

pulse & pulse interface

Pressing Parameters Guide

Pulse and Pulse Interface: Parameters for Pressing

	100g/2g ingot	200g/2g ingot	200g/5g ingot	300g/2g ingot
Starting Temp.	700°C	700°C	700°C	700°C
Temp. Increase	60°C/min.	60°C/min.	60°C/min.	60°C/min.
Final Temp.	915°C	920°C	925°C	950°C
Holding Time	18 min.	20 min.	20 min.	20 min.
Pressing Time**	6 min.	8 min.	8 min.	8 min.*
Pressure	PP 100: 4.5	PP 100: 4.5	PP 100: 4.5	PP 100: 4.5
	VP 300: 3.0	VP 300: 3.0	VP 300: 3.0	VP 300: 3.0
	EP 500: 4.5 bar	EP 500: 4.5 bar	EP 500: 4.5 bar	EP 500: 4.5 bar
Stop Speed	EP 600-150	EP 600-150	EP 600-150	EP 600-150
Cooling Time	YHN: 5 min.	YHN: 5 min.	YHN: 5 min.	YHN: 5 min.
	WHN: 0 min.	WHN: 0 min.	WHN: 0 min.	WHN: 0 min.
	N: 0 min.	N: 0 min.	N: 0 min.	N: 0 min.
	NP: 5 min.	NP: 5 min.	NP: 5 min.	NP: 5 min.

Ingots and plungers are not pre-heated

Yellow High Noble (YHN)
 White High Noble (WHN)
 Noble Alloy (N)
 Non Precious Alloy (NP)

Note: Pressing time for time press is dependent upon amount of material being processed.
 Any other furnaces call technical department.

*When processing 300g rings follow manufacturer guidelines.
 **With the EP500/EP600, pressing time is established automatically.