Mr Volcano
Satanite – PREP/APPLICATION

The steps below are for applying Satanite on a Mr Volcano Hero 2, which would use 3.5 pounds of refractory. Adjust the instructions to the size of forge that you have, for reference, the blanket dimensions of a Hero 2 when laid out flat is 24" x 16". To achieve the desired thickness, you will need to apply two thin coats of Refractory.

When preparing to mix the Satanite refractory, make sure to measure with a scale – do not guess. Mix for 5 minutes. Look for a sour cream type consistency. See below for mixing ratios.

NOTE: Refractory curing must be done in a temperature environment of **at least 50°F-** the warmer the better.

TIPS:

- Using a brush will greatly help with spreading the mixture evenly.
- Do not get refractory into the entry tube. Wipe off refractory from the entry tube or the outside shell body while it is still wet.

STEPS:

1. **Pre-wet the insulation**: Spray water lightly on all exposed areas of the insulation. Any dry spots in the blanket will absorb the water from the refractory mixture too fast and cause cracks. Too much water will prolong the drying step.
2. **Apply 1st Coat**: Mix the following: **2.25 lb** Satanite Refractory with **9.94 fl oz** water (10.37 oz in weight). Cover all exposed surfaces of the blanket evenly.
3. **Allow the 1st Coat to dry**: Let the first coat air dry for 24 hours. If after 24 hours some areas are still wet, you can dry it with a heat gun, hair dryer, or let it air dry for another 24-48 hours.
4. **Apply 2nd Coat**: Mix the following: **1.25 lb** Satanite Refractory with **5.53 fl oz** water (5.77 oz in weight).
5. **Allow the 2nd Coat to dry**: Same way as the first coat.
6. **Cure the refractory coatings:** After the second layer has been dried, you are now ready to cure the refractory to make it a one solid piece. The idea is to remove water that is still left in the refractory coating after the drying. It is very important to do this slowly, by heating it up in the given time increments and letting it cool down. As soon as you see steam forming then turn it off. Don't rush this process.

a) Start with firing up the burners on low and keep it on for 45 seconds.
b) Turn off the forge and allow it to cool down for 5 minutes.
c) Repeat Steps A and B – increasing the time in step "A" by 5 seconds to each interval until you don't see any steam forming.

During the curing process: Most water escapes through the cold face, not the hot face. The seams of the forge serve as weep holes to the cold face to provide an escape path for steam to exhaust during the heating of the curing process. It is normal for refractory to develop some cracks after final drying and regular use.

Happy to help: Support@Mrvolcano.com