

- 1 Shop Test
- 2 Boeing D6-49327 Empty*
- 3 Test Reciepe
- 4 Cold Weather
- 5 Pressure Up and Down
- 6
- 7 PMT-F7G
- 8
- 9 NB321
- 10
- 11 AX-3300
- 12
- 13 PMT-F5
- 14
- 15 PMT-F7 + CORE
- 16
- 17 EA9394 / C-2
- 18
- 19 MOLD POST CURE
- 20
- 21 NB321 + CORE
- 22
- 23
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- 49
- 50

Recipe Name

NB321

Step Name

Initialize

1

Prev

Next

Hold Time

Step Time

1

Time Units

Minutes

Vacuum

Set Point

29

Tolerance

2.00

Pressure

Set Point

0

Ramp Rate

3.00

Temperature

Set Point

70

Ramp Rate

2.00

Control TC

Air TC

Part Window

100

System Enables

Fan On

Press On

Temp On

Vac On

Terminating Event #1

Terminate On

Time

Condition

Greater Than ">"

Goal

1

TC Criteria

AIR TC

OR

Terminating Event #2

Terminate On

NONE

Condition

Less Than "<"

Goal

0

TC Criteria

AIR TC

- 1 Shop Test
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- 48
- 49
- 50

Recipe Name

NB321

Step Name

Ramp

2

Prev

Next

Hold Time

Step Time

0

Time Units

Minutes

Vacuum

Set Point

29

Tolerance

2.00

Pressure

Set Point

50

Ramp Rate

2.00

Temperature

Set Point

275

Ramp Rate

3.00

Control TC

Leading TC

Part Window

100

System Enables

Fan On

Press On

Temp On

Vac On

Terminating Event #1

Terminate On

Temperature

Condition

Greater Than ">"

Goal

268

TC Criteria

LAGGING TC

AND

Terminating Event #2

Terminate On

Pressure

Condition

Greater Than ">"

Goal

48

TC Criteria

AIR TC

Setup TC & Recipe

Setup Vacuum

Operate Screen

System Screen

Trend Screen

Main Screen

Print Screen

Alarm Screen

- 1 Shop Test
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- 49
- 50

Recipe Name

NB321

Step Name

Soak

3

Prev

Next

Hold Time

Step Time

120

Time Units

Minutes

Vacuum

Set Point

29

Tolerance

2.00

Terminating Event #1

Terminate On

Time

Condition

Greater Than ">"

Goal

120

TC Criteria

AIR TC

Terminating Event #2

Terminate On

NONE

Condition

Less Than "<"

Goal

0

TC Criteria

AIR TC

OR

Pressure

Set Point

50

Ramp Rate

2.00

Temperature

Set Point

275

Ramp Rate

3.00

Control TC

Average TC

Part Window

100

System Enables

Fan On

Press On

Temp On

Vac On

- 1 Shop Test
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Recipe Name

NB321

Step Name

Cool Under Pressure

4

Prev

Next

Hold Time

Step Time

0

Time Units

Minutes

Vacuum

Set Point

29

Tolerance

2.00

Terminating Event #1

Terminate On

Temperature

Condition

Less Than "<"

Goal

140

TC Criteria

LEADING TC

Terminating Event #2

Terminate On

NONE

Condition

Less Than "<"

Goal

0

TC Criteria

AIR TC

OR

Pressure

Set Point

50

Ramp Rate

3.00

Temperature

Set Point

100

Ramp Rate

3.00

Control TC

Air TC

Part Window

100

System Enables

Fan On

Press On

Temp On

Vac On



Previous
Recipe

9

Next
Recipe

- 1 Shop Test
- 2 Boeing D6-49327 Empty*
- 3 Test Reciepe
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- 49
- 50

Recipe Name

NB321



Step Name

Depressurize

6



Prev

Next

Hold Time

Step Time

0

Time Units

Minutes

Vacuum

Set Point

29

Tolerance

2.00

Terminating Event #1

Terminate On

Temperature

Condition

Less Than "<"

Goal

120

TC Criteria

LEADING TC

Terminating Event #2

Terminate On

Pressure

Condition

Less Than "<"

Goal

2

TC Criteria

AIR TC

AND

Pressure

Set Point

0

Ramp Rate

5.00

Temperature

Set Point

100

Ramp Rate

3.00

Control TC

Air TC

Part Window

100

System Enables

Fan On

Press On

Temp On

Vac On

Setup
TC & Recipe

Setup
Vacuum

Operate
Screen

System
Screen

Trend
Screen

Main
Screen

Print
Screen

Alarm
Screen

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- 49
- 50

Recipe Name

NB321

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Step Name

End

6

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Prev

Next

Hold Time

Step Time

0

Time Units

Minutes

Vacuum

Set Point

29

Tolerance

2.00

Pressure

Set Point

0

Ramp Rate

5.00

Temperature

Set Point

100

Ramp Rate

3.00

Control TC

Air TC

Part Window

20

System Enables

Fan Off

Press Off

Temp Off

Vac Off

Terminating Event #1

Terminate On

Temperature

Condition

Less Than "<"

Goal

100

TC Criteria

AIR TC

AND

Terminating Event #2

Terminate On

Pressure

Condition

Less Than "<"

Goal

1

TC Criteria

AIR TC

Setup TC & Recipe

Setup Vacuum

Operate Screen

System Screen

Trend Screen

Main Screen

Print Screen

Alarm Screen