

Slump Profiles

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Fast | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1200 | 0:05 | |
| 4 | 500 | 1225 | 0:12 | |
| 5 | 9999 | 990 | 0:25 | |
| 6 | 600 | 940 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Medium | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1200 | 0:20 | |
| 4 | 500 | 1225 | 0:12 | |
| 5 | 9999 | 990 | 0:30 | |
| 6 | 300 | 960 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Med/Slow | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 300 | 450 | 0:20 | |
| 2 | 300 | 1000 | 0:20 | |
| 3 | 500 | 1200 | 0:30 | |
| 4 | 500 | 1225 | 0:12 | |
| 5 | 9999 | 990 | 1:00 | |
| 6 | 100 | 960 | 2:00 | |
| 7 | 50 | 750 | 0:01 | |
| 8 | 100 | 200 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Slow | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 200 | 250 | 1:00 | |
| 2 | 250 | 500 | 1:00 | |
| 3 | 250 | 750 | 1:00 | |
| 4 | 500 | 1175 | 1:00 | |
| 5 | 500 | 1225 | 0:25 | |
| 6 | 9999 | 960 | 5:00 | |
| 7 | 30 | 760 | 0:01 | |
| 8 | 50 | 200 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Fast | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1150 | 0:05 | |
| 4 | 500 | 1225 | 0:12 | |
| 5 | 9999 | 980 | 0:25 | |
| 6 | 600 | 950 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Medium | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1150 | 0:20 | |
| 4 | 500 | 1225 | 0:13 | |
| 5 | 9999 | 980 | 0:30 | |
| 6 | 300 | 950 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Med/Slow | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 300 | 450 | 0:20 | |
| 2 | 300 | 1000 | 0:20 | |
| 3 | 500 | 1150 | 0:30 | |
| 4 | 500 | 1225 | 0:12 | |
| 5 | 9999 | 980 | 1:00 | |
| 6 | 100 | 950 | 2:00 | |
| 7 | 50 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Slow | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 200 | 250 | 1:00 | |
| 2 | 250 | 500 | 1:00 | |
| 3 | 250 | 750 | 1:00 | |
| 4 | 500 | 1150 | 1:00 | |
| 5 | 500 | 1225 | 0:20 | |
| 6 | 9999 | 950 | 5:00 | |
| 7 | 30 | 760 | 0:01 | |

8 100 200 0:01

8 50 200 0:01

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Fast | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1250 | 0:05 | |
| 4 | 500 | 1280 | 0:12 | |
| 5 | 9999 | 1035 | 0:25 | |
| 6 | 600 | 1015 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Medium | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1250 | 0:20 | |
| 4 | 500 | 1280 | 0:12 | |
| 5 | 9999 | 1035 | 0:30 | |
| 6 | 300 | 1015 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Med/Slow | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 300 | 450 | 0:20 | |
| 2 | 300 | 1000 | 0:20 | |
| 3 | 500 | 1250 | 0:30 | |
| 4 | 500 | 1280 | 0:12 | |
| 5 | 9999 | 1035 | 1:00 | |
| 6 | 100 | 1015 | 2:00 | |
| 7 | 50 | 750 | 0:01 | |
| 8 | 100 | 200 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Slow | Slump | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 200 | 250 | 1:00 | |
| 2 | 250 | 500 | 1:00 | |
| 3 | 250 | 750 | 1:00 | |
| 4 | 500 | 1250 | 1:00 | |
| 5 | 500 | 1280 | 0:20 | |
| 6 | 9999 | 1015 | 5:00 | |
| 7 | 30 | 750 | 0:01 | |
| 8 | 50 | 200 | 0:01 | |

Tac Fuse Profiles

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Fast | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1200 | 0:05 | |
| 4 | 500 | 1325 | 0:15 | |
| 5 | 9999 | 990 | 0:25 | |
| 6 | 600 | 940 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Medium | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1200 | 0:20 | |
| 4 | 500 | 1325 | 0:15 | |
| 5 | 9999 | 990 | 0:30 | |
| 6 | 300 | 960 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Med/Slow | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 300 | 450 | 0:20 | |
| 2 | 300 | 1000 | 0:20 | |
| 3 | 500 | 1200 | 0:30 | |
| 4 | 500 | 1325 | 0:15 | |
| 5 | 9999 | 990 | 1:00 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Slow | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 200 | 250 | 1:00 | |
| 2 | 250 | 500 | 1:00 | |
| 3 | 250 | 750 | 1:00 | |
| 4 | 500 | 1175 | 1:00 | |
| 5 | 500 | 1325 | 0:20 | |

