

Product Information

Dolit 788+

KI.FU.002 | 04/12/2023



CRS
Chemical Resistant Systems

PRODUCT GROUP

Mortar - Synthetic resin

BINDER BASE

Furan resin, aldehyde-free

PROPERTIES / APPLICATION

Laying and jointing mortar based on an aldehyde-free, modified furan resin and a carbonaceous filler for easy laying and jointing of acid-resistant ceramic tiles, bricks or carbon bricks.

Preferred material for lining components with increased thermal load or thermal cycling, inorganic-chemical load, frequent transitions between dry and moist load, e.g. during industrial flue gas cooling, in quenches and venturis.

- Temperature resistance
 - Up to 280 °C (continuous load).
 - Up to 350 °C (short-term load).
 - The temperature resistance is basically dependent on the project-specific chemical stress.
- Outstanding thermal shock resistance.
- Very good stability in areas of wet/dry transitions.
- Very good chemical resistance, e.g. to inorganic acids (also hydrofluoric acid).
- Excellent adhesion to ceramic tiles, bricks or carbon bricks.
- Hardening with low shrinkage.
- Electrically conductive (see Testing the electrostatic discharge capacity [► 5]).
- Good storage stability of the components even at higher storage temperatures.

SYSTEM DESIGN

Dolit 788+ Mortar mass

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PHYSICAL DATA

Physical property	DIN	ASTM	Value	Unit
Density	DIN EN ISO 1183-1		1.5	g/cm ³
Flexural strength ^[1]		ASTM C 580	24	MPa
Flexural modulus of elasticity ^[1]		ASTM C 580	5000	MPa
Compressive strength ^[1]		ASTM C 579	70	MPa
Tensile strength ^[1]		ASTM C 307	10	MPa
Adhesive strength to ceramic tiles	DIN EN ISO 4624		> 2	MPa
Adhesion to carbon tiles	DIN EN ISO 4624		> Intrinsic tensile strength carbon tiles	MPa
Electr. leakage resistance	DIN EN 14879-6 At ≤ 50% relative humidity	ASTM F 150/98	< 10 ⁸	Ω

PRECONDITIONS

The temperatures for the substrate, ambient air and Dolit materials must be between 10 °C and 30 °C during application. The optimum processing temperature is 20 °C. Higher and lower temperatures affect the working time and consistency of the composition. Consumption and application performance may change as a result.

During application, the substrate must be kept absolutely dry. No moisture (condensate, mist, etc.) may get onto the surfaces to be protected.

Unevenness must already be levelled out in the substrate.

Distance to dew point has to be at least 3 K, at a relative humidity of above 70 % at least 5 K.

The construction site must be protected from draught and direct sunlight.

Dolit mortar systems can be used for the full-joint or hollow-joint installation of tiles and bricks. Normally, the build-up is carried out on one of the coating or lining systems from the CRS programme under the conditions and system build-ups described there (e.g. execution of an adhesive layer). If such a sealing layer is not used, at least a suitable primer with appropriate sprinkling must be provided.

If tiles laid in a hollow joint are to be jointed with a Dolit mortar material, the bedding joint must be hardened and dry again. The open joint should have a rectangular cross-section, be at least 15 mm deep and 5 - 8 mm wide. The side surfaces of the tiles must be free of mortar material and the joint must be clean.

^[1] Mean value, determined on annealed samples.

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DELIVERY FORM / BEST BEFORE DATE

Component	Item no.	Quantity	Package	Months
Dolit-788+-Solution	5233325001	25 kg	Hobbock	24
Dolit-788+-Powder	5233048021	15 kg	Bag	24

- All components must be stored and transported in a dry and frost-free place.
- The minimum shelf life applies to a storage temperature of 20 °C. Higher temperatures shorten, lower temperatures extend the minimum shelf life.

Safety notice

- For handling, storage and transport, observe the relevant safety data sheets!

WORKING EQUIPMENT

NOTE! The materials to be processed can have an aggressive effect on mixing and processing tools due to the solvents, acidic, alkaline or abrasive components they contain. Therefore, please use only suitable tools for mixing and processing.

