



## ***Technical Information***

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### **GENERAL GUIDELINES FOR CURING, DRYING AND INITIAL HEATUP FOR DEGASSER SNORKLE ASSEMBLY CAST WITH ProCAST 90-10 XR**

1. Allow to cure in the mold at ambient temperature for 24 hours after the castable is in place. Ambient temperature should be 80°F to 100°F.
2. Allow to cure after the mold is removed at the same conditions as above for 24 hours.
3. Keep the castable moist during the ambient curing period by using a membrane curing compound, plastic sheet or a water mist spray.
4. Drying Schedule:
  - a. Ambient to 300°F at 20°F per hour
  - b. Raise to 750°F at 15°F per hour
  - c. Hold at 750°F for eight hours minimum
5. The structure can then either be cooled at 100°F per hour or installed for use.

#### **NOTES:**

- A. The use of "XR" fibers in ProCAST 90-10 XR does not guarantee a rapid heat-up rate. But, it does significantly reduce the possibility of internal damage during heat-up.
- B. Temperatures should be monitored at the refractory surface at several locations to ensure uniform heating.
- C. The schedule should be controlled initially by the hottest area monitored. If this results in exceeding the recommended rate in the coolest area of the unit, then the coolest area should become the control and the schedule picked up again at that point. The coolest area should come to equilibrium before ramping up to the next temperature.
- D. If steaming is observed at any time during the schedule, the temperature should be held constant until the steaming subsides. The schedule can be resumed when steaming ends.
- E. 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.
- F. **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](http://www.rescoproducts.com)), or call 888.283.5505.**