



WORK INSTRUCTION

Sunbeam Exo-Gas Annealing Furnace

REVISION: 00

PROCEDURE NO.: WI-8.2.4.34

DATE EFFECTIVE: 05/28/09

Annealing Temperatures and Speeds for the Sunbeam Exo-Gas Annealing Furnace

(Temperaturas y Velocidades Para el Sunbeam Exo-Gas Annealing Furnace)

Material <i>(Material)</i>	Temperature <i>(Temperatura)</i>	Speed <i>(Velocidad)</i>
Incoloy	1950F to 2050F	6" per minute <i>(6" por minuto)</i>
Stainless Steel	1950F to 2050F	6" per minute <i>(6" por minuto)</i>
Steel	1800F to 1820F	6" per minute <i>(6" por minuto)</i>
Copper	1650F to 1675F	13" per minute <i>(13" por minuto)</i>

REVISION HISTORY

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	05/28/09	All	Initial release

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
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