

**FFR**

**FIELD FURNACE REFRACTORIES
Pty Ltd.**
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Castable Ovens

For a meter internal castable dome oven

8	Bags Duracast 1400	\$42.60each	\$340.80
21	Floor Tiles 50 x 230 x 230mm	\$7.70each	\$161.70
26	I.F.B 230 x 230 x 60mm	\$5.50each	\$143.00
2	25x600x7200 128kg/m3 Roll	\$126.50each	\$253.50
12	230 x 115 x 50mm	\$2.55each	\$ 30.60
1	2kg Air set mortar	\$15.10each	\$ 15.10

Total

\$ 944.70



These steps are only a guide.

- First lay the insulation brick on a hebel slab 75mm thick, or 100mm concrete slab with 2 layers of 5mm mesh
- Then the insulation brick are laid out covering the area of the oven.
- Lay the floor tile on top cutting to size with 50mm brick round the edge.
- Place door and flue templates in place, create a mound of brickie sand for chamber, making the shape of the oven.
- Lay newspaper over sand and plastic.
- Cast the oven with Duracast 1400 50–60mm thick.
- Lay ceramic fiber blanket over the cast oven 3 layers recommend minimum (50mm thick). If you have excess use as well the more the better.
- Then lay chicken wire over blanket.
- An easy mix 1 bag of cement, 1 bag brickie sand, 2 bag of Sydney sand, 1 bag river sand. The trick is to avoid too much water in the mix, a thick creamy mix that can make a peak is perfect to render over chicken wire 20 - 30mm thick, leave for 24 hours. Too much water promotes shrinkage in turn causes cracking.
- Remove flue and door moulds, shovel sand out and your oven is done.
- First fire is most important if heated up too quick you can damage the oven, Three to four bags of heat beads is the best way to dry the oven out. The idea is to not let any flames touch the castable till it reaches about two hundred degrees. By lighting the heat beads outside in a weber or on some bricks, then with a shovel you can scoop them up once alight and spread them around the inside perimeter. Every 30-60 minutes tapping them, every hour you can use another bag. 7-8 hours later you can start a small fire.

Now your ready to cook.

