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(54) Title: INORGANIC FIBRE COMPOSITIONS

(57) Abrégé/Abstract:

Melt formed inorganic fibres are disclosed having the composition:- Al_2O_3 5 - 90 mol% K_2O 5 - 90 mol% SiO_2 5 - 90 mol% in which $\text{SiO}_2 + \text{Al}_2\text{O}_3 + \text{K}_2\text{O} \geq 50$ mol%. Fibres of like composition having K_2O greater than 12 mol% are also encompassed.

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(57) Abstract: Melt formed inorganic fibres are disclosed having the composition:- Al₂O₃ 5 - 90 mol% K₂O 5 - 90 mol% SiO₂ 5 - 90 mol% in which SiO₂ + Al₂O₃ + K₂O ≥ 50 mol%. Fibres of like composition having K₂O greater than 12 mol% are also encompassed.

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INORGANIC FIBRE COMPOSITIONS

This invention relates to inorganic fibre compositions.

Fibrous materials are well known for their use as thermal and/or acoustic insulating materials and are also known for their use as strengthening constituents in composite materials such as, for example, fibre reinforced cements, fibre reinforced plastics, and as a component of metal matrix composites. Such fibres may be used in support structures for catalyst bodies in pollution control devices such as automotive exhaust system catalytic converters and diesel particulate filters. Such fibres may be used as a constituent of friction materials [e.g. for automotive brakes]. The fibres of the present invention have a range of properties and may be usable in any or all of these applications depending on the properties shown.

Prior to 1987 there were four principle types of fibrous materials used for making thermal insulation products [such as, for example, blanket, vacuum formed shapes, and mastics]. These were made by two principal manufacturing routes, although the details of the particular routes vary according to manufacturer. The fibres and routes were (in order of increasing cost and temperature performance):-

Melt formed fibres

- Mineral wools
- Glass wools
- Aluminosilicate fibres

Sol-gel process fibres

- So-called polycrystalline fibres

Melt formed fibres are formed by making a melt and fiberising the resultant melt by any one of the many known methods. These methods include:-

- forming a stream of melt and allowing the stream to contact spinning wheels from which it is flung to form fibres
- forming a stream of melt and allowing the stream to impinge upon a jet of gas that may be transverse, parallel with, or at an angle to the direction of the stream and thereby blasting the melt into fibres

- forming a fibre from the melt by a rotary process in which the melt escapes through apertures in the circumference of a spinning cup and is blasted by hot gases to form fibres
- extruding the melt through fine apertures to form filaments, and in which further treatment may be used [e.g. flame attenuation in which the filament is passed through a flame]
- or any other method by which a melt is converted into a fibre.

Because of the history of asbestos fibres, a lot of attention has been paid to the relative potency of a wide range of fibre types as a cause of lung disease. Studies of the toxicology of natural and man-made fibres led to the idea that it was the persistence of fibres in the lung that caused problems. Accordingly, the view developed that if fibres can be removed from the lung quickly then any risk to health would be minimised. The concepts of “biopersistent fibres” and “biopersistence” arose – fibres that last for a long time in the animal body are considered biopersistent and the relative time that fibres remain in the animal body is known as biopersistence. Whilst several glass systems were known to be soluble in lung fluids, resulting in low biopersistence, there was a problem in that such glass systems were generally not useful for high temperature applications. A market need was seen for a fibre that could have a low biopersistence combined with a high temperature capability. In 1987 Johns Manville developed such a system based on a calcium magnesium silicate chemistry. Such material not only had a higher temperature capability than traditional glass wools, but also had a higher solubility in body fluids than the aluminosilicate fibres mostly used for high temperature insulation. Such low biopersistent fibres have been developed since, and a range of alkaline earth silicate [AES] fibres are now on the market.

Patents relating to AES fibres include:

- International Patent Application No. WO87/05007 – the original Johns-Manville application – which disclosed that fibres comprising magnesia, silica, calcia and less than 10 wt% alumina are soluble in saline solution. The solubilities of the fibres disclosed were in terms of parts per million of silicon (extracted from the silica containing material of the fibre) present in a saline solution after 5 hours of exposure.
- International Patent Application No. WO89/12032 disclosed additional fibres soluble in saline solution and discussed some of the constituents that may be present in such fibres.

- European Patent Application No. 0399320 disclosed glass fibres having a high physiological solubility and having 10-20mol% Na₂O and 0-5mol% K₂O. Although these fibres were shown to be physiologically soluble their maximum use temperature was not indicated.

5 Further patent specifications disclosing selection of fibres for their saline solubility include for example European 0412878 and 0459897, French 2662687 and 2662688, WO86/04807, WO90/02713, WO92/09536, WO93/22251, WO93/15028, WO94/15883, WO97/16386, WO2003/059835, WO2003/060016, EP1323687, WO2005/000754, WO2005/000971, and United States 5250488.

10 The refractoriness of the fibres disclosed in these various prior art documents varies considerably and for these alkaline earth silicate materials the properties are critically dependent upon composition.

As a generality, it is relatively easy to produce alkaline earth silicate fibres that perform well at low temperatures, since for low temperature use one can provide additives such as boron oxide
15 to ensure good fiberisation and vary the amounts of the components to suit desired material properties. However, as one seeks to raise the refractoriness of alkaline earth silicate fibres, one is forced to reduce the use of additives, since in general (albeit with exceptions) the more components are present, the lower the refractoriness.

WO93/15028 disclosed fibres comprising CaO, MgO, SiO₂, and optionally ZrO₂ as principal
20 constituents. Such AES fibres are also known as CMS (calcium magnesium silicate) or CMZS (calcium magnesium zirconium silicate) fibres. WO93/15028 required that the compositions used should be essentially free of alkali metal oxides. Amounts of up to 0.65wt% were shown to be acceptable for materials suitable for use as insulation at 1000°C.

WO93/15028 also disclosed methods of predicting the solubility of glasses and included a
25 range of materials that were tested as glasses for their solubility, but not formed as fibres. Among these compositions were compositions having the reference KAS, KMAS, and KNAS which were respectively a potassium aluminosilicate, a potassium magnesium aluminosilicate, and a potassium sodium aluminosilicate. These compositions were rated as having insufficient solubility on the basis of solubility measurements in a physiological like solution. The type of
30 physiological solution used has a pH of about 7.4.

It has subsequently been found that solubility depends on the environment within which a fibre finds itself. Although the physiological saline solution present in intercellular lung fluid approximates to that given in WO93/15028, and has a pH of around pH 7.4, the mechanism for clearing fibres involves their attack by macrophages. It is known that the pH of the physiological saline present where the macrophages contact fibres is significantly lower (around pH 4.5) and this has an effect on solubility of inorganic fibres [see "*In-vitro dissolution rate of mineral fibres at pH 4.5 and 7.4 - A new mathematical tool to evaluate the dependency on composition*" Torben Knudsen and Marianne Guldberg, Glass Sci. Technol. 78(205) No.3].

WO94/15883 disclosed a number of such fibres usable as refractory insulation at temperatures up to 1260°C or more. As with WO93/15028, this patent required that the alkali metal oxide content should be kept low, but indicated that some alkaline earth silicate fibres could tolerate higher levels of alkali metal oxide than others. However, levels of 0.3% and 0.4% by weight Na₂O were suspected of causing increased shrinkage in materials for use as insulation at 1260°C.