Measuring cup

Scale

Mixing vessel

Drilling machine

Anchor stirrer

Mortar mixer

Trowel

Joint iron

Joint injector

GISCODE

Product	GISCODE
Dolit 788+ Mortar mass	SB-F10

MIXING RATIO / CONSUMPTION

BEDDING AND JOINTING MORTAR

DOLIT 788+ MORTAR MASS

Component	kg per Litre	Part by weight	kg per Mix	Liters per Mix
Dolit-788+-Solution	0.577	100	2.000	1.710
Dolit-788+-Powder	0.923	160	3.200	4.500
Total	1.500	260	5.200	

Volume per batch	≈ 3.45 l Mortar mass
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Mortar required for full-length installation (bedding joint 5 mm, butt joint 7 mm)

Split tiles 240 x 115 x 20 mm	≈ 7.5 l	11.25 kg/m ²
Split tiles 240 x 115 x 40 mm	≈ 9.5 l	14.25 kg/m ²
Bricks 240 x 115 x 65 mm	≈ 11.5 l	17.25 kg/m ²
Bricks 240 x 115 x 80 mm	≈ 13.0 l	19.50 kg/m ²
Bed joint thickness	4 – 7 mm	
Joint width	5 – 8 mm	

MIXING / APPLICATION

Processing may only be started when the application requirements are met and can be maintained during the entire processing and curing.

MIXING SEQUENCE

- At high ambient temperatures, mix smaller quantities of mortar to avoid a strong exothermic reaction of the mixture.
- Stir the solution well with the anchor stirrer (300 - 500 rpm) before use or partial withdrawal. Move the stirrer past the vessel wall and bottom.
- Liquid components are measured or weighed and transferred to a mixing vessel.
- Solids are measured or weighed out individually, added to the solution in portions and mixed in carefully with an anchor stirrer (300 - 500 rpm) until a lump-free mixture is obtained.
- During the mixing process, move the stirrer past the vessel wall and bottom several times.

APPLICATION

- The mortar can be used for the full-joint or hollow-joint installation of tiles or bricks.
- Bedding joint is applied to the substrate in a thickness of 4 - 7 mm.
- For full-joint application, apply the mortar to two side edges of the tiles or bricks. Then place the tile or brick in position.
- Remove the mortar bead with the trowel and smooth out the joint.
- With hollow joint installation, the butt joint remains free and is filled later.
- Special care should be taken to ensure that the work is free of voids.
- Subsequent jointing can be carried out using a jointing injector and jointing iron.
- To compact the joint, excess material is pressed into the joint with the joint iron. Remaining material is removed with the trowel.

POT LIFE

- At 20 °C the pot life is approx. 30 - 50 min.
- The pot life depends on the temperature.
- Higher temperatures shorten it, lower temperatures prolong it.

WAIT- / CURING TIME

- Waiting time until walkability (at 20 °C) at least 24 hours.
- Curing time until complete chemical and mechanical resistance (at 20 °C) at least 7 days.

CLEANING

Tools that are soiled with uncured materials can be cleaned with Dolit-Universal-Cleaner. Clean only in well ventilated areas and observe safety measures.

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TESTING THE ELECTROSTATIC DISCHARGE CAPACITY

Tile flooring needs to be cleaned before the test. There must be no insulating layers.

The test takes place at the construction site and is carried out at the earliest 8 days after installation.

The measurement of the earth leakage resistance R_E for testing the electrostatic discharge capability is carried out in accordance with DIN EN 14879-6 and is performed using a commercially available resistance meter up to 10^8 ohms with 100 volts DC as the measuring voltage. A circular electrode with a diameter of 50 mm is used as the measuring electrode. As a contact mediator, a 50 mm diameter flow paper slightly moistened with tap water is placed on the surface of the tile. During the measurement, a force of approx. 10 N is applied to the base.

For tile coverings with non-electrically conductive ceramic tiles, measurements are taken in the area of the joint. Particular care must be taken to ensure that there is uninterrupted contact between the electrode, contact mediator and joint during the measurement.

For non-conductive tiles, the panel size must not exceed the following dimensions to ensure conductivity across the joint material:

- For rectangular tiles 115 x 240 mm
- For square panels: 150 mm x 150 mm

SAFETY / DISPOSAL

- Ensure sufficient ventilation, especially when working in closed rooms, pits or containers.
- Observe fire and smoking ban.
- Observe safety data sheets, hazard statements and safety advice on the containers.
- Wear prescribed personal protective equipment. Avoid skin contact with the materials.
- Clean and care for hands with skin protection soap and ointment. Do not use solvents.
- Wear a dust mask during grinding work, e.g. repairs.
- Follow operating instructions according to §14 GefahrstoffV and Technical Rules for Hazardous Substances TRGS 507.
- Comply with the accident prevention regulations of the employers' liability insurance associations.
- Avoid direct contact of the materials with the flame, especially when welding, watch out for welding beads.
- Preferably consume residual quantities.
- Do not pour residues down the sink or into the dustbin.
- Collect residues for disposal separately in durable, sealable and labelled containers.

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This issue replaces all previous versions.