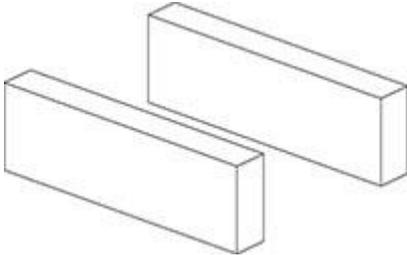


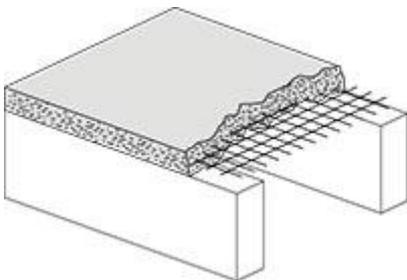
Aufbauanleitung

1



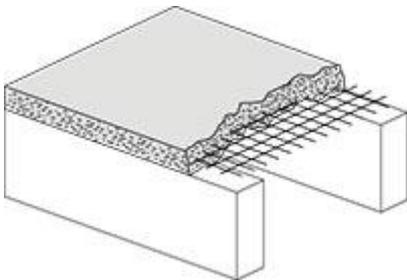
Build two masonry supports about 75 cm high to get a 110 cm high frame.

2



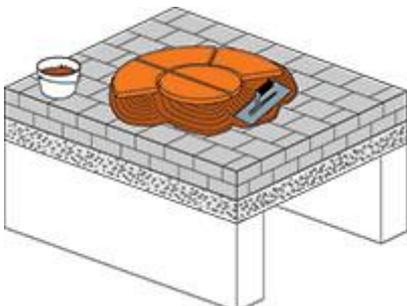
Place a load-bearing concrete slab, of a thickness of about 15 cm.

3



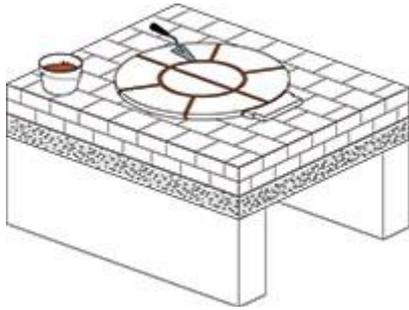
Build a floor at a height of about 15 cm with panels of lightweight cellular concrete or lightweight concrete with expanded clay or vermiculite.

4



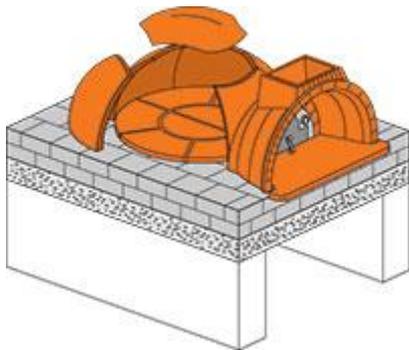
After wetting the floor, spread a thin layer of Refrax with a toothed trowel to lay down the pieces of the floor.

5



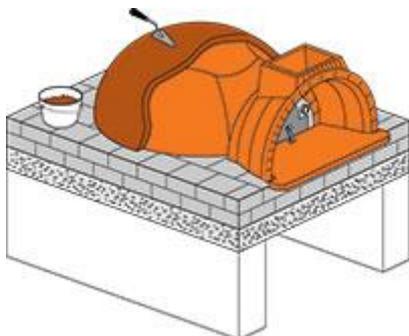
Wet the gaps between the pieces of the floor and fill with Refrax, making sure the filling reaches lower than the floor.

6



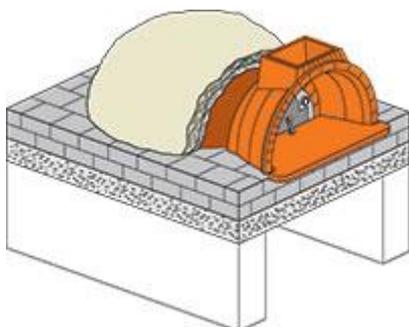
After mounting the dome and possibly the arc, make sure the different pieces are fully set.

7



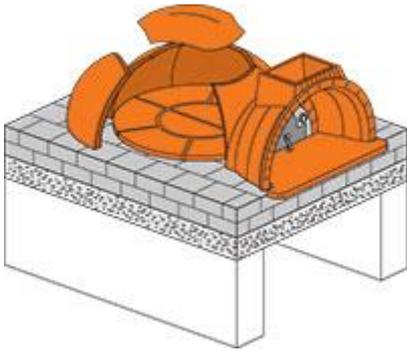
Wet the junctions between the different pieces of the dome and spread a 5 cm layer Refrax from the outside. For greater thermal inertia cast a layer of Refrax of 6 cm over the entire dome. **NB:** in larger ovens a thin wire mesh must be placed within the layer of Refrax.

8



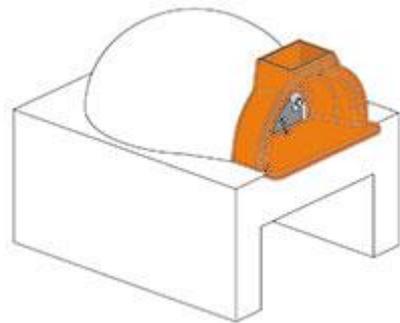
After applying the layer of Refrax mortar, continue with the insulation of the oven by spreading at least four layers of ceramic fiber around the dome. We suggest to place at least 4 layers with 2,5 cm thickness or 8 layers with 1,3 cm thickness.

9



To keep the spherical shape of the oven in view, cast 3/4 cm of sand and cement on top of the outer insulation and place a layer of metal mesh on top of it as a pre-emptive measure.

10



If the oven is installed outside, it must be protected from rain and humidity.

How much ceramic fiber and mortar to use?

Internal diameter of the oven	Ceramic fiber	Mortar
80	2 rolls	Kg 75
90	2,5 rolls	Kg 85
100	3 rolls	Kg 100
110	4 rolls	Kg 135
120	4,5 rolls	Kg 150
130	5 rolls	Kg 170
140	6 rolls	Kg 200
160	6,5 rolls	Kg 230
180	9 rolls	Kg 320