

Technical Information

GENERAL GUIDELINES FOR CURING, DRYING AND INITIAL HEATING OF HEAT SET/AIR SET PLASTICS AND RAM MIXES

Curing Schedule: Plastics and ram mixes require no "curing" period. Drying should begin as soon as possible after the installation is completed.

Drying Schedule: Plastics and ram mixes will begin to stiffen slowly after exposure to air. A low temperature drying schedule is recommended to ensure that the lining develops its ultimate properties. "Dry" heat must be utilized.

1. Raise the temperature to 400°F (205°C) at 50°F (28°C) per hour.
2. Hold at 400°F (205°C) for one (1) hour per inch of lining thickness or three hours minimum.
3. The structure can be cooled or raised to normal operating temperature at 100°F (56°C) per hour.

Notes:

- A. A lining previously dried at 400°F (205°C), as described above, can be brought operating temperature using a normal heating rate of 100°F (56°C) per hour.
- B. 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.
- C. **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.**