WO97/16386 disclosed fibres usable as refractory insulation at temperatures of up to 1260°C or more. These fibres comprised MgO, SiO₂, and optionally ZrO₂ as principal constituents. These fibres are stated to require substantially no alkali metal oxides other than as trace impurities (present at levels of hundredths of a percent at most calculated as alkali metal oxide). The fibres have a general composition

SiO₂ 65–86%

MgO 14-35%

with the components MgO and SiO₂ comprising at least 82.5% by weight of the fibre, the balance being named constituents and viscosity modifiers.

WO2003/059835 discloses certain calcium silicate fibres in which La₂O₃ or other lanthanide additives are used to improve the strength of the fibres and blanket made from the fibres. This patent application does not mention alkali metal oxide levels, but amounts in the region of ~0.5wt% were disclosed in fibres intended for use as insulation at up to 1260°C or more.

WO2006/048610 disclosed that for AES fibres it was advantageous to mechanical and thermal properties to include small amounts of alkali metal oxides.

The scope of such low biopersistence fibres is limited, in that above about 1300°C they tend to deteriorate in performance.

Alternative low biopersistence fibres that have been proposed are alkaline earth aluminates. Such materials have been suggested as calcium aluminate (EP0586797) and strontium aluminate (WO96/04214). Such fibres are not produced commercially.

The applicants have developed sol-gel fibres comprising aluminosilicates having significant additions of alkaline earth metal oxides or alkali metal oxides and these are subject of International patent application No. PCT/GB2006/004182.

The applicants have now developed an alternative fibre chemistry that provides low biopersistence fibres, for which some fibres at least are capable of providing fibres of comparable thermal performance to aluminosilicate fibres.

Accordingly, the present invention provides melt formed inorganic fibres having the composition:-

Al_2O_3 5 - 90 mol%

K_2O 5 - 90 mol%

SiO_2 5 - 90 mol%

in which $\text{SiO}_2 + \text{Al}_2\text{O}_3 + \text{K}_2\text{O} \geq 50$ mol%, preferably greater than 60 mol%, more preferably ≥ 70 mol%, still more preferably ≥ 80 mol%, or even ≥ 90 mol%.

In particular embodiments such fibres comprise,

Al_2O_3 5 - 34 mol%

K_2O 5 - 34 mol%

SiO_2 61 - 90 mol%

or

Al_2O_3 5 - 78 mol%

K_2O 17 - 90 mol%

SiO_2 5 - 61 mol%

or

Al_2O_3 24 - 90 mol%

K_2O 5 - 17 mol%

SiO_2 5 - 61 mol%

The amount of K_2O may be less than 50 mol%, less than 40 mol%, less than 35 mol% or less than 30 mol%. The amount of K_2O may be greater than 10 mol% or greater than 20 mol%.

The amount of Al_2O_3 may be greater than 10 mol%, and may be greater than 20 mol%.

The amount of SiO₂ may be greater ≥ 20 mol%, ≥ 30 mol%, or ≥ 35 mol%. The amount of SiO₂ may be below 80 mol% or below 70 mol%.

Further features of the invention are apparent from the claims and in the light of the following description.

- 5 The inventors produced a range of potassium aluminosilicate fibres using an experimental rig in which a melt was formed of appropriate composition, tapped through an 8-16 mm orifice, and blown to produce fibre in a known manner. (The size of the tap hole was varied to cater for the viscosity of the melt – this is an adjustment that must be determined experimentally according to the apparatus and composition used).
- 10 The appended results differ from those shown in the priority application, since it was determined that an insufficient melting temperature for some melts resulted in the presence of carbonate [potassium was supplied as potassium carbonate]. Accordingly the results presented in the following tables represent fresh testing of the materials exemplified in the priority application and further examples.
- 15 Table 1 appended hereto shows the fibres made and their compositions in weight percent as determined by x-ray fluorescence analysis.

Table 2 appended hereto shows the fibres made and their calculated compositions in mole percent.

- Table 3 appended hereto shows shrinkage of the fibres made. The shrinkage was measured by
20 the method of manufacturing vacuum cast preforms, using 75g of fibre in 500cm³ of 0.2% starch solution, into a 120 x 65mm tool. Platinum pins (approximately 0.3-0.5mm diameter) were placed 100 x 45mm apart in the 4 corners. The longest lengths (L1 & L2) and the diagonals (L3 & L4) were measured to an accuracy of $\pm 5\mu\text{m}$ using a travelling microscope. The samples were placed in a furnace and ramped to a temperature 50°C below the test
25 temperature at 300°C/hour and ramped at 120°C/hour for the last 50°C to test temperature and left for 24 hours. On removal from the furnace the samples were allowed to cool naturally. The shrinkage values are given as an average of the 4 measurements.

Table 4 appended hereto shows solubility of the fibres made in ppm of the major glass components after a 5 hour static test in a pH~4.5 physiological saline solution.

- 30 A detailed procedure to measure solubility comprises weighing $0.500\text{g} \pm 0.003\text{g}$ of fibre into a centrifuge tube using plastic tweezers. The fibre is usually chopped (6# wire mesh) and

deshotted (hand sieved with 10# wire), but may be bulk or blanket if only small amounts of fibre are available. Each sample is weighed out in duplicate. 25cm³ of simulated body fluid is poured into each centrifuge tube using the graduated dispenser and the tubes sealed. The simulated body fluid is only added to the fibre at the start of the test and comprises the following ingredients in 10 litres of water.

	<u>Reagent</u>	<u>Weight</u>
	NaHCO ₃	19.5 g
	CaCl ₂ ·2H ₂ O	0.29g
10	Na ₂ HPO ₄	1.48g
	Na ₂ SO ₄	0.79g
	MgCl ₂ ·6H ₂ O	2.12
	Glycine (H ₂ NCH ₂ CO ₂ H)	1.18g
	Na ₃ citrate·2H ₂ O	1.52g
15	Na ₃ tartrate·2H ₂ O	1.8g
	Na pyruvate	1.72g
	90% lactic acid	1.56g
	Formaldehyde	15ml
	HCl	~7.5ml

with the HCl added slowly, as this is an approximate figure for pH adjustment to a final figure of ~4.5pH. The simulated body fluid is allowed a minimum of 24hrs to equilibrate and pH is adjusted accordingly after this period.

All of the reagents used are of Analar or equivalent grade and the procedure is carried out using plastic equipment as silica leaching may occur from glassware.

The centrifuge tubes are then placed in a shaking water bath, which is held at 37°C ± 1°C (body temperature) and shaken for 5hrs. The short time of 5 hours was chosen because the solubility of some of these materials is so high that the amount of K₂O leached out can cause the pH to move to higher values, so distorting results, if longer times are used.

After shaking, the two solutions for each fibre are decanted and filtered through Whatman, 110mm diameter no. 40 ashless filter papers into one 50ml bottle. The solution is then submitted for Inductively Coupled Plasma Atomic Emission Spectroscopy (ICP). The oxides tested for will depend on the composition of the fibre being tested. The results are reported as ppm of the relevant oxide.

