

CHINA PYRAMID PROGRAMME

USING FRIT, SCRAP, PATTIES OR BULLSEYE BILLETS

	$^{\circ}\text{C}$ per hour	$^{\circ}\text{C}$	Hold(m)
1	55	93	360*
2	55	677	30
3	332	843	60
4	FULL	516	210
5	6	393	0
6	13	346	0
7	66	24	0

* This time can vary. Set the controller to ensure that you are present when the casting reaches top temperature to allow for a visual inspection of the piece.