneumatic caulking gun pressure should be about 65 psi (4.5 kg/cm<sup>2</sup>) at the regulator. Apply the 22 CAULK until it reaches the surface of the existing refractory lining.
6. One tube is required for approximately 5 linear ft (1.5 m) to fill an average 1/4 in (6 mm) opening about 1 to 1-1/2 in (25 to 38 mm) in depth. Recommend ordering twice the required amount to have sufficient quantity.
7. The 22 CAULK will air harden and can be heat cured as the unit is brought up to temperature. For best results the hot face of the lining should be heated to 650°F (340°C) minimum.
8. No special thermal curing is necessary.