Nabertherm

MORE THAN HEAT 30-3000 °C

Material-ID	100040
Hersteller	Sagemax
Beschreibung	Reserve
Material Name	NexxZr Glaze Spray

	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	1. Brand (Diffusionsbrand)						x		400	60							x	40	820	300		X	20	920	210							x	50	450		
2	2. Brand (Individualisierungsbrand)						x		400	60							x	50	920	120												x	50	450		
3	Alternative Brandführung						x		400	60							x	40	920	210												x	50	450		

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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 firing (diffusion firing)						x		400	60							x	40	820	300		X	20	920	210							x	50	450		
2	2nd firing (individualization firing)						x		400	60							x	50	920	120												x	50	450		
3	Alternative firing						x		400	60							x	40	920	210												x	50	450		