Referring first to fibre properties, it was initially found that when the molar ratio of $K_2O:SiO_2$ is less than 30:70 then coarse fibres tend to result with fibre diameters well above $10\mu m$ [e.g. $50-250\mu m$]. However subsequently this was found to be too sweeping a generalisation and it was realised that fibres with greater than 40wt% SiO_2 [typically more than 52 mol%] were coarse. Such fibres having more than 40wt% SiO_2 and that are made as fine fibres tend to have a relatively high shrinkage since they tend to be prone to viscous flow. Nevertheless such fibres may be of interest in some applications. If fine fibres [$<10\mu m$ diameter] are required, then viscosity modifiers may be added. Suitable viscosity modifiers may comprise alkali metal oxides, alkaline earth metal oxides, lanthanide elements, boron oxide, fluoride, and indeed any element or compound known in the art to affect the viscosity of silicate glasses. The amounts and type of such viscosity modifiers should be selected to accord with the end use of the fibres. Boron oxide for example is likely to reduce the maximum use temperature although it may be tolerated [see fibre KAS80]. A viscosity modifier that has been found particularly useful is magnesium, which may be added as the oxide or in other form [see for example fibre KMAS1]. Calcium oxide can be tolerated as may strontium oxide. Zirconium oxide and iron oxide may be tolerated in small amounts. In general, the compositions of the present invention appear tolerant of additives although the amount acceptable to achieve desired properties will vary from additive to additive.

Table 3 shows that that the majority of fibres have a relatively low shrinkage at temperatures from $1000^\circ C$ to $1300^\circ C$, with many having low shrinkage even as high as $1500^\circ C$. It appears that those fibres with too much of an excess of K_2O over Al_2O_3 , or too little K_2O in relation to Al_2O_3 show high shrinkages and while usable in applications such as reinforcement or as filler materials in composite articles are not to be recommended for use as high temperature insulation materials.

Close to a 1:1 molar ratio $K_2O:Al_2O_3$ appears to provide good results and for best high temperature performance [low shrinkage after exposure to $1300^\circ C$ for 24 hours] the molar ratio $K_2O:Al_2O_3$ may be less than 1.6, preferably less than 1.5, more preferably less than 1.45; and may be greater than 0.4, preferably greater than 0.8.

Preferably the fibres of the above mentioned compositions have a melting point of greater than 1400°C. Still more preferably the fibres have a melting point of greater than 1600°C, more preferably greater than 1650°C, and still more preferably greater than 1700°C. (For glasses the melting point is defined as the temperature at which the composition has a viscosity of 10 Pa.s).

- 5 It can be seen that the composition KMAS1 melts at 1450°C even though having a relatively low shrinkage at 1400°C. Such a fibre could reasonably be used in insulation applications at temperatures up to, say, 1350°C while still leaving room for temporary excursions to higher temperatures. In contrast, many of the fibres still show low shrinkage at 1500°C and would be suitable for higher temperature applications.
- 10 It should be noted that at elevated temperatures the fibres may have a tendency to lose potassium. While this may limit the applications to which the fibres may be put, there are many applications for which this is not a problem.

The $K_2O - Al_2O_3 - SiO_2$ system contains wide regions of high melting point. For example, as an indication only:-

- 15
- the mineral composition $K_2O \cdot Al_2O_3 \cdot 2SiO_2$ (kaliophilite) has a melting point of ~1800°C
 - the mineral composition $K_2O \cdot Al_2O_3 \cdot 4SiO_2$ (leucite) has a melting point of ~1690°C.

In contrast, there are regions where melting points are lower and some eutectics are formed.

- For ease of manufacture a composition having a low melting point [e.g. close to or at a eutectic] is to be preferred, whereas for best high temperature performance a composition
- 20 having a high melting point is to be preferred. The applicants have found that compositions with about 35-40wt% silica [typically 47-52mol%] are easy to fiberise and form fibres that show low shrinkage at elevated temperatures. Such fibres with about 23-25wt% K_2O [typically 18-22mol%] are particularly easily formed.

The solubility shown in Table 4 indicates that extremely high solubility may be achieved.

- 25 Fibres with $K_2O + Al_2O_3 + SiO_2 > 80\%$ and with less than 20 mol% K_2O , while showing considerably higher solubility than an aluminosilicate fibre [RCF] do not tend to show such high solubility as calcium magnesium silicate fibres. A good solubility for such fibres is found for K_2O in the range 25 mol% to 30 mol%. For fibres having significant additions of some viscosity modifying additives [e.g. Mg] high solubility may be found [See KMAS1].

For comparison, the total solubility of a commercial calcium-magnesium silicate fibre (which is considered biosoluble in a pH 7.4 simulated physiological solution) and a commercial aluminosilicate fibre (which is not considered biosoluble in a pH 7.4 simulated physiological solution) measured under the same conditions were both ~13ppm.

- 5 While static solubilities are only indicative of biopersistence, these results are strong support for the premise that if inhaled the fibres of the invention would not persist as long as commercial aluminosilicate fibres.

For applications where mechanical resilience is important the fibres may be subjected to a heat treatment. One such application is in pollution control devices such as catalytic converters,
10 diesel particulate filters or traps, exhaust pipes and the like. The demands of such an environment are high and in particular the mats and end cones used need to have sufficient resilience to remain in place after exposure to temperatures of 800°C or more [typically 900°C may occur]. Amorphous fibres have been used to make such end cones but tend to lose resilience, and hence their holding pressure against the housing walls, if exposed to
15 temperatures above about 900°C.

By resilience, in this context, is meant the ability of an article to recover its initial shape after deformation. This can be measured by simply looking to the size and shape of an article after deformation to see the extent to which it has returned from the deformed shape towards the undeformed shape. However, in the present context it is most usually measured by looking to
20 the force resisting deformation, since this is an indicator of how well the end cones are likely to stay in place.

WO2004/064996 proposes the use of fibres that are at least partially crystalline or microcrystalline as these are stated to be resistant to shrinkage and more resilient than amorphous fibres, although WO2004/064996 recognises that such crystalline or
25 microcrystalline fibres are more brittle than amorphous fibres. The resilient nature of crystalline or heat treated microcrystalline fibres is well known in the blanket art – see for example WO00/75496 and WO99/46028.

Vitreous fibres such as melt formed silicate fibres are subject of regulation in Europe, and different fibre classes have different hazard classifications and labelling requirements.
30 Conventional vitreous aluminosilicate fibres require more stringent labelling concerning health hazards [as so-called category 2 carcinogens] than do alkaline earth silicate fibres which are exonerated from carcinogen classification.

Directive 97/69/EC which amends Annex 1 of Directive 67/548/EEC and classifies materials as to their potential carcinogenicity (the Hazardous Substances Directive) has two broad chemical categories for silicate fibres of less than 6µm diameter. These categories and their consequences are:-

5

>18% w/w (CaO, MgO, Na ₂ O, K ₂ O, BaO)	Category 3 - requires product warning label showing St. Andrews Cross and indicating potential harm if inhaled – such fibres may be exonerated from labelling requirements if they meet one or more defined tests of low biopersistence.
<18% w/w (CaO, MgO, Na ₂ O, K ₂ O, BaO)	Category 2 – requires product warning label showing skull and crossbones symbol and indicating potential carcinogen if inhaled – cannot be exonerated from labelling requirements

It will be apparent that the presently claimed class of fibres cover compositions that could fall in Category 3 or Category 2, but advantageously, the amount of CaO + MgO + Na₂O + K₂O + BaO is greater than 18% by weight.

- 10 The appended claims limit the fibres to being melt formed fibres. It will be apparent that similar fibres may be capable of manufacture using alternative routes such as sol-gel routes. The present invention also covers such sol-gel fibres provided they comprise 12 mol% or more K₂O.

