



Segment	Start	Stop	Grade/min	Timp	OBS.
1	0	400	10		
2	400	1000	17.5	30 min	
3	1000	1530	4		
4	1530	1530	0	120	Holding
5	1530	800		-12.2	END
6	800	400			Natural cooling

- 800 celsius = program end
- 6-9 units holding time 2h30min
- 10 units holding time 3h