

Schedule – “B”

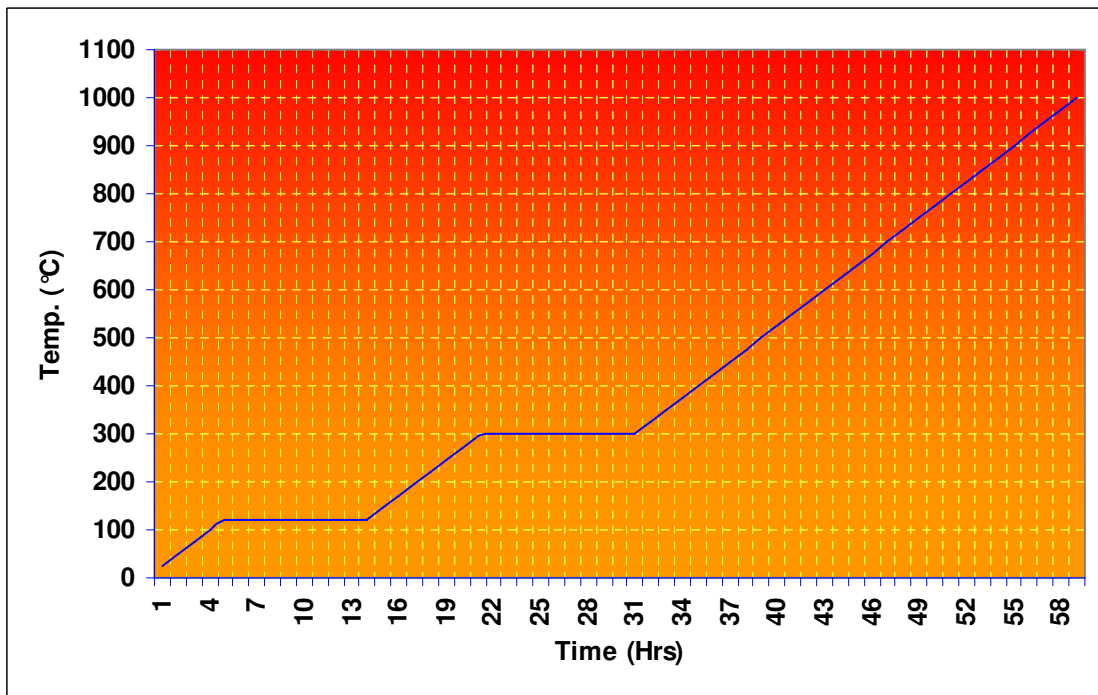
Curing, Drying and Heat-Up Schedule for CASTFLO® Al, CALDE CAST LW / XL / MW Insulating Refractory Castables.

Example: A single shot lining of CASTFLO Al 1000, 250mm thick installed in off-take ducting.

- Curing Time : Min. 24 Hours
- Ambient Temperature: 25°C
- Ramp Rate Section (1): 25°C / Hr
- Holding Temperature (1): 120°C
- Holding Time Section (2): Thickness of Lining $\frac{250 \text{ mm}}{25 \text{ mm / Hr}} = 10$ Hours
- Ramp Rate Section (3): 25°C / Hr
- Holding Temperature (3): 300°C
- Holding Time Section (4): Thickness of Lining $\frac{250 \text{ mm}}{25 \text{ mm / Hr}} = 10$ Hours

- Ramp Rate to Operating Temperature: 25°C / Hr
- Operating Temp. Hold Time: 12 Hrs or 1 Hr / 25 mm of Refractory – which ever is the greater.
- Cooling down Rate: 100°C / Hr

Graphical View



CAUTION

FOLLOWING ANY FIRING SCHEDULE, BE ALERT FOR VISIBLE STEAMING FROM THE REFRACTORY. IF THIS OCCURS, HOLD THE TEMPERATURE CONSTANT UNTIL THE STEAMING DISSIPATES, THEN CONTINUE FROM THE POINT IN THE SCHEDULE AT WHICH THE STEAMING COMMENCED.