



## Heat up Schedule for Plastic Refractories

Following Installation, heat can be applied to all SPAR plastics. No air curing is necessary. Once heating has begun, follow through until completion. Stopping the heating cycle may cause the formation of a parting plane in the lining. SPAR recommends the following heating schedule.

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

### Air Set and Heat Set Plastics

- Raise the temperature from 300°F to 1000°F at 75°F per hour

If the operating temperature is above 1000°F, then continue to increase temperature at 75°F per hour to operating temperature or to a minimum temperature of 2200°F. If unit is not going into operation, but will be cooled down, hold at this temperature for 1 hour per inch of lining thickness.

### Phosphate Bonded Plastics

- Raise the temperature from 300°F to 1000°F at 50°F per hour

If the operating temperature is above 1000°F, then continue to increase temperature at 50°F per hour to operating temperature or to a minimum temperature of 2200°F. If unit is not going into operation, but will be cooled down, hold at this temperature 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.

*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.*