

HEATING SCHEDULE FOR DENSE **SPARFIRE** PRODUCTS

After installation, allow to cure at ambient temperature for a minimum of 4 hours or until castable sets up. Ambient temperature should be 50°F to 90°F. If possible allow the lining to cure up to 24 hours to obtain maximum properties.

The dry out/heat-up rate for **SPARFIRE** products can be greatly accelerated over conventional castables.

□ **SINGLE COMPONENT **SPARFIRE** LINING**

○ **Up to 9" thick:**

Increase from ambient to operating temperature at a maximum rate of 200°F per hour with no holds necessary at intermediate temperatures.

○ **Greater than 9" thick**

Increase from ambient to operating temperature at a maximum rate of 150°F per hour with no holds necessary at intermediate temperatures.

□ **TWO COMPONENT LININGS**

○ **Conventional insulating castable backup:**

- Before installing **SPARFIRE** over insulating castable backup, allow insulating castable to cure for 24 hours.
- After **SPARFIRE** installation and cure, increase from ambient to operating temperature at a maximum rate of 150°F per hour.

○ ****SPARFIRE** insulating castable backup:**

- Before installing **SPARFIRE** primary lining over **SPARFIRE** insulating castable backup, allow insulating castable to cure for 24 hours.
- After **SPARFIRE** installation and cure, increase from ambient to operating temperature at a maximum rate of 200°F per hour.

○ **Fiber backup:**

- After fiber installation, **SPARFIRE** can be installed right away.
- After **SPARFIRE** installation and cure, increase from ambient to operating temperature at a maximum rate of 200°F per hour.

□ **WEEP HOLES**

- If the above heating rates are to be followed; two component linings having an insulating castable backup should have weep holes installed in the shell to facilitate removal of water and steam from insulating layer.

□ **EXHAUST OR VENTILATION OF UNIT**

- Adequate exhaust and ventilation of air during heat up is critical to the success of any dry out scenario. However, with **SPARFIRE** linings it can be even more critical because of the higher heating rates. Moisture must not be allowed to become trapped in the unit because it can slow the evolution of water from the lining and cause steam pressure to build within the lining.