



Technical Information

SUGGESTED CURING AND HEATING SCHEDULE FOR RESCO BASIC SPECIALTIES (BASIC CASTABLES, GUN MIXES, and RAM MIXES)

**Including PERMANENTE AF, PERMACAST FG, PERMA-STAR
K/R CAST, and RESCOMAG PRODUCTS**

CURING:

1. As a precast shape, basic castables have a low green strength so they should be left in the mold overnight (minimum 12 hours) at a temperature maintained between 80°F and 90°F. Curing at lower temperatures can delay the set of the refractory.
2. As a cast furnace lining, the basic specialty can be heated as soon as practical.

HEATUP:

- 1 For precast shapes, remove forms and leave on base plate for handling.
- 2 Place in dryer set at 300°F. Hold at 300°F for one hour per inch thickness (minimum 6 hours and maximum 12 hours). After hold, increase temperature at a rate of 100°F per hour to operating temperature or maximum dryer temperature.
3. For furnace linings, increase temperature at a rate of 100°F per hour to 500°F to 700°F. Hold at temperature until the shell temperature is above 250°F.
4. If desired, cool or increase to operating temperature at a controlled rate of 100°F per hour. Do not force cool the lining or shapes.

NOTES:

- A. If the heating schedule is interrupted by a loss of heat and/or power into the unit, 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 at a rate of 100°F per hour. Resco assumes no liability for this procedure, as it is difficult to determine that point at which the entire lining is stable.
- B. Avoid direct flame or arc impingement at all times
- 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.**