

Schedule – “C”

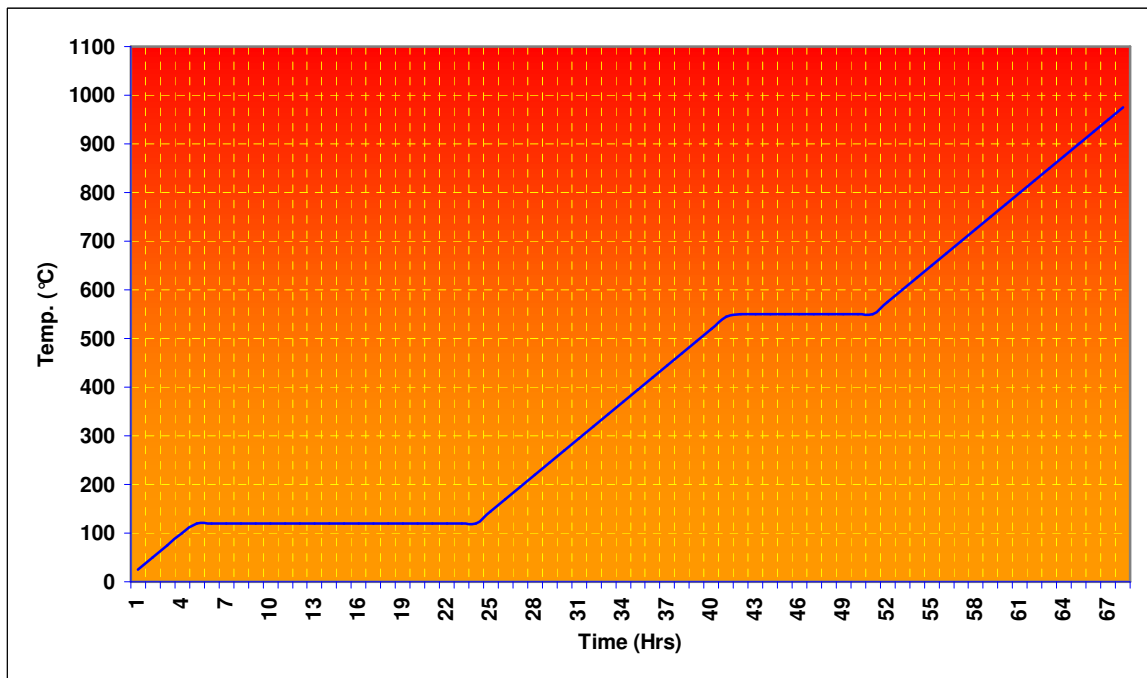
Curing, Drying and Heat-Up Schedule for CASTFLO® AC / AG CALDE CAST / GUN Dense Refractories.

Example: A single shot lining of CASTFLO AL 16, 250mm thick installed in a rotary kiln.

- Curing Time : 24 Hours
- Ambient Temperature: 25°C
- Ramp Rate Section (1): 25°C / Hr
- Holding Temperature (2): 120°C
- Holding Time Section (2): Thickness of Lining $250 \text{ mm} \div 12.5 \text{ mm / Hr} = 20$ Hours
- Ramp Rate Section (4): 25°C / Hr
- Holding Temperature (5): 550°C
- Holding Time Section (5): Thickness of Lining $250 \text{ mm} \div 25 \text{ mm / Hr} = 10$ Hours

- Ramp Rate to Operating Temp.: 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.