

# SUGGESTED BURNOUT CYCLES

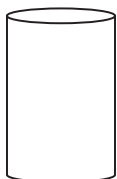
## 5 Hour Cycle



2-1/2" x 2-1/2"  
(63 x 63 mm)

1 hour - 300°F / 149°C  
1 hour - 700°F / 371°C  
2 hour - 1350° / 732°C  
1 hour - Casting Temp.

## 8 Hour Cycle



3-1/2" x 4"  
(89 x 100 mm)

2 hour - 300°F / 149°C  
2 hour - 700°F / 371°C  
3 hour - 1350°F / 732°C  
1 hour - Casting Temp.

## 12 Hour Cycle



4" x 8"  
(100 x 200 mm)

2 hour - 300°F / 149°C  
2 hour - 700°F / 371°C  
2 hour - 900°F / 482°C  
4 hour - 1350°F / 732°C  
2 hour - Casting Temp.