Table 1										
Fibre reference	Composition weight percent									
	CaO	MgO	SrO	Na ₂ O	K ₂ O	Al ₂ O ₃	SiO ₂	Fe ₂ O ₃	B ₂ O ₃	ZrO ₂
KAS3	0.3	0.1	0.0	0.0	21.9	25.3	51.8	0.0	0.0	0.0
KAS2	0.0	0.0	0.0	0.0	34.0	29.0	35.7	0.0	0.0	0.0
KAS4	0.0	0.0	0.0	0.0	18.5	22.0	58.7	0.0	0.0	0.0
KAS5	0.0	0.0	0.0	0.0	33.0	18.9	45.7	0.0	0.0	0.0
KAS9	0.0	0.0	0.0	0.0	24.4	24.3	49.6	0.0	0.0	0.0
KAS10	0.0	0.0	0.0	0.0	35.5	24.5	39.3	0.0	0.0	0.0
KAS11	0.0	0.0	0.0	0.0	37.1	22.7	37.9	0.0	0.0	0.0
KAS13	0.0	0.0	0.0	0.0	22.9	26.5	49.7	0.0	0.0	0.0
KAS14	0.0	0.0	0.0	0.0	29.8	25.7	42.8	0.0	0.0	0.0

Table 1										
Fibre reference	Composition weight percent									
	CaO	MgO	SrO	Na ₂ O	K ₂ O	Al ₂ O ₃	SiO ₂	Fe ₂ O ₃	B ₂ O ₃	ZrO ₂
KAS15	0.0	0.0	0.0	0.0	37.4	26.8	33.8	0.0	0.0	0.0
KAS12	0.0	0.0	0.0	0.0	30.4	17.7	51.4	0.0	0.0	0.0
KAS17	0.0	0.0	0.0	0.0	27.1	27.0	45.2	0.0	0.0	0.0
KNAS1	0.0	0.0	0.0	6.7	26.2	28.4	37.9	0.0	0.0	0.0
KMAS1	0.0	13.9	0.0	0.0	19.8	16.1	50.0	0.0	0.0	0.0
KNAS2	0.0	0.0	0.0	6.8	24.1	29.2	39.3	0.0	0.0	0.0
KAS18	0.0	0.0	0.0	0.0	23.8	15.3	60.4	0.0	0.0	0.0
KAS25	0.0	0.0	0.0	0.0	35.6	35.9	26.3	0.0	0.0	0.0
KAS27	0.0	0.0	0.0	0.2	37.1	31.3	31.3	0.0	0.0	0.0
KAS28	0.0	0.0	0.0	0.0	32.5	34.6	31.1	0.0	0.0	0.0
KAS29	0.0	0.0	0.0	0.0	34.5	28.8	36.7	0.0	0.0	0.0
KAS30	0.0	0.0	0.0	0.0	25.6	36.3	35.9	0.0	0.0	0.0
KAS31	0.0	0.0	0.0	0.0	20.6	40.1	37.5	0.0	0.0	0.0
KAS32	0.0	0.0	0.0	0.0	25.3	32.3	41.4	0.0	0.0	0.0
KAS33	0.0	0.0	0.0	0.0	17.4	36.7	45.4	0.0	0.0	0.0
KAS34	0.0	0.0	0.0	0.0	20.7	31.1	46.2	0.0	0.0	0.0
KAS35	0.0	0.0	0.0	0.0	15.1	34.9	48.5	0.0	0.0	0.0
KAS36	0.0	0.0	0.0	0.0	14.9	31.6	52.3	0.0	0.0	0.0
KAS37	0.0	0.0	0.0	0.0	31.8	29.4	39.2	0.0	0.0	0.0
KAS40	0.0	0.0	0.0	0.1	21.4	20.3	57.2	0.0	0.0	0.0
KMAS3	0.0	5.1	0.0	0.0	19.4	19.7	55.5	0.0	0.0	0.0
KAS41	0.0	0.0	0.0	0.1	33.8	37.1	27.5	0.0	0.0	0.0
KAS43	0.0	0.0	0.0	0.0	23.7	24.0	50.7	0.0	0.0	0.0
KAS44	0.0	0.0	0.0	0.0	28.5	31.3	40.7	0.0	0.0	0.0
KAS45	0.0	0.0	0.0	0.0	28.0	27.5	44.5	0.0	0.0	0.0
KAS46	0.0	0.0	0.0	0.0	27.7	28.3	43.2	0.0	0.0	0.0
KAS47	0.0	0.0	0.0	0.0	25.1	24.8	49.4	0.0	0.0	0.0
KMAS4	0.1	5.4	0.0	0.1	16.6	19.4	57.1	0.0	0.0	0.0
KAS50	0.0	0.0	0.0	0.1	34.4	35.5	29.6	0.0	0.0	0.0
KAS51	0.0	0.1	0.0	0.1	33.7	41.7	23.4	0.0	0.0	0.0
KAS52	0.0	0.0	0.0	0.1	43.2	26.0	31.3	0.0	0.0	0.0
KAS53	0.0	0.0	0.0	0.1	29.8	42.6	26.7	0.0	0.0	0.0
KAS54	0.0	0.0	0.0	0.1	22.5	42.9	33.9	0.0	0.0	0.0
KAS55	0.0	0.0	0.0	0.2	25.3	39.9	33.3	0.0	0.0	0.0
KAS56	0.2	0.1	0.0	0.2	17.8	48.8	32.5	0.0	0.0	0.0
KSAS1	0.0	0.0	2.4	0.2	24.8	30.3	41.9	0.0	0.0	0.0
KCAS1	2.3	0.1	0.0	0.1	27.5	27.2	42.0	0.0	0.0	0.0
KMAS6	0.0	2.8	0.0	0.2	24.3	30.1	40.7	0.0	0.0	0.0
KAS48	0.0	0.1	0.0	0.1	30.5	32.8	35.9	0.0	0.0	0.0
KAS59	0.3	0.1	0.0	0.2	20.0	45.3	32.5	0.1	0.0	0.0
KCAS2	2.7	0.1	0.0	0.1	20.4	34.0	40.9	0.0	0.0	0.0
KSAS2	0.1	0.1	2.9	0.2	21.4	37.6	37.1	0.0	0.0	0.0
KAS60	0.0	0.0	0.0	0.7	18.1	37.8	42.3	0.0	0.0	0.0
KAS61	0.0	0.1	0.0	0.2	15.9	35.1	46.5	0.1	0.0	0.0
KAS62	0.0	0.1	0.0	0.2	32.0	45.8	21.1	0.1	0.0	0.0

