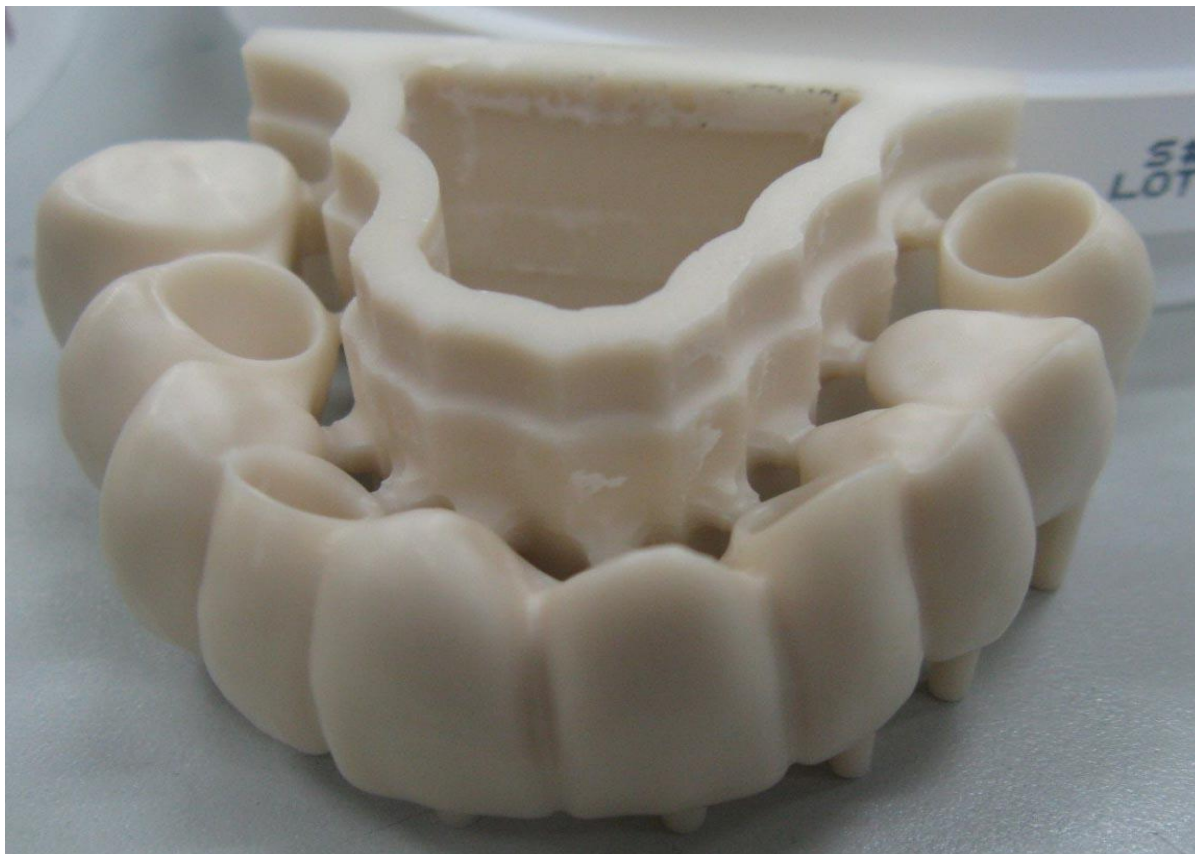


for NexxZr™ T and NexxZr™ S

Stage	Program	Rate/Minute	Time (Minutes)	Units in Furnace
1	Room Temperature ~ 250°C	2 °C/Minute	115	
2	250 ~ 1520°C	6 °C/Minute	212	1--5
		5 °C/Minute	254	6--10
		4 °C/Minute	318	11--15
		3 °C/Minute	423	16--50
3	1,520°C ~ 1,520°C	0°C/Minute	120	1~10
			150	11~50
4	1,520°C ~ 80°C	Natural Cooling		



* When sintering large bridges as pictured above at stage 3 (1,520°C) the hold time should be increased to 3 hours.