



Applications

Heat up Schedule for Low Cement Castables

Following placement, all SPAR castables and gun mixes should be allowed to cure for 24 hours before heat up procedures begin. After this 24 hour period, Spar recommends the following heat up schedule for low cement castables.

- Raise the temperature from ambient to 300°F at 100°F per hour
Hold for 1 hour per inch of lining thickness
- Raise the temperature from 300°F to 600°F at 50°F per hour
Hold for 1 hour per inch of lining thickness
- Raise the temperature from 600°F to 1000°F at 50°F per hour
Hold for 1 hour per inch of lining thickness

The unit may be allowed to cool at this point if it is not being put into operation. Allow the lining to cool naturally. Do not allow cooling rate to exceed 100°F per hour.

If the unit is being put into operation, continue heating to operating temperature at 100°F per hour.

Note: The dry out of refractory involves more than following a heating schedule. Issues such as burner size and placement, exhaust location, air volume, air velocity, thermocouple placement, etc. must be addressed. Spar recommends consulting an experienced dry out company.

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