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Technical Bulletin

TB-H07-ATM1

Heat Up Schedules

Schedule ATM-1

This schedule is applicable for field installation bake out of:

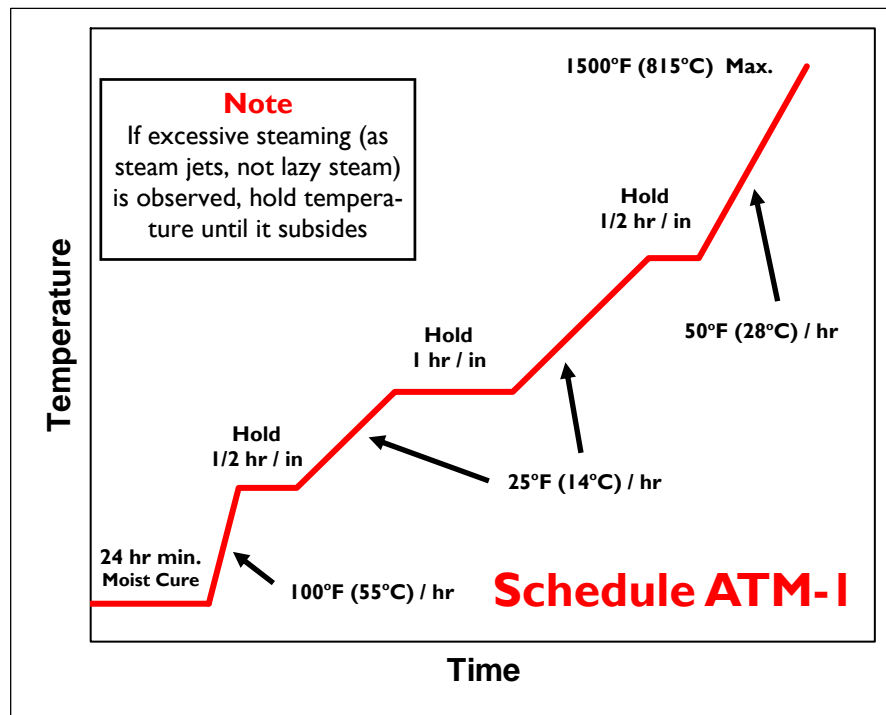
Plicast Al-Tuff & Plicast Al-Shield Castable Refractories and Plibrico Phosphate Bonded Plastic Refractories

Instructions

After the castable has moist cured 24 hrs, follow the heating rate shown on the chart to a maximum of 1500°F (815°C). The cool down rate (both initial and subsequent) should not exceed 200°F (110°C) per hour to minimize thermal stress. All hold times are for *total* refractory lining thickness.

Schedule ATM-1

- Ambient Moist Cure -24 hr
- Ambient to 400°F (205°C)
@ 100°F (55°C) / hr
- Hold at 400°F (205°C)
1/2 hr per 1 in (25mm)
- 400°F (205°C) to 650°F (345°C)
@ 25°F (14°C) / hr
- Hold at 650°F (345°C)
1 hr per 1 in (25mm)
- 650°F (345°C) to 1000°F (540°C)
@ 25°F (14°C) / hr
- Hold at 1000°F (540°C)
1/2 hr per 1 in (25mm)
- 1000°F (540°C) to 1500°F (815°C)
@ 50°F (28°C) / hr
- Hold at 1500°F (815°C) -Max.
1 hr per 1 in (25mm)



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.