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Technical Bulletin

TB-H07-D

Heat Up Schedules

Schedule D

This schedule is applicable for field installation bake out of:

ExoSet UNO and ExoSet UNO G Castable Refractories

Instructions

After the castable or gun mix is installed no formal moist curing is required. After the castable has set, 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.

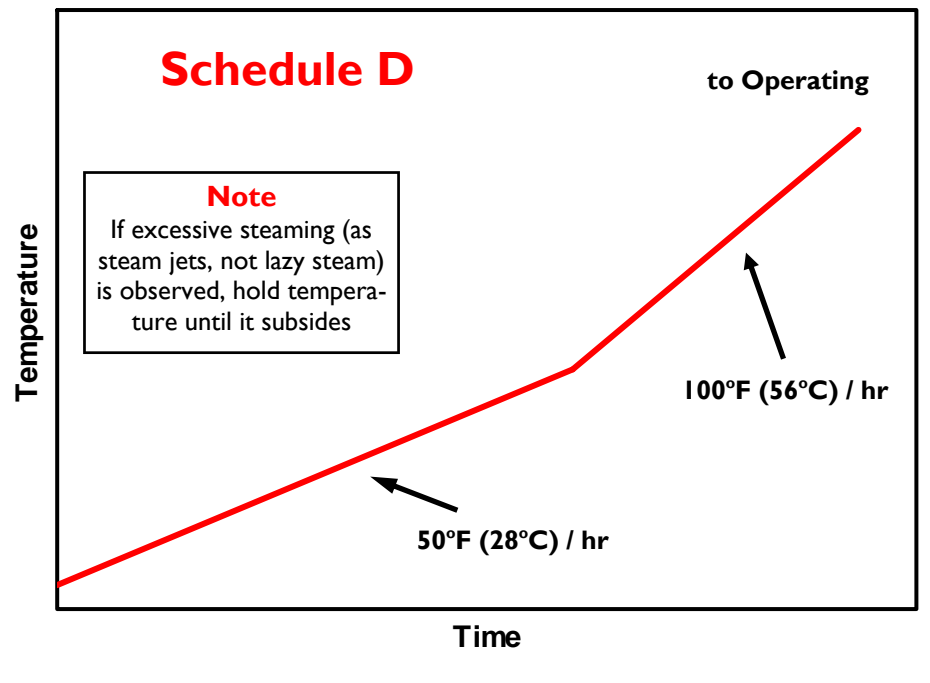
Note: For installations of ExoSet UNO >10" (250mm) thick, please consult the Plibrico Technical Department

Schedule D

Ambient to 1000°F (540°C)
50°F (28°C) / hr

1000°F (540°C) to Operating
100°F (55°C) / hr

Operating Temperature
Hold
1 hr per 1 in (25mm)
of Total Lining Thickness



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.