| | | | |
|---|-----|-----|------|
| 6 | 100 | 960 | 2:00 |
| 7 | 50 | 750 | 0:01 |
| 8 | 100 | 200 | 0:01 |

| | | | |
|---|------|-----|------|
| 6 | 9999 | 960 | 5:00 |
| 7 | 30 | 760 | 0:01 |
| 8 | 50 | 200 | 0:01 |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Fast | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1150 | 0:05 | |
| 4 | 500 | 1325 | 0:15 | |
| 5 | 9999 | 980 | 0:25 | |
| 6 | 600 | 950 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Medium | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1150 | 0:20 | |
| 4 | 500 | 1350 | 0:11 | |
| 5 | 9999 | 980 | 0:30 | |
| 6 | 300 | 950 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Med/Slow | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 300 | 450 | 0:20 | |
| 2 | 300 | 1000 | 0:20 | |
| 3 | 500 | 1150 | 0:30 | |
| 4 | 500 | 1325 | 0:15 | |
| 5 | 9999 | 980 | 1:00 | |
| 6 | 100 | 950 | 2:00 | |
| 7 | 50 | 750 | 0:01 | |
| 8 | 100 | 200 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Slow | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 200 | 250 | 1:00 | |
| 2 | 250 | 500 | 1:00 | |
| 3 | 250 | 750 | 1:00 | |
| 4 | 500 | 1150 | 1:00 | |
| 5 | 500 | 1325 | 0:20 | |
| 6 | 9999 | 950 | 5:00 | |
| 7 | 30 | 760 | 0:01 | |
| 8 | 50 | 200 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Fast | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1250 | 0:05 | |
| 4 | 500 | 1430 | 0:15 | |
| 5 | 9999 | 1035 | 0:25 | |
| 6 | 600 | 1015 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Medium | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1250 | 0:20 | |
| 4 | 500 | 1430 | 0:15 | |
| 5 | 9999 | 1035 | 0:30 | |
| 6 | 300 | 1015 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Med/Slow | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 300 | 450 | 0:20 | |
| 2 | 300 | 1000 | 0:20 | |
| 3 | 500 | 1250 | 0:30 | |
| 4 | 500 | 1430 | 0:15 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Slow | Tac Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 200 | 250 | 1:00 | |
| 2 | 250 | 500 | 1:00 | |
| 3 | 250 | 750 | 1:00 | |
| 4 | 500 | 1250 | 1:00 | |

| | | | | | | | |
|---|------|------|------|---|------|------|------|
| 5 | 9999 | 1035 | 1:00 | 5 | 500 | 1430 | 0:20 |
| 6 | 100 | 1015 | 2:00 | 6 | 9999 | 1015 | 5:00 |
| 7 | 50 | 750 | 0:01 | 7 | 30 | 750 | 0:01 |
| 8 | 100 | 200 | 0:01 | 8 | 50 | 200 | 0:01 |

Full Fuse Profiles

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Fast | Full Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1200 | 0:05 | |
| 4 | 500 | 1450 | 0:15 | |
| 5 | 9999 | 990 | 0:25 | |
| 6 | 600 | 940 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Medium | Full Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1200 | 0:20 | |
| 4 | 500 | 1450 | 0:15 | |
| 5 | 9999 | 990 | 0:30 | |
| 6 | 300 | 960 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Med/Slow | Full Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 300 | 450 | 0:20 | |
| 2 | 300 | 1000 | 0:20 | |
| 3 | 500 | 1200 | 0:30 | |
| 4 | 500 | 1450 | 0:15 | |
| 5 | 9999 | 990 | 1:00 | |
| 6 | 100 | 960 | 2:00 | |
| 7 | 50 | 750 | 0:01 | |
| 8 | 100 | 200 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 90 | Slow | Full Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 200 | 250 | 1:00 | |
| 2 | 250 | 500 | 1:00 | |
| 3 | 250 | 750 | 1:00 | |
| 4 | 500 | 1175 | 1:00 | |
| 5 | 500 | 1450 | 1:00 | |
| 6 | 9999 | 960 | 5:00 | |
| 7 | 30 | 760 | 0:01 | |
| 8 | 50 | 200 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Fast | Full Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1150 | 0:05 | |
| 4 | 500 | 1450 | 0:15 | |
| 5 | 9999 | 980 | 0:25 | |
| 6 | 600 | 950 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Medium | Full Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1150 | 0:20 | |
| 4 | 500 | 1470 | 0:16 | |
| 5 | 9999 | 980 | 0:30 | |
| 6 | 300 | 950 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Med/Slow | Full Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 300 | 450 | 0:20 | |
| 2 | 300 | 1000 | 0:20 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Slow | Full Fuse | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 200 | 250 | 1:00 | |
| 2 | 250 | 500 | 1:00 | |

