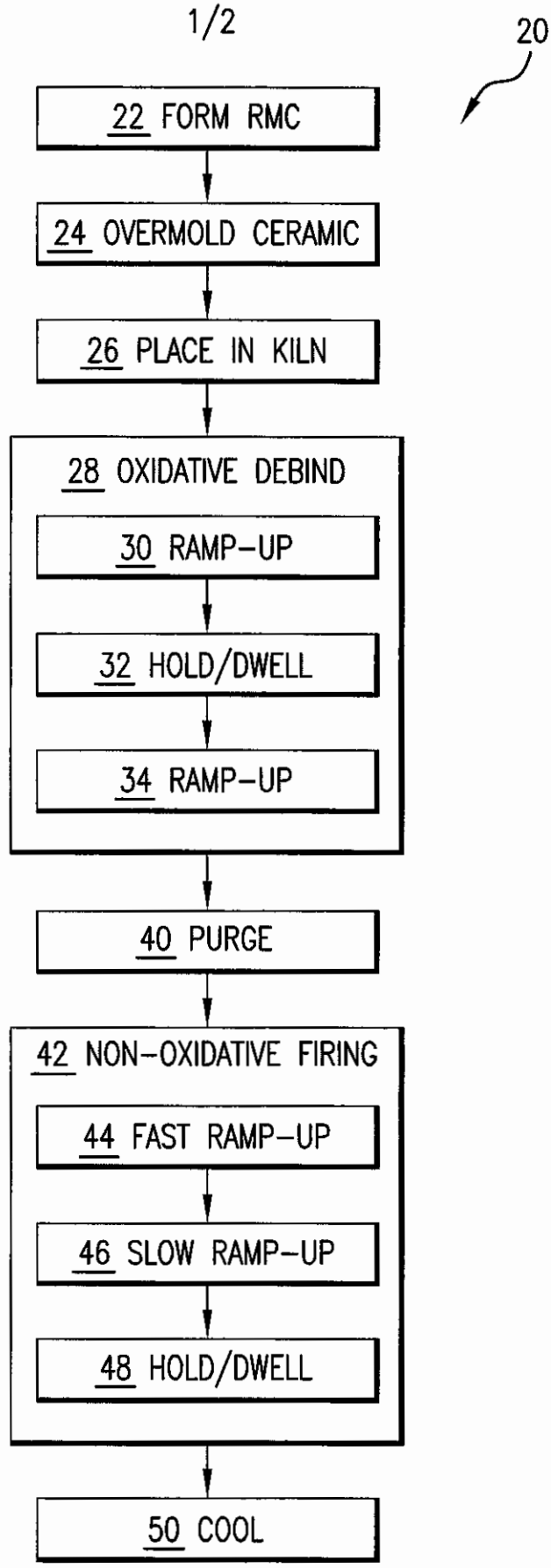

20
22 FORM RMC
24 OVERMOLD CERAMIC
26 PLACE IN KILN
28 OXIDATIVE DEBIND
30 RAMP-UP
32 HOLD/DWELL
34 RAMP-UP
40 PURGE
42 NON-OXIDATIVE FIRING
44 FAST RAMP-UP
46 SLOW RAMP-UP
48 HOLD/DWELL
50 COOL

FIG. 1

