



**Plibrico Company LLC**

1010 N. Hooker Street  
Chicago, IL 60622  
Phone: 312-337-9000  
Fax: 312-337-9003  
www.plibrico-usa.com

**Technical Bulletin**

TB-H07-A

# Heat Up Schedules

## Schedule A

This schedule is applicable for field installation bake out for Clay/Air Bond and Phosphate Bond grades\* of:

### **Plibrico Plastic Refractories and Pliram Ramming Mixes**

\* including Plibrico HyRATE Gunning Plastic Refractories

### Instructions

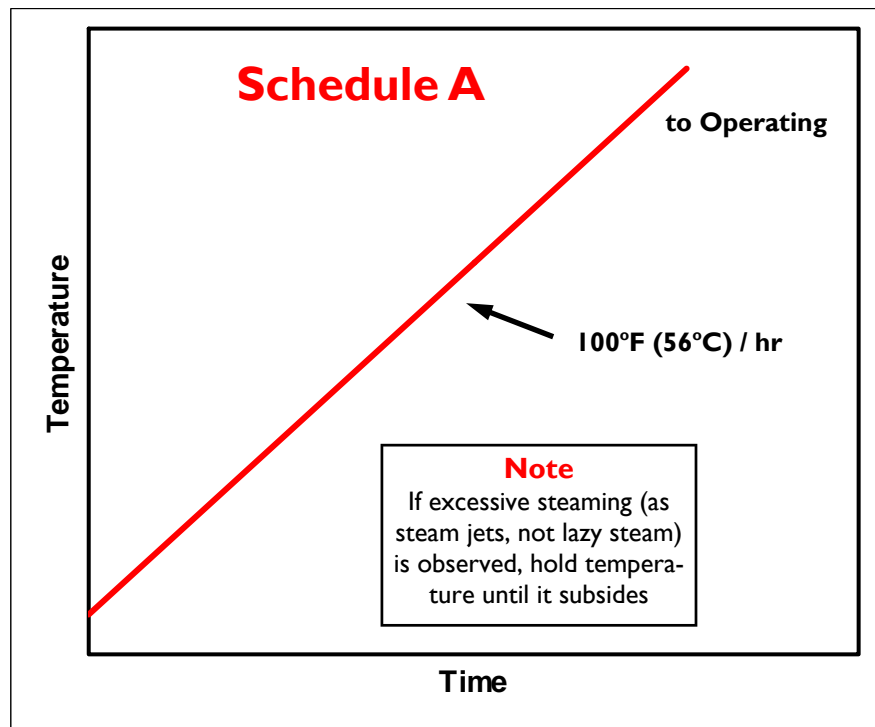
After the plastic is installed, follow the heating rate shown on the chart. The cool down rate (both initial and subsequent), to minimize thermal stress, should not exceed 200°F (110°C) per hour.

Note: For installations of Plibrico Plastic >10" (250mm) thick, please consult the Plibrico Technical Department

#### Schedule A

Ambient to  
Operating Temperature

100°F (56°C) / hr



### WARNING

Note that the target control temperatures are to be measured by thermocouple placement on or within 1/2 in. (12 mm) of the **hot face surface** of the refractory and must be monitored at multiple locations on the refractory within the furnace. Care should be taken to not exceed the heating rates or cause excessive thermal gradients (>50°F (28°C)) throughout the furnace during bake out. The refractory during bake out should not be exposed to flame impingement or spot heating and there should be sufficient air circulation through the furnace. This schedule also assumes that there is path for the moisture driven through the refractory to escape the furnace or vessel such as weep holes or venting. Failure to take any of these parameters into account may result in lining damage or explosion. For questions, please consult your Plibrico representative or the Plibrico Technical or Engineering department.