



Technical Information

CURING SCHEDULE FOR PERMANENTE[®] AF, PERMACAST FG, PERMA-STAR RAM CAST PRODUCTS (PREFORMED SHAPES)

1. Preformed shapes have a low green strength so they should be held at 100°F and left in the mold overnight.
2. Remove forms and raise furnace temperature to 300°F at 50°F per hour.
3. DO NOT HOLD at temperatures below a furnace shell temperature of 250°F unless excessive steam is evident. Continue with temperature increase after steam subsides.
4. Continue increasing temperature until operating temperature is reached or cool at 100°F/hr.
5. Avoid direct flame or arc impingement at all times

NOTES:

- A. 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.
- B. **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.**