

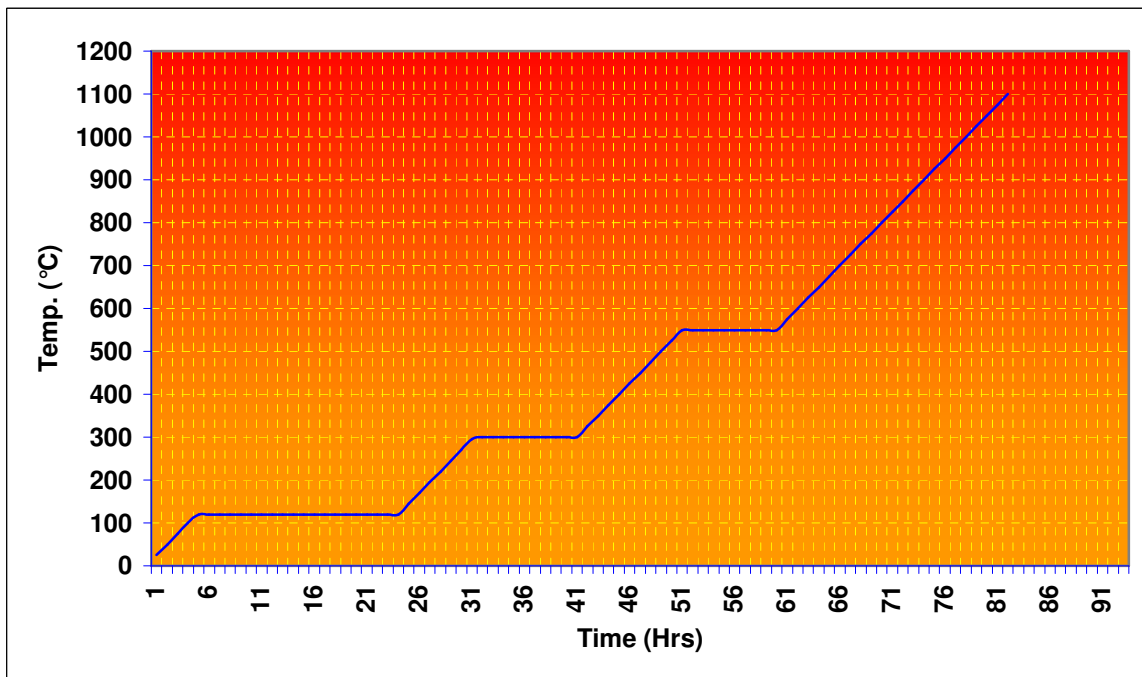
## Schedule – “D”

### Curing, Drying and Heat-Up Schedule for CASTFLO AH / AK / AL, CALDE FLOW / GUN Low Cement Refractory Castables.

Example: A single shot lining of CALDEFLOW AZ, 250mm thick installed in a kiln nose ring.

- Curing Time : 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  $250 \text{ mm} \div 12.5 \text{ mm / Hr} = 20$  Hours
- Ramp Rate Section (3): 25°C / Hr
- Holding Temperature (3): 300°C
- Holding Time Section (4): Thickness of Lining  $250 \text{ mm} \div 25 \text{ mm / Hr} = 10$  Hours
- Ramp Rate Section (5): 25°C / Hr
- Holding Temperature (5): 550°C
- Holding Time Section (6): 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 2 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.**