



BAY STATE CRUCIBLE CO.

Serving the Foundry Industry since 1907

7-3K Mix Crucible Preheat Procedure

1. Center crucible in furnace coil. **Leave crucible empty.**
2. Close furnace exhaust. Non-magnetic disk works well.
3. Turn furnace power to 5%. Leave at 5% for 20 minutes minimum. Water spritz or mist should evaporate quickly from interior crucible surface after 20 minutes.
4. Turn furnace power to 10%. Leave at 10% for 20 minutes minimum. There should be a 4" wide, light pink band on the interior crucible sidewall after 20 minutes. If a small pink band can't be seen after 20 minutes, turn up power small amounts until it can be seen. If the band is more than 6" wide, turn down power slightly during future preheats.
5. Turn furnace to twice the power required at conclusion of step 4 above. Leave at this setting for 20 minutes minimum. The crucible interior bottom radius should glow red after 20 minutes. If bottom radius is only light pink after 20 minutes, turn up power in small amounts till it glows red. If radius is bright orange after 20 minutes, turn down power slightly during future preheats.
6. Open furnace exhaust and turn off furnace power.
7. Load crucible evenly with dense charge. Ingots should be installed vertically with room to expand.
8. Set furnace at desired power to obtain normal melt rate. Melting metal finishes the preheat procedure.

NEVER PREHEAT A CRUCIBLE THEN LET COOL WITHOUT MELTING AT LEAST ONE HEAT 1ST. THIS CAN BUILD STRESS IN THE CRUCIBLE. IF PREHEAT PROCEDURE IS INTERRUPTED YOU MUST START OVER.

THIS PROCEDURE SHOULD ONLY BE USED ON OUR 7-3K MIX.

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