



Segment	Start	Stop	Grade/min	Time	OBS.
1	0	1200	2.5		
2	1200	1200	0	30 min	
3	1200	1300	2		
4	1300	1480	8		
5	1480	1480	0	120	Holding
6	1480	800	-8		
7	800	40			END

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

