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Technical Bulletin

TB- H07-PS-SB

Heat Up Schedules

Schedule PS-SB

This schedule is a general guide for pre cast shape bake out of:

Plicast Si-Bond Castables

Heat up rates and hold times may vary with shape configuration and size and furnace loads. For field installation bake out, please refer to **Schedule E**.

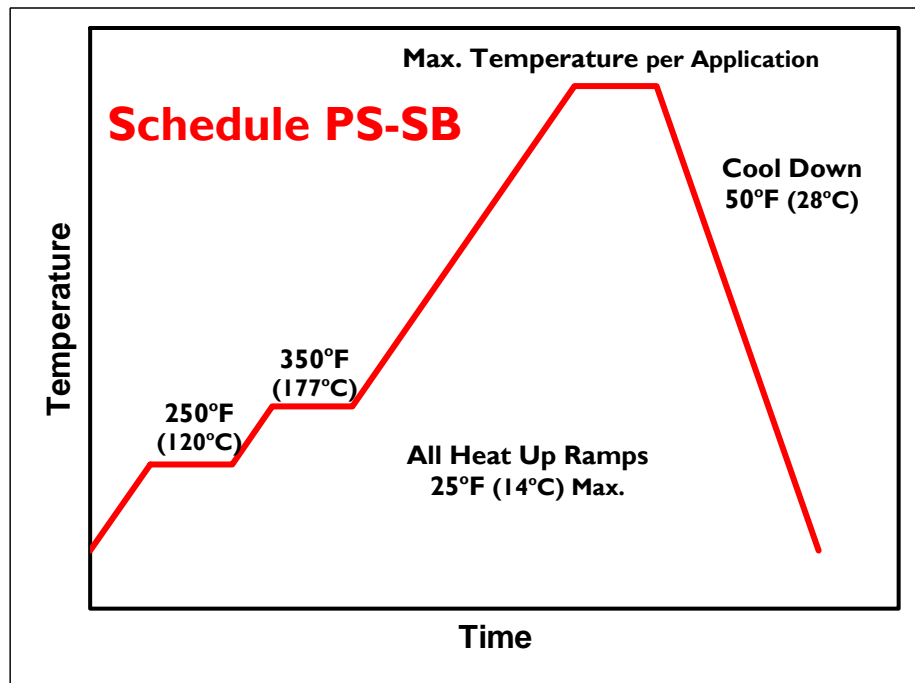
Instructions

After the castable has cured set a minimum 16-24 hrs in the mold, it is recommended after form removal that the shape be allowed to air dry for at least 24 hrs before beginning the heat up.

Schedule PS-SB

- All Ramps
@ 25°F (14°C) / hr (max.)
- Hold @
250°F (120°C)
350°F (177°C)
Max. temperature
- Hold Times (min)
Cross Section

Thickness	Hold
9" (225mm)	8 hr
12" (300mm)	12 hr
18" (460mm)	14 hr
- Cool Down
@ 50°F (28°C) / hr (max.)



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 to allow uniform heating of the refractory load. Failure to take any of these parameters into account may result in shape damage or explosion. For questions, please consult your Plibrico representative or the Plibrico Technical or Engineering department.