| | | | |
|---|------|------|------|
| 3 | 500 | 1150 | 0:30 |
| 4 | 500 | 1450 | 0:15 |
| 5 | 9999 | 980 | 1:00 |
| 6 | 100 | 950 | 2:00 |
| 7 | 50 | 750 | 0:01 |
| 8 | 100 | 200 | 0:01 |

| | | | |
|---|------|------|------|
| 3 | 250 | 750 | 1:00 |
| 4 | 500 | 1150 | 1:00 |
| 5 | 500 | 1450 | 1:00 |
| 6 | 9999 | 950 | 5:00 |
| 7 | 30 | 760 | 0:01 |
| 8 | 50 | 200 | 0:01 |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | |
|----------------|------------------|--------------------|-------------|
| 82 | Fast | Full Fuse | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |
| 1 | 500 | 450 | 0:10 |
| 2 | 500 | 1000 | 0:10 |
| 3 | 500 | 1250 | 0:05 |
| 4 | 500 | 1500 | 0:15 |
| 5 | 9999 | 1035 | 0:25 |
| 6 | 600 | 1015 | 0:45 |
| 7 | 300 | 750 | 0:01 |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | |
|----------------|------------------|--------------------|-------------|
| 82 | Medium | Full Fuse | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |
| 1 | 400 | 450 | 0:15 |
| 2 | 400 | 1000 | 0:15 |
| 3 | 500 | 1250 | 0:20 |
| 4 | 500 | 1500 | 0:15 |
| 5 | 9999 | 1035 | 0:30 |
| 6 | 300 | 1015 | 1:00 |
| 7 | 150 | 750 | 0:01 |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | |
|----------------|------------------|--------------------|-------------|
| 82 | Med/Slow | Full Fuse | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |
| 1 | 300 | 450 | 0:20 |
| 2 | 300 | 1000 | 0:20 |
| 3 | 500 | 1250 | 0:30 |
| 4 | 500 | 1500 | 0:15 |
| 5 | 9999 | 1035 | 1:00 |
| 6 | 100 | 1015 | 2:00 |
| 7 | 50 | 750 | 0:01 |
| 8 | 100 | 200 | 0:01 |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | |
|----------------|------------------|--------------------|-------------|
| 82 | Slow | Full Fuse | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |
| 1 | 200 | 250 | 1:00 |
| 2 | 250 | 500 | 1:00 |
| 3 | 250 | 750 | 1:00 |
| 4 | 500 | 1250 | 1:00 |
| 5 | 500 | 1500 | 1:00 |
| 6 | 9999 | 1015 | 5:00 |
| 7 | 30 | 750 | 0:01 |
| 8 | 50 | 200 | 0:01 |

Cast Profiles

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | |
|----------------|------------------|--------------------|-------------|
| 90 | Fast | Cast | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |
| 1 | 500 | 450 | 0:10 |
| 2 | 500 | 1000 | 0:10 |
| 3 | 500 | 1200 | 0:05 |
| 4 | 700 | 1500 | 1:00 |
| 5 | 9999 | 990 | 0:25 |
| 6 | 600 | 940 | 0:45 |
| 7 | 300 | 750 | 0:01 |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | |
|----------------|------------------|--------------------|-------------|
| 90 | Medium | Cast | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |
| 1 | 400 | 450 | 0:15 |
| 2 | 400 | 1000 | 0:15 |
| 3 | 500 | 1200 | 0:20 |
| 4 | 700 | 1500 | 1:00 |
| 5 | 9999 | 990 | 0:30 |
| 6 | 300 | 960 | 1:00 |
| 7 | 150 | 750 | 0:01 |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | |
|----------------|------------------|--------------------|-------------|
| 90 | Med/Slow | Cast | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | |
|----------------|------------------|--------------------|-------------|
| 90 | Slow | Cast | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |

| | | | |
|---|------|------|------|
| 1 | 300 | 450 | 0:20 |
| 2 | 300 | 1000 | 0:20 |
| 3 | 500 | 1200 | 0:30 |
| 4 | 700 | 1500 | 1:00 |
| 5 | 9999 | 990 | 1:00 |
| 6 | 100 | 960 | 2:00 |
| 7 | 50 | 750 | 0:01 |
| 8 | 100 | 200 | 0:01 |

| | | | |
|---|------|------|------|
| 1 | 200 | 250 | 1:00 |
| 2 | 250 | 500 | 1:00 |
| 3 | 250 | 750 | 1:00 |
| 4 | 500 | 1175 | 1:00 |
| 5 | 500 | 1475 | 1:25 |
| 6 | 9999 | 960 | 5:00 |
| 7 | 30 | 760 | 0:01 |
| 8 | 50 | 200 | 0:01 |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Fast | Cast | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1150 | 0:05 | |
| 4 | 700 | 1500 | 1:00 | |
| 5 | 9999 | 980 | 0:25 | |
| 6 | 600 | 950 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Medium | Cast | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1150 | 0:20 | |
| 4 | 700 | 1470 | 0:17 | |
| 5 | 9999 | 980 | 0:30 | |
| 6 | 300 | 950 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Med/Slow | Cast | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 300 | 450 | 0:20 | |
| 2 | 300 | 1000 | 0:20 | |
| 3 | 500 | 1150 | 0:30 | |
| 4 | 700 | 1500 | 1:00 | |
| 5 | 9999 | 980 | 1:00 | |
| 6 | 100 | 950 | 2:00 | |
| 7 | 50 | 750 | 0:01 | |
| 8 | 100 | 200 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 96 | Slow | Cast | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 200 | 250 | 1:00 | |
| 2 | 250 | 500 | 1:00 | |
| 3 | 250 | 750 | 1:00 | |
| 4 | 500 | 1150 | 1:00 | |
| 5 | 500 | 1475 | 1:25 | |
| 6 | 9999 | 950 | 5:00 | |
| 7 | 30 | 760 | 0:01 | |
| 8 | 50 | 200 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Fast | Cast | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 500 | 450 | 0:10 | |
| 2 | 500 | 1000 | 0:10 | |
| 3 | 500 | 1250 | 0:05 | |
| 4 | 700 | 1520 | 1:00 | |
| 5 | 9999 | 1035 | 0:25 | |
| 6 | 600 | 1015 | 0:45 | |
| 7 | 300 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> | | |
|----------------|------------------|--------------------|-------------|--|
| 82 | Medium | Cast | | |
| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> | |
| 1 | 400 | 450 | 0:15 | |
| 2 | 400 | 1000 | 0:15 | |
| 3 | 500 | 1250 | 0:20 | |
| 4 | 700 | 1520 | 1:00 | |
| 5 | 9999 | 1035 | 0:30 | |
| 6 | 300 | 1015 | 1:00 | |
| 7 | 150 | 750 | 0:01 | |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> |
|------------|--------------|----------------|
| 82 | Med/Slow | Cast |

| <u>COE</u> | <u>Speed</u> | <u>Process</u> |
|------------|--------------|----------------|
| 82 | Slow | Cast |

| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |
|----------------|------------------|--------------------|-------------|
| 1 | 300 | 450 | 0:20 |
| 2 | 300 | 1000 | 0:20 |
| 3 | 500 | 1250 | 0:30 |
| 4 | 700 | 1520 | 1:00 |
| 5 | 9999 | 1035 | 1:00 |
| 6 | 100 | 1015 | 2:00 |
| 7 | 50 | 750 | 0:01 |
| 8 | 100 | 200 | 0:01 |

| <u>Segment</u> | <u>Rate/Hour</u> | <u>Temperature</u> | <u>Hold</u> |
|----------------|------------------|--------------------|-------------|
| 1 | 200 | 250 | 1:00 |
| 2 | 250 | 500 | 1:00 |
| 3 | 250 | 750 | 1:00 |
| 4 | 500 | 1250 | 1:00 |
| 5 | 500 | 1520 | 1:25 |
| 6 | 9999 | 1015 | 5:00 |
| 7 | 30 | 750 | 0:01 |
| 8 | 50 | 200 | 0:01 |