Table 1										
Fibre reference	Composition weight percent									
	CaO	MgO	SrO	Na ₂ O	K ₂ O	Al ₂ O ₃	SiO ₂	Fe ₂ O ₃	B ₂ O ₃	ZrO ₂
KAS63	0.0	0.1	0.0	0.2	24.6	55.0	17.9	0.0	0.0	0.0
KAS65	0.0	0.1	0.0	0.2	24.1	43.0	31.5	0.1	0.0	0.0
KACaSrS02	2.4	0.1	2.2	0.2	24.6	28.9	39.0	0.0	0.0	0.0
KAMgSrS02	0.1	2.5	2.3	0.2	24.2	31.1	39.6	0.0	0.0	0.0
KAS63	0.0	0.1	0.0	0.2	28.5	50.6	21.4	0.0	0.0	0.0
KAS64	0.0	0.1	0.0	0.2	24.2	52.9	22.7	0.0	0.0	0.0
KAS66	0.0	0.1	0.0	0.2	18.0	45.3	35.2	0.0	0.0	0.0
KAS67	0.3	0.0	0.0	0.1	21.6	29.3	49.4	0.0	0.0	0.1
KAS68	0.2	0.0	0.0	0.2	32.3	54.9	13.2	0.0	0.0	0.1
KAS69	0.0	0.0	0.0	0.2	31.7	53.5	15.6	0.0	0.0	0.1
KAS70	0.0	0.0	0.0	0.2	30.7	58.9	11.7	0.0	0.0	0.1
KAS71	0.0	0.0	0.0	0.3	28.7	55.9	16.1	0.0	0.0	0.1
KAS72	0.0	0.0	0.0	0.3	28.4	58.8	12.4	0.0	0.0	0.1
KAS73	0.0	0.0	0.0	0.2	23.6	58.2	17.8	0.0	0.0	0.1
KAS74	0.0	0.0	0.0	0.3	24.1	61.7	13.4	0.0	0.0	0.1
KAS75	0.0	0.0	0.0	0.3	33.1	52.4	16.3	0.0	0.0	0.1
KAS76	0.0	0.0	0.8	0.2	21.0	29.0	48.6	0.0	0.0	0.1
KAS77	0.9	0.0	0.0	0.2	22.1	28.2	49.1	0.1	0.0	0.1
KAS78	0.0	1.0	0.0	0.2	21.1	27.8	49.0	0.1	0.0	0.1
KAS79	0.0	0.0	0.0	0.8	22.5	29.2	48.1	0.1	0.0	0.1
KAS80	0.0	0.0	0.0	0.2	22.9	29.7	47.3	0.0	0.7	0.1
KAS81	0.5	0.1	0.0	0.2	21.2	28.7	49.4	0.0	0.0	0.1
KAS82	0.0	0.2	0.4	0.2	20.7	30.0	48.4	0.0	0.0	0.1
KAS83	0.5	0.1	0.8	0.2	20.7	29.0	48.2	0.0	0.0	0.1
KAS84	0.5	0.1	0.5	0.2	21.2	30.2	47.1	0.0	0.0	0.1
KAS85	1.0	0.1	0.5	0.2	21.3	30.2	47.0	0.1	0.0	0.1
KAS76-2	0.1	0.3	0.9	0.2	20.7	30.1	47.1	0.0	0.0	0.1
KAS77-2	1.0	0.1	0.0	0.2	21.1	30.7	47.0	0.0	0.0	0.1
KAS 76-3	0.0	0.1	0.9	0.3	21.2	29.2	48.3	0.0	0.0	0.1
KAS82-2	0.1	0.1	0.4	0.1	20.4	28.5	50.4	0.1	0.0	0.1
KAS86	1.0	0.1	0.9	0.2	20.7	30.2	46.8	0.1	0.0	0.1

Table 2										
Fibre reference	Composition mol percent									
	CaO	MgO	SrO	Na ₂ O	K ₂ O	Al ₂ O ₃	SiO ₂	Fe ₂ O ₃	B ₂ O ₃	ZrO ₂
KAS3	0.4%	0.2%	0.0%	0.0%	17.2%	18.4%	63.8%	0.0%	0.0%	0.0%
KAS2	0.0%	0.0%	0.0%	0.0%	29.1%	23.0%	47.9%	0.0%	0.0%	0.0%
KAS4	0.0%	0.0%	0.0%	0.0%	14.1%	15.5%	70.3%	0.0%	0.0%	0.0%
KAS5	0.0%	0.0%	0.0%	0.0%	27.0%	14.3%	58.7%	0.0%	0.0%	0.0%
KAS9	0.0%	0.0%	0.0%	0.0%	19.6%	18.0%	62.4%	0.0%	0.0%	0.0%
KAS10	0.0%	0.0%	0.0%	0.0%	29.6%	18.9%	51.5%	0.0%	0.0%	0.0%

Table 2										
Fibre reference	Composition mol percent									
	CaO	MgO	SrO	Na ₂ O	K ₂ O	Al ₂ O ₃	SiO ₂	Fe ₂ O ₃	B ₂ O ₃	ZrO ₂
KAS11	0.0%	0.0%	0.0%	0.0%	31.6%	17.8%	50.6%	0.0%	0.0%	0.0%
KAS13	0.0%	0.0%	0.0%	0.0%	18.3%	19.5%	62.2%	0.0%	0.0%	0.0%
KAS14	0.0%	0.0%	0.0%	0.0%	24.7%	19.7%	55.6%	0.0%	0.0%	0.0%
KAS15	0.0%	0.0%	0.0%	0.0%	32.5%	21.5%	46.0%	0.0%	0.0%	0.0%
KAS12	0.0%	0.0%	0.0%	0.0%	23.9%	12.8%	63.3%	0.0%	0.0%	0.0%
KAS17	0.0%	0.0%	0.0%	0.0%	22.0%	20.3%	57.7%	0.0%	0.0%	0.0%
KNAS1	0.0%	0.0%	0.0%	8.3%	21.5%	21.5%	48.7%	0.0%	0.0%	0.0%
KMAS1	0.0%	22.3%	0.0%	0.0%	13.6%	10.2%	53.9%	0.0%	0.0%	0.0%
KNAS2	0.0%	0.0%	0.0%	8.4%	19.6%	21.9%	50.1%	0.0%	0.0%	0.0%
KAS18	0.0%	0.0%	0.0%	0.0%	17.9%	10.7%	71.4%	0.0%	0.0%	0.0%
KAS25	0.0%	0.0%	0.0%	0.0%	32.4%	30.2%	37.5%	0.0%	0.0%	0.0%
KAS27	0.0%	0.0%	0.0%	0.3%	32.1%	25.1%	42.5%	0.0%	0.0%	0.0%
KAS28	0.0%	0.0%	0.0%	0.0%	28.7%	28.2%	43.1%	0.0%	0.0%	0.0%
KAS29	0.0%	0.0%	0.0%	0.0%	29.1%	22.4%	48.5%	0.0%	0.0%	0.0%
KAS30	0.0%	0.0%	0.0%	0.0%	22.2%	29.1%	48.8%	0.0%	0.0%	0.0%
KAS31	0.0%	0.0%	0.0%	0.0%	17.7%	31.8%	50.5%	0.0%	0.0%	0.0%
KAS32	0.0%	0.0%	0.0%	0.0%	21.1%	24.9%	54.1%	0.0%	0.0%	0.0%
KAS33	0.0%	0.0%	0.0%	0.0%	14.2%	27.6%	57.9%	0.0%	0.0%	0.0%
KAS34	0.0%	0.0%	0.0%	0.0%	17.0%	23.6%	59.4%	0.0%	0.0%	0.0%
KAS35	0.0%	0.0%	0.0%	0.0%	12.2%	26.1%	61.6%	0.0%	0.0%	0.0%
KAS36	0.0%	0.0%	0.0%	0.0%	11.8%	23.2%	65.0%	0.0%	0.0%	0.0%
KAS37	0.0%	0.0%	0.0%	0.0%	26.4%	22.6%	51.0%	0.0%	0.0%	0.0%
KAS40	0.0%	0.0%	0.0%	0.1%	16.5%	14.4%	69.0%	0.0%	0.0%	0.0%
KMAS3	0.0%	8.7%	0.0%	0.0%	14.2%	13.3%	63.7%	0.0%	0.0%	0.0%
KAS41	0.0%	0.0%	0.0%	0.1%	30.4%	30.8%	38.7%	0.0%	0.0%	0.0%
KAS43	0.0%	0.0%	0.0%	0.0%	18.9%	17.7%	63.4%	0.0%	0.0%	0.0%
KAS44	0.0%	0.0%	0.0%	0.0%	23.5%	23.9%	52.6%	0.0%	0.0%	0.0%
KAS45	0.0%	0.0%	0.0%	0.0%	22.7%	20.6%	56.6%	0.0%	0.0%	0.0%
KAS46	0.0%	0.0%	0.0%	0.0%	22.8%	21.5%	55.7%	0.0%	0.0%	0.0%
KAS47	0.0%	0.0%	0.0%	0.0%	20.0%	18.3%	61.7%	0.0%	0.0%	0.0%
KMAS4	0.1%	9.2%	0.0%	0.1%	12.1%	13.1%	65.4%	0.0%	0.0%	0.0%
KAS50	0.0%	0.0%	0.0%	0.1%	30.2%	28.8%	40.8%	0.0%	0.0%	0.0%
KAS51	0.0%	0.2%	0.0%	0.1%	30.8%	35.2%	33.6%	0.0%	0.0%	0.0%
KAS52	0.0%	0.0%	0.0%	0.1%	37.1%	20.6%	42.1%	0.0%	0.0%	0.0%
KAS53	0.0%	0.0%	0.0%	0.1%	26.8%	35.4%	37.7%	0.0%	0.0%	0.0%
KAS54	0.0%	0.0%	0.0%	0.1%	19.5%	34.3%	46.0%	0.0%	0.0%	0.0%
KAS55	0.0%	0.0%	0.0%	0.3%	22.1%	32.1%	45.5%	0.0%	0.0%	0.0%
KAS56	0.3%	0.2%	0.0%	0.3%	15.5%	39.3%	44.4%	0.0%	0.0%	0.0%
KSAS1	0.0%	0.0%	1.8%	0.3%	20.5%	23.1%	54.3%	0.0%	0.0%	0.0%
KCAS1	3.1%	0.2%	0.0%	0.1%	22.4%	20.5%	53.7%	0.0%	0.0%	0.0%
KMAS6	0.0%	5.3%	0.0%	0.2%	19.8%	22.7%	52.0%	0.0%	0.0%	0.0%
KAS48	0.0%	0.2%	0.0%	0.1%	26.0%	25.8%	47.9%	0.0%	0.0%	0.0%
KAS59	0.4%	0.2%	0.0%	0.3%	17.6%	36.7%	44.7%	0.1%	0.0%	0.0%
KCAS2	3.8%	0.2%	0.0%	0.1%	16.9%	26.0%	53.1%	0.0%	0.0%	0.0%
KSAS2	0.1%	0.2%	2.2%	0.3%	18.2%	29.5%	49.4%	0.0%	0.0%	0.0%

