SUGGESTED HEATING PROCEDURE
For RESCOBOND CASTABLES AND GUN MIXES

(Including the Rescobond 3000, 3000G, 3000A, 3000AG, Rescobond 17 (TL0743), Rescobond 88 (TL0744), and Rescobond 90 and 90A)

The following schedule is suggested for Resco Products' Rescobond castables and gun mixes, but not including Rescobond AA-22S (see note #4 below). Controlled release of water in the castable is necessary to prevent possible build-up of steam pressure and potential steam spalling:

1. After installation, the heating procedure can begin. It should be noted that, prior to heatup, Rescobond products must not be exposed to freezing temperatures during installation or the setting period.
2. Increase temperature at a rate of **100°F per hour to operating temperature**. This should be considered the ideal heating rate for both single and dual component linings. Temperature hold periods are not required or recommended during the heatup period.
3. Circulation and exhaust of the preheating air is required during heatup, to remove steam that has evolved from the lining.
4. If the unit is not going into operation, but will be cooled down, hold at the operating temperature for a minimum period of 1½ hours per inch (25 mm) of lining thickness up to a maximum period of 8 hours.
5 Allow the lining to cool down naturally; do not exceed 100ºF (38^{o}C) 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, 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.
4. Use the Suggested Heating Procedure specifically for RESCOBOND AA-22S.
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^{o} to 90^{o} 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.**