

Suggested Heat Treating Procedure for Calcium Silicate and Cement boards.

It is suggested that the Material being used be heat treated up to the expected operational temperature. Example: Marinite P to be used at 1100F. Follow the steps below to treat that material to 1100F

A longer and slower heat cycle should be used for thicker material.

Place in furnace at ambient Temperature. (All temperatures in F)

Increase Temp to 300F. Hold for 1 Hour.

Increase Temp to 400F. Hold for 1 Hour.

Increase Temp to 500F. Hold for 2 Hours.

Increase Temp to 750F. Hold for 2 Hours.

Increase Temp to 1000F. Hold for 2 Hours.

Increase Temp to 1100. Hold for 2 Hours.

For CS85 Continue to Increase Temperature in 250 degree F increments and hold for 1-2 hours at each Temperature until you have reached 1800F.

Let oven and material cool down slowly with the door closed at approximately 50F per hour. Material can be removed at 300F.