Table 2										
Fibre reference	Composition mol percent									
	CaO	MgO	SrO	Na ₂ O	K ₂ O	Al ₂ O ₃	SiO ₂	Fe ₂ O ₃	B ₂ O ₃	ZrO ₂
KAS60	0.0%	0.0%	0.0%	0.9%	15.0%	29.0%	55.1%	0.0%	0.0%	0.0%
KAS61	0.0%	0.1%	0.0%	0.2%	13.1%	26.6%	59.9%	0.0%	0.0%	0.0%
KAS62	0.0%	0.1%	0.0%	0.3%	29.6%	39.2%	30.6%	0.1%	0.0%	0.0%
KAS63	0.0%	0.1%	0.0%	0.3%	23.7%	48.9%	27.0%	0.0%	0.0%	0.0%
KAS65	0.0%	0.1%	0.0%	0.3%	21.2%	35.0%	43.5%	0.1%	0.0%	0.0%
KACaSrS02	3.4%	0.2%	1.7%	0.3%	20.7%	22.4%	51.4%	0.0%	0.0%	0.0%
KAMgSrS02	0.1%	4.8%	1.7%	0.2%	19.6%	23.3%	50.3%	0.0%	0.0%	0.0%
KAS63	0.0%	0.2%	0.0%	0.3%	26.1%	42.8%	30.7%	0.0%	0.0%	0.0%
KAS64	0.0%	0.2%	0.0%	0.3%	22.2%	44.8%	32.6%	0.0%	0.0%	0.0%
KAS66	0.0%	0.2%	0.0%	0.3%	15.6%	36.2%	47.7%	0.0%	0.0%	0.0%
KAS67	0.4%	0.0%	0.0%	0.1%	17.0%	21.3%	61.1%	0.0%	0.0%	0.1%
KAS68	0.3%	0.0%	0.0%	0.3%	30.9%	48.6%	19.8%	0.0%	0.0%	0.1%
KAS69	0.0%	0.0%	0.0%	0.3%	29.9%	46.6%	23.1%	0.0%	0.0%	0.1%
KAS70	0.0%	0.0%	0.0%	0.3%	29.6%	52.4%	17.7%	0.0%	0.0%	0.1%
KAS71	0.0%	0.0%	0.0%	0.4%	27.0%	48.7%	23.8%	0.0%	0.0%	0.1%
KAS72	0.0%	0.0%	0.0%	0.4%	27.7%	52.9%	18.9%	0.0%	0.0%	0.1%
KAS73	0.0%	0.0%	0.0%	0.3%	22.3%	50.9%	26.4%	0.0%	0.0%	0.1%
KAS74	0.0%	0.0%	0.0%	0.4%	23.5%	55.5%	20.5%	0.0%	0.0%	0.1%
KAS75	0.0%	0.0%	0.0%	0.4%	30.8%	45.0%	23.8%	0.0%	0.0%	0.1%
KAS76	0.0%	0.0%	0.6%	0.2%	16.8%	21.4%	60.9%	0.0%	0.0%	0.1%
KAS77	1.2%	0.0%	0.0%	0.2%	17.4%	20.5%	60.6%	0.0%	0.0%	0.1%
KAS78	0.0%	1.8%	0.0%	0.2%	16.7%	20.3%	60.8%	0.0%	0.0%	0.1%
KAS79	0.0%	0.0%	0.0%	1.0%	17.8%	21.4%	59.7%	0.0%	0.0%	0.1%
KAS80	0.0%	0.0%	0.0%	0.2%	18.2%	21.8%	58.9%	0.0%	0.8%	0.1%
KAS81	0.7%	0.2%	0.0%	0.2%	16.7%	20.9%	61.2%	0.0%	0.0%	0.1%
KAS82	0.0%	0.4%	0.3%	0.2%	16.5%	22.1%	60.5%	0.0%	0.0%	0.1%
KAS83	0.7%	0.2%	0.6%	0.2%	16.5%	21.4%	60.3%	0.0%	0.0%	0.1%
KAS84	0.7%	0.2%	0.4%	0.2%	17.0%	22.3%	59.1%	0.0%	0.0%	0.1%
KAS85	1.3%	0.2%	0.4%	0.2%	16.9%	22.2%	58.6%	0.0%	0.0%	0.1%
KAS76-2	0.1%	0.6%	0.7%	0.2%	16.6%	22.4%	59.3%	0.0%	0.0%	0.1%
KAS77-2	1.3%	0.2%	0.0%	0.2%	16.8%	22.6%	58.7%	0.0%	0.0%	0.1%
KAS 76-3	0.0%	0.2%	0.7%	0.4%	16.9%	21.5%	60.3%	0.0%	0.0%	0.1%
KAS82-2	0.1%	0.2%	0.3%	0.1%	16.1%	20.8%	62.3%	0.0%	0.0%	0.1%
KAS86	1.3%	0.2%	0.7%	0.2%	16.5%	22.3%	58.6%	0.0%	0.0%	0.1%

