Nabertherm

MORE THAN HEAT 30-3000 °C

Material-ID	100002
Hersteller	GC
Beschreibung	Reserve
Material Name	Initial MC

	Prozesse	Vortrocknen					Schließen					Vorwärmen					Brennen 1					Brennen 2					Brennen 3					Kühlen				
Programm-nummer	Name	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum
1	Washbrand Pastenopaker NEM	x		550	1		x			360							x	80	960	60	x															
2	Washbrand Pastenopaker	x		550	1		x			360							x	80	940	60	x															
3	Washbrand Pulveropaker NEM	x		660	1		x			120							x	80	960	60	x															
4	Washbrand Pulveropaker	x		600	1		x			120							x	80	940	60	x															
5	Opakerbrand Pastenopaker	x		550	1		x			360							x	80	930	60	x															
6	Opakerbrand Pulveropaker	x		600	1		x			120							x	80	930	60	x															
7	1. und 2. Schulterbrand	x		550	1		x			120							x	80	930	60	x															
8	1. Dentinbrand	x		580	1		x			360							x	55	890	60	x															
9	Korrekturbrand	x		580	1		x			360							x	55	880	60	x															
10	Glanzbrand	x		600	1		x			120							x	55	890	60																
11	Glanzbrand mit Glasur	x		480	1		x			120							x	45	850	60																
12	Korrekturmasse-Brand	x		450	1		x			240							x	45	770	60	x															

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	Processes	Predrying					Closing					Preheating					Firing 1					Firing 2					Firing 3					cooling				
Program number	Name	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum
1	1st Paste Opaque Firing NEM	x		550	1		x			360							x	80	960	60	x															
2	1st Paste Opaque Firing	x		550	1		x			360							x	80	940	60	x															
3	1st Powder Opaque Firing NEM	x		660	1		x			120							x	80	960	60	x															
4	1st Powder Opaque Firing	x		600	1		x			120							x	80	940	60	x															
5	2nd Paste Opaque Firing	x		550	1		x			360							x	80	930	60	x															
6	2nd Powder Opaque Firing	x		600	1		x			120							x	80	930	60	x															
7	1st and 2nd Shoulder Firing	x		550	1		x			120							x	80	930	60	x															
8	1st Dentin Firing	x		580	1		x			360							x	55	890	60	x															
9	2nd Dentin Firing	x		580	1		x			360							x	55	880	60	x															
10	Glaze Firing	x		600	1		x			120							x	55	890	60																
11	Glaze firing with glaze powder	x		480	1		x			120							x	45	850	60																
12	Correction powder firing	x		450	1		x			240							x	45	770	60	x															