General Application Advice

Dry Spray Mortar

Application Guidelines

Application Conditions
It is possible to apply one or several layers. The second and all further layers are applied to each previously sprayed layer, which must have stiffened but not yet completely dry. If the previous layer has dried out completely, it must be pre-wetted before application. Please refer to the application information in the official test certificate.

Machine Technology
Standard dry-spraying machines with rotor delivery are suitable for application. To ensure a consistent delivery of the spraying material, we advise the use of the machine technology listed in Table 1.

Water-/Oil separator
To ensure an optimal delivery, an additional sufficiently large water-oil separator must be attached between the compressor unit exit and the spraying nozzle.

Water Boosting Pump
To prevent possible pressure fluctuations in the water delivery, which may lead to insufficient wetting of the dry-spraying material, it is absolutely necessary to employ a pressure-raising pump.

Rebound Behaviour
The rebound behaviour must be considered individually for each object, as it depends on position and accessibility of a structural part and on the skills of the nozzle-operator. Please refer to the nozzle-operator manual published by the Industrial Association German Construction Chemicals. The rebound values listed in Table 2 are experience values which take all parameters into account.

Definition: Rebound
Rebound is the part of the spraying material which rebounds from the surface and falls to the ground. Rebound is not the additional loss of material due to a possible subsequent treatment (finishing, levelling over a height gage) of the sprayed layer.

Auxilliary Form Work
When re-profiling supports, pillars and beams suitable form work must be installed. When concrete covers are increased over larger areas, height gages must be installed to achieve an even height.

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Table 1: Machine Technology

Configuration	Technology 1 (Velco)	Technology 2 (Aliva)
Dry-spraying machine	Velco Rotamat 25 tb with a 48 rotor	Aliva 237 with a 0.7 litre rotor
Spraying Nozzle	Cast iron nozzle 32/18 mm	Aliva Vulcollan nozzle 32/18 mm
Delivery Hose	Length: 40 m Ø interior/exterior 48/32 mm	Length: 40 m Ø interior/exterior 52/32 mm
Water-pressure raising pump	Adjusted to 6 bar water pressure	Adjusted to approx. 12-15 bar water pressure
Compressor Capacity	5-6 m^3/minute	5-6 m^3/minute
Delivery air pressure at the spraying machine	approx. 1.4-1.5 bar	approx. 1.4 bar
Delivery Capacity	approx. 800-1200 kg/h	approx. 300-400 kg/h

Table 2: Experience Values for Rebound

Direction of Application	vertical		overhead	
Layer thickness (mm)	10-20	20-50	10-20	20-50
Rebound in %	20-25	15-20	25-35	20-25

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