Table 3						
Fibre reference	Shrinkage % at specified temperature °C for 24 hours					
	1000	1100	1200	1300	1400	1500
KAS3				2.3	2.5	2.9
KAS2				1.6	1.7	2.3
KAS4				0.9	1.0	0.4
KAS5	18.5			17.0		
KAS9				1.4	1.5	1.2
KAS10				3.6	3.7	3.6
KAS11	2.4	0.0	5.4	6.3	7.0	6.8
KAS13				0.8	1.1	1.4
KAS14	0.4			1.1	1.1	1.2
KAS15	2.9			2.6	2.6	2.8
KAS12	19.8			19.3		
KAS17				0.8	1.1	1.4
KNAS1	2.1	3.4	4.3			
KMAS1	2.5	2.1	2.2	2.9	3.2	Melt at 1450
KNAS2	1.6	2.2	2.5	4.5	4.4	
KAS18	11.0			10.9		
KAS25	0.9	1.4	1.7	1.5	3.9	5.0
KAS27	1.9	2	2.1	2.2	2.8	2.8
KAS28	1.5	1.4	1.4	1.8	3.0	3.3
KAS29	1.7	1.9	1.9	1.8	1.8	1.9
KAS30	1.4	1.5	1.5	1.1	1.2	1.0
KAS31	2.3	2.4	2.7	3.7	3.8	3.8
KAS32	1.9	1.9	1.7	2.0	2.1	2.3
KAS33	2.1	2.1	2.3	1.9	1.9	2.0
KAS34	1.6	2.4	2.5	3.7	3.8	3.8
KAS35	2.6	5.4		9.7		
KAS36	3.8	4.1		5.2		
KAS37					1.5	1.6
KAS40					0.5	0.5
KMAS3	1.4	1.2	0.8	1.7	1.8	Melted
KAS41					4.6	
KAS43					0.0	0.0
KAS44	0.6	0.0	0.0	0.4	0.0	0.0
KAS45	0.7		0.6	1.3		1.2
KAS46					1.4	0.0
KAS47					1.2	0.0
KMAS4					3.7	Melted
KAS50	1.4	1.6	1.8	2.0	3.0	3.9
KAS51	0.4	0.5	1.1	3.0	4.2	5.3
KAS52	1.0	0.7	0.1	1.3	1.0	0.3
KAS53		1.7			3.3	3.8
KAS54		1.8			1.9	2.0

Table 3						
Fibre reference	Shrinkage % at specified temperature °C for 24 hours					
	1000	1100	1200	1300	1400	1500
KAS55		1.7			2.4	3.1
KAS56	1.5	2.0		2.8	3.3	
KSAS1	0.0	0.0	0.0	0.6	0.0	0.5
KCAS1		0.8			1.1	1.9
KMAS6		0.4			1.4	4.1
KAS48	1.7	1.8	2.0	2.1	2.3	3.1
KAS59	2.4	2.5		3.0	4.9	
KCAS2				2.5	2.4	Melted
KSAS2	1.7	1.7		1.9	2.1	10.4
KAS60	2.5	2.5	2.6	3.8	3.9	3.5
KAS61	1.8	2.3	2.8	2.6	2.7	2.0
KAS62	0.6	0.6	0.7	2.3	3.8	5.3
KAS63	1.0	1.2	1.8	2.5	2.8	3.7
KAS65	2.0	1.8	1.8	1.7	2.3	2.7
KACaSrS02	1.3	1.0	1.0	1.0	4.4	
KAMgSrS02	1.0	1.0	0.9	1.9	4.9	Melted
KAS63	1.3	1.4	1.8	2.5	3.8	4.7
KAS64	2.5	2.7	3.3	3.7	4.0	6.0
KAS66	1.8	1.9	2.4	2.6	2.9	2.6
KAS67	0.7	1.8	1.7	1.8	1.2	1.4
KAS68	6.6					
KAS69	6.0			7.2		
KAS70	6.6					
KAS71	4.7			6.6		
KAS72	6.5			8.5		
KAS73	1.5	1.7	2.4	2.7	3.6	7.1
KAS74	5.6					
KAS75	6.5			8.2		
KAS76	0.2	2.3	1.2	1.2	1.2	1.3
KAS77	0.6	2.7	2.7	2.8	2.8	4.1
KAS78	3.6	3.7	3.8	3.8	3.9	4.1
KAS79	0.0	1.1	1.2	1.3	1.3	1.3
KAS80	0.0	0.3	0.2	0.2	0.1	0.2
KAS81	0.0	1.0	1.0	1.1	1.2	
KAS82	4.0					
KAS83	2.7	3.9	3.8	3.9	4.0	
KAS84	0.0	0.9	0.8	1.0	1.0	
KAS85	4.9					
KAS76-2				6.2		
KAS77-2				0.4	0.4	0.6
KAS 76-3				10.7		
KAS82-2				16.2		
KAS86				15.1		

Table 4								
Fibre reference	Solubility ppm							
	Al ₂ O ₃	CaO	Fe ₂ O ₃		MgO	SiO ₂	K ₂ O	Total
KAS3	0	0	0		0	3	37	40
KAS2	7	0	0		0	9	202	218
KAS4	1	0	0		0	1	17	19
KAS5	0	0	0		0	3	356	359
KAS9	3	0	0		0	2	47	52
KAS10	2	0	0		0	2	460	464
KAS11	0	0	0		0	14	400	414
KAS13	1	0	0		0	2	10	13
KAS14	0	0	0		0	2	101	103
KAS15	1	0	0		0	3	265	269
KAS12	0	0	0		0	14	216	230
KAS17	2	0	0		0	4	44	50
KNAS1	5	0	0		0	6	150	161
KMAS1	1	0	0		0	3	323	327
KNAS2	6	0	0		0	11	74	91
KAS18	2	0	0		0	1	12	15
KAS25	6	0	0		0	8	351	365
KAS27	4	0	0		0	5	303	312
KAS28	12	0	0		0	11	168	191
KAS29	6	0	0		0	7	255	268
KAS30	15	0	0		0	15	97	127
KAS31	11	0	0		0	8	52	71
KAS32	5	0	0		0	6	72	83
KAS33	3	0	0		0	3	334	340
KAS34	2	0	0		0	2	154	158
KAS35	4	0	0		0	3	61	68
KAS36	4	0	0		0	3	28	35
KAS37	5	0	0		0	6	61	72
KAS40	1	0	0		0	1	8	10
KMAS3	1	0	0		3	0	1	5
KAS41	3	0	0		0	3	234	240
KAS43								
KAS44	3	0	0		0	4	38	45
KAS45	1	0	0		0	1	4	6
KAS46	4	0	0		0	3	24	31
KAS47	1	0	0		0	3	161	165
KMAS4	1	0	0		3	1	20	25
KAS50	15	0	0		0	13	21	49
KAS51	12	0	0		0	17	156	185
KAS52	7	0	0		0	5	201	213
KAS53	20	0	0		0	12	66	98
KAS54	1	1	0		0	2	96	100
KAS55	14	1	1		1	12	164	193

