

Technical Information

RECOMMENDED CURING, DRYING, AND INITIAL HEATUP SCHEDULE FOR CASTABLES INSTALLED AT TEMPERATURES UNDER 40°F

1. Allow to cure at ambient temperature for 24 hours after the castable is in place. Ambient temperature should be 70°F to 90°F.
2. Keep the castable moist during the ambient curing period by using a membrane curing compound, plastic sheet or a water mist spray.
3. Ambient to 300°F at 50°F per hour
4. Hold at 300°F for six hours
5. Raise to 450°F at 25°F per hour
6. Hold at 450°F for six hours
7. Raise to 600°F at 25°F per hour
8. Hold at 600°F one hour per inch of lining thickness or six hours - whichever is longer.
9. Raise to 1000°F at 50°F per hour
10. Hold at 1000°F one hour per inch of lining thickness if lining is more than nine inches thick.
11. Raise to operating temperature at 100°F per hour

Notes:

1. The dry out of refractory entails more than just following a heating schedule. Issues such as burner sizing and location, exhaust location, air volume and velocity, etc need to be addressed. Resco recommends that an experienced dry out company be consulted.
2. Temperatures should be monitored at the refractory surface at several locations in the unit.
3. If steaming is observed at any time during the schedule, the temperature should be held constant until the steaming subsides. The schedule can resume when steaming ends.
4. If, for any reason, the heating schedule is interrupted by a loss of heat and/or power into the unit, Resco Products recommends that the heating schedule be initiated from the beginning once power and/or heat is restored. At the end user or contractor's discretion, they may elect to attempt to restart the cycle and "stabilize" the lining temperature at the point of interruption. After the lining has been stabilized, the heat up cycle may be resumed as scheduled from that point on. Resco assumes no liability for this procedure, as it is difficult to determine that point at which the entire lining is stable to prevent the possibility of a steam spall.
5. **This schedule is recommended for situations where proper heating equipment and air circulation are used, weep holes are present and unclogged, and the ambient temperature ranges from 60° to 90° F. If all of these parameters are not met, a more conservative dry out schedule is needed. Consult your Resco Products, Inc salesman, the RESCO website (www.rescoproducts.com), or call 888.283.5505.**