



Work Instruction

Infrared Department Kiln Program Selection

Revision: 00

Procedure No.: WI-8.2.4.52

Date Effective: 6/6/2013

Nabertherm N300 Kilns

Program	Intended Use
1	Ceramic Heaters, Alumina Plates with Glaze
3	Alumina Tape without Glaze
5	VS Glow Ceramic Housings, CRF Heaters



Work Instruction

Infrared Department Kiln Program Selection

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Nabertherm W1000 Kiln

Program	Intended Use
1	Ceramic Heaters, Alumina Plates with Glaze
2	VS Glow Ceramic Housings, CRF Heaters



Work Instruction

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Revision: 00

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Nabertherm Flatbed Kiln

Program	Intended Use
2	GEM Tubes Before Painting with Gold, GEM Tubes with Gold, Alumina Plates for KTG with Gold, VS Glow Housings with Gold
5	GEM Tubes Before Painting with White Ceramic, GEM Tubes with White Ceramic
9	Ceramic Heaters with External Thermocouple and VSR Heaters Using CRM-101-146 (China Clay) and SEA-110-102 (Aremco #642) Adhesive Potting Mixture

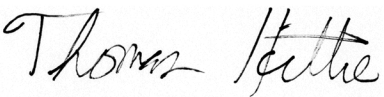
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For kiln firing procedures, see WI-8.2.4.30. This procedure is intended to control the instructions posted by each kiln when necessary. Some kilns have only one program, and some kilns have a very descriptive user interface; these kilns do not require posted instructions to determine which program is to be used on which kind of job. It is up to the Ceramic Infrared Product Manager to ensure that only the appropriate page(s) of the latest revision of this work instruction is posted by each kiln that requires it.

Revision History

Revision Level	Date of Revision	Sections	Description of Change	Initial
00	6/6/2013	All	Initial Release	TCH

Authorization

Position	Held By	Signature
Product Manager	Thomas Hittie	
Senior Management Representative	Abraham Joseph	