Table 4								
Fibre reference	Solubility ppm							
	Al ₂ O ₃	CaO	Fe ₂ O ₃		MgO	SiO ₂	K ₂ O	Total
KAS56	3	0	0		0	2	433	438
KSAS1	12	1	0	1	3	13	16	46
KCAS1	18	2	0		0	23	30	73
KMAS6	5	0	0		5	3	67	80
KAS48	15	0	0		0	17	93	125
KAS59	4	0	0		0	4	137	145
KCAS2	2	1	0		0	2	177	182
KSAS2	6	0	0	2	0	5	38	51
KAS60	1	0	0		0	1	12	14
KAS61	2	0	0		0	3	419	424
KAS62	8	0	0		0	21	287	316
KAS63	7	0	0		0	18	346	371
KAS65	5	0	0		0	5	278	288
KACaSrS02	1	8	0	0	0	3	863	875
KAMgSrS02	4	0	0	7	1	6	237	255
KAS63	14	0	0	0	0	25	181	220
KAS64	9	0	0	0	0	15	201	225
KAS66								
KAS67	3	0	0	0	0	1	7	11
KAS68	1220	0	0	0	0	11	2187	3418
KAS69	101	0	0	0	0	2	557	660
KAS70	1109	0	0	0	0	8	1735	2852
KAS71	96	0	0	1	0	3	512	612
KAS72	667	0	0	0	0	7	2060	2734
KAS73	10	0	0	0	0	3	355	368
KAS74	5	0	0	0	0	4	509	518
KAS75	20	0	0	0	0	5	350	375
KAS76	2	0	0	1	0	2	43	48
KAS77	2	2	0	0	0	2	22	28
KAS78	2	0	0	0	2	2	129	135
KAS79	2	0	0	0	0	2	24	28
KAS80	2	0	0	0	0	1	3	6
KAS81	1	1	0	0	0	1	2	5
KAS82	3	0	0	1	0	3	46	53
KAS83	2	2	0	1	0	3	99	107
KAS84	2	2	0	0	0	2	10	16
KAS85	3	2	0	1	0	3	28	37
KAS76-2	2	0	0	2	0	2	118	124
KAS77-2	2	2	0	0	0	0	4	8
KAS 76-3								
KAS82-2								
KAS86								

The embodiments of the present invention for which an exclusive property or privilege is claimed are defined as follows:

1. Inorganic fibres having the composition:
 Al_2O_3 is ≥ 5 mol%
 K_2O is 12 to 40 mol%
 SiO_2 is 5 to 80 mol%
 in which $\text{SiO}_2 + \text{Al}_2\text{O}_3 + \text{K}_2\text{O} \geq 80$ mol% and ≤ 100 mol%.
2. The inorganic fibres, as claimed in Claim 1, in which the amount of K_2O is less than 30 mol%.
3. The inorganic fibres, as claimed Claim 1, in which the amount of SiO_2 is ≥ 20 mol%.
4. The inorganic fibres, as claimed in Claim 1, in which the amount of SiO_2 is ≥ 30 mol%.
5. The inorganic fibres, as claimed in Claim 1, in which the amount of SiO_2 is ≥ 35 mol%.
6. The inorganic fibres, as claimed in any one of Claims 1 to 5, in which the amount of SiO_2 is below 70 mol%.
7. The inorganic fibres, as claimed in any one of Claims 1 to 6, in which the amount of SiO_2 is greater than 52 mol% and the fibres comprise viscosity modifiers in amounts sufficient to enable fibres of less than 10 μm to be formed.
8. The inorganic fibres, as claimed in Claim 7, in which the viscosity modifier is selected from the group consisting of alkali metal oxides, alkaline earth metal oxides, lanthanide oxides, boron oxide, fluorides, and mixtures thereof.
9. The inorganic fibres, as claimed in Claim 7, in which the viscosity modifier comprises magnesium in oxide or other form.

10. The inorganic fibres, as claimed in any one of Claims 1 to 9, in which the molar ratio $K_2O:Al_2O_3$ is less than 1.5 and greater than 0.4.
11. The inorganic fibres, as claimed in any one of Claims 1 to 10, in which the amount of $CaO + MgO + Na_2O + K_2O + BaO$ is greater than 18% by weight.
12. The inorganic fibres, as claimed in any one of Claims 1 to 11, having the composition:
 - Al_2O_3 is 10 to 50 mol%
 - K_2O is 12 to 40 mol%
 - SiO_2 is 30 to 80 mol%
 in which $SiO_2 + Al_2O_3 + K_2O \geq 80$ mol%.
13. The inorganic fibres as claimed in Claim 12, having the composition:
 - Al_2O_3 is 15 to 40 mol%
 - K_2O is 15 to 30 mol%
 - SiO_2 is 40 to 60 mol%
 in which $SiO_2 + Al_2O_3 + K_2O \geq 90$ mol%.
14. The inorganic fibres as claimed in Claim 13 in which the amount of Al_2O_3 is in the range 25 to 35 mol%.
15. The inorganic fibres, as claimed in any one of Claims 1 to 6, in which the amount of SiO_2 is less than 52 mol%.
16. The inorganic fibres, as claimed in Claim 1, wherein:
 - Al_2O_3 is 5 to 34 mol%
 - K_2O is ≤ 34 mol%
 - SiO_2 is ≥ 61 mol%.
17. The inorganic fibres, as claimed in Claim 1, wherein:
 - Al_2O_3 is 5 to 78 mol%

K_2O is ≥ 17 mol%

SiO_2 is 5 to 61 mol%.

18. The inorganic fibres, as claimed in Claim 1, having the composition:

Al_2O_3 is ≥ 24 mol%

K_2O is ≤ 17 mol%

SiO_2 is 5 to 61 mol%.
19. The inorganic fibres, as claimed in Claim 1, in which the fibres are formed by forming a stream of melt and allowing the stream to contact spinning wheels.
20. The inorganic fibres, as claimed in Claim 1, in which the fibres are formed by forming a stream of melt and allowing the stream to impinge upon a jet of gas.
21. The inorganic fibres, as claimed in Claim 1, in which the fibres are formed from a melt by a rotary process in which the melt escapes through apertures in the circumference of a spinning cup and is blasted by hot gases.
22. The inorganic fibres, as claimed in Claim 1, in which the fibres are formed from a melt by extruding the melt through fine apertures to form filaments.
23. The inorganic fibres, as claimed in Claim 1, which have been at least partially crystallised by heat treatment following firing.
24. The inorganic fibres as claimed in any one of Claims 1 to 23, in which the fibres have a composition having a melting point greater than $1400^\circ C$.
25. The inorganic fibres, as claimed in Claim 1, in which the fibres have a composition having a melting point of greater than $1600^\circ C$.
26. Thermal insulation comprising inorganic fibres as claimed in any one of Claims 1 to 25.

27. The thermal insulation, as claimed in Claim 26, in which the insulation is in the form of a blanket.
28. Mastics comprising inorganic fibres as claimed in any one of Claims 1 to 25.
29. Composite materials comprising inorganic fibres as claimed in any one of Claims 1 to 25.
30. Support structures for catalyst bodies comprising inorganic fibres as claimed in any one of Claims 1 to 25.
31. Friction materials comprising inorganic fibres as claimed in any one of Claims 1 to 25.