

APP. VII
 VII. Initial Refractory Curing Instructions

(AFTER MAJOR
 REFRACT. WORK)

The thermal oxidizer should be heated up according to the following Time-Temperature Schedule, after a minimum of one day of Air Curing.

(AIR BLOWER ONLY) 950°

TIME-HOURS

OXIDIZER TEMPERATURES

DAY 2: 0-1
 1-7 (6 HRS)

7-8

8-9

9-10

10-11

11-12

12-13

13-14

14-15

15-16

16-17

17-18

18-19

19-20

20-21

21-31 (10 HRS.)

31-32

32-33

33-34

34-35

35-36

36-37

Raise to 300°F

Hold at 300°F

Raise to 350°F

Raise to 400°F

Raise to 450°F

Raise to 500°F

Raise to 550°F

Raise to 600°F

Raise to 650°F

Raise to 700°F

Raise to 750°F

Raise to 800°F

Raise to 850°F

Raise to 900°F

Raise to 950°F

Raise to 1000°F

Hold at 1000°F

Raise to 1200°F

Raise to 1400°F

Raise to 1600°F

Raise to 1800°F

Raise to 2000°F

Raise to 2200°F

(ATONL
 STEAM
 @
 1000)

NOTE: Once the curing is started, the thermal oxidizer should not be turned off until curing is complete.

S/D: If the unit has been shut down for any length of time, the following schedule should be followed to prevent excessive damage to the refractory.

Subject to Protective Order
 of 14th Judicial District Court
 No. 91-1145

SL 002027

(1) Extended shutdown one month or longer: Complete cure out in compliance with initial curing cycle. (APP. VII)

(2) One week to one month or longer: Heat system with gas control valve in low fire position for 24 hours. Raise temperature per Cold Start-up Procedure that follows. (APP. ~~VII~~ VII 250°F)

(3) Maximum shutdown one week: Heat system for one hour with gas control valve in low fire position. Raise temperature for Cold Start-up Procedure that follows. (APP. ~~VII~~ VII 250°F)

WHT
HYDRO
BLAST
↓
NOF
E/LA
(MIN
REFR
WORK

WHEN REFRACTORY
GETS WET (HYDROBLASTED)
HOLD #2 INC @ 250°F
FOR 24 HRS. THEN GO
TO #3 (ABOVE)

Smc
6/89

SL 002028

CONFIDENTIAL:
Subject to Protective Order
of 14th Judicial District Court
No. 91-1145

VIII. Refractory Start-Up Schedule

APP. VIII

Cold Start-Up After Initial Cure-Out

(TYPICAL OUTAGE WASHING WITH MIN REFRACT.)

TIME-HOURS

OXIDIZER TEMPERATURES

1 DAY (3 HRS)	(BLINDS OPEN)* 200°F	
0-1		Raise to 500°F
1-4 (3 HRS)		Hold at 500°F
4-5		Raise to 600°F
5-6		Raise to 800°F
6-7		Raise to 1000°F
7-8		Raise to 1200°F
8-9		Raise to 1400°F
9-10	EXTEND.	Raise to 1600°F
10-11		Raise to 1800°F
11-12		Raise to 2000°F
12-13		Raise to 2200°F

< ATM
STM

NOTE: If the unit has been shutdown in excess of one month, the initial curing schedule should be followed.

Hot Start-Up After Temporary Shutdown

Over a period of 30 minutes, gradually increase the temperature to 1000°F. Hold this temperature for one (1) hour. Gradually increase the temperature to 2200°F at a rate of 200°F per hour.

Put Atomic
STREAM
ON
BLINDS.

* No. 3 INC.

SMALL INC'S DON'T
GET WET LIKE
#3 INC.

SL 002029

CONFIDENTIAL:
Subject to Protective Order
of 14th Judicial District Court
No. 91-1145