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Technical Bulletin

TB- H07-E

Heat Up Schedules

Schedule E

This schedule is applicable for field installation bake out of:

Plicast Si-Bond Castables

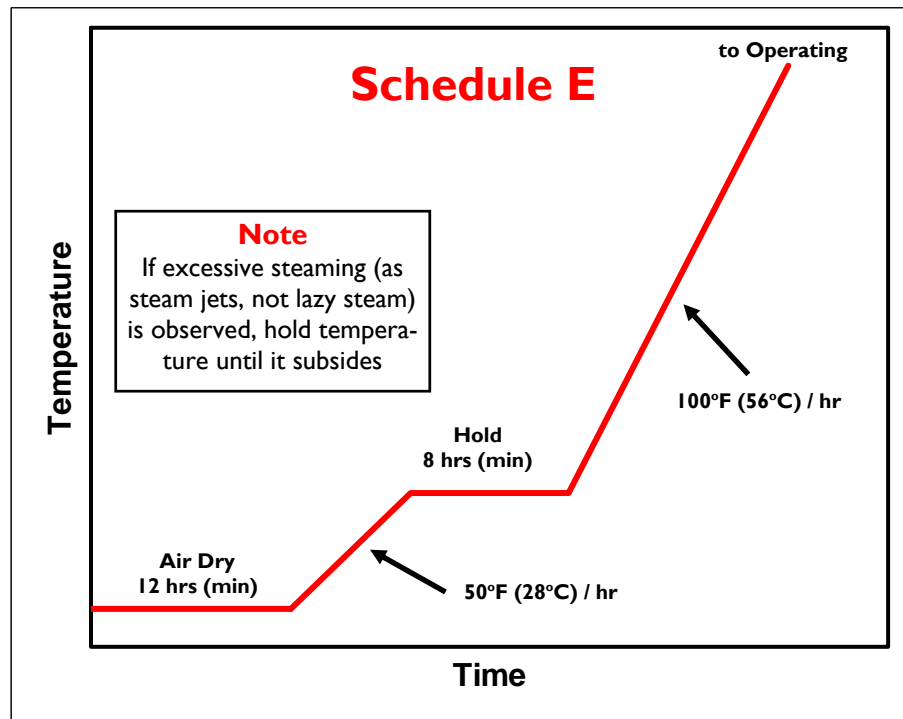
This guide is applicable for installations of up to 9" thickness of Si-Bond castables. For thicker installations, please contact the Plibrico Technical Department. For pre cast shape bake out, please refer to **Schedule PS-SB**

Instructions

After the castable has set and forms are removed, let the castable air dry for 12 hrs. (min) and then follow the heating rate shown on the chart. Note the hold period. The cool down rate (both initial and subsequent) should not exceed 200°F (110°C) per hour to minimize thermal stress.

Schedule E

- Air Dry – 12 hr (min)
- Ambient to 400°F (205°C)
@ 50°F (28°C) / hr
- Hold to 400°F (205°C)
8 hr (min)
- 400°F (205°C) to Operating
@ 100°F (56°C) / hr
- Hold at Operating
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.