

Schedule – “B”

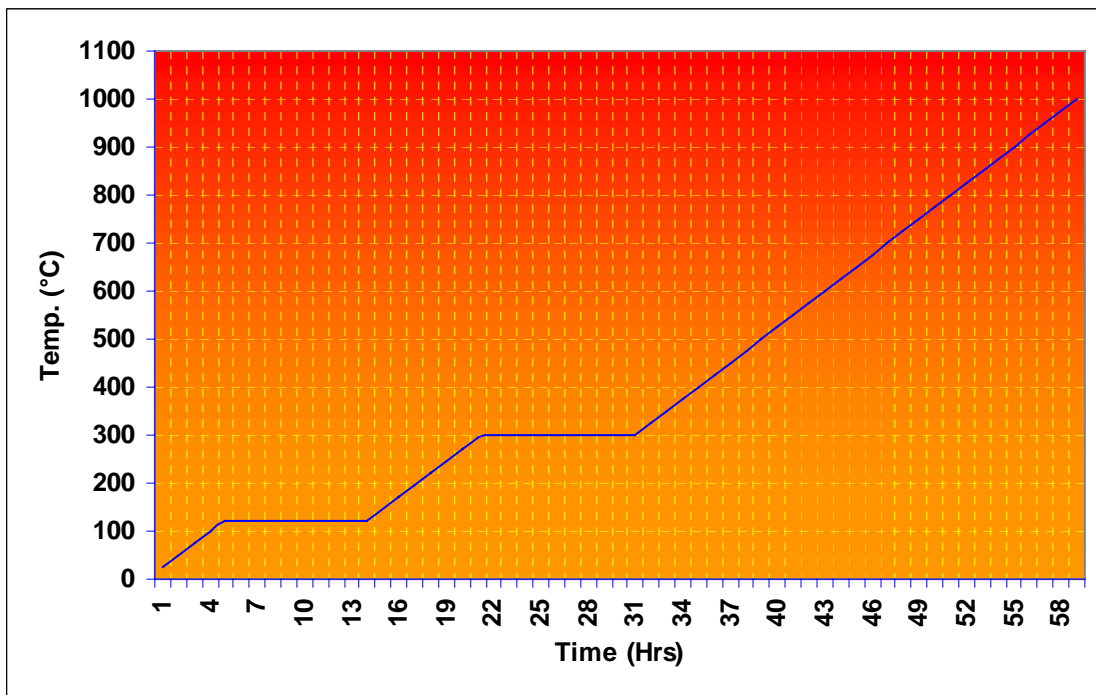
Curing, Drying and Heat-Up Schedule for HANLITE / KERLITE Refractory Castables.

Example: A single shot lining of HANLITE 1000 XG, 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 $250 \text{ mm} \div 25 \text{ mm / Hr} = 10$ Hours
- Ramp Rate Section (3): 25°C / Hr
- Holding Temperature (3): 300°C
- Holding Time Section (4): Thickness of Lining $250 \text{ mm} \div 25 \text{ mm / Hr} = 10$ 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.

These schedules are only a guide line and you should contact **Lafarge Refractories** to obtain a specific heat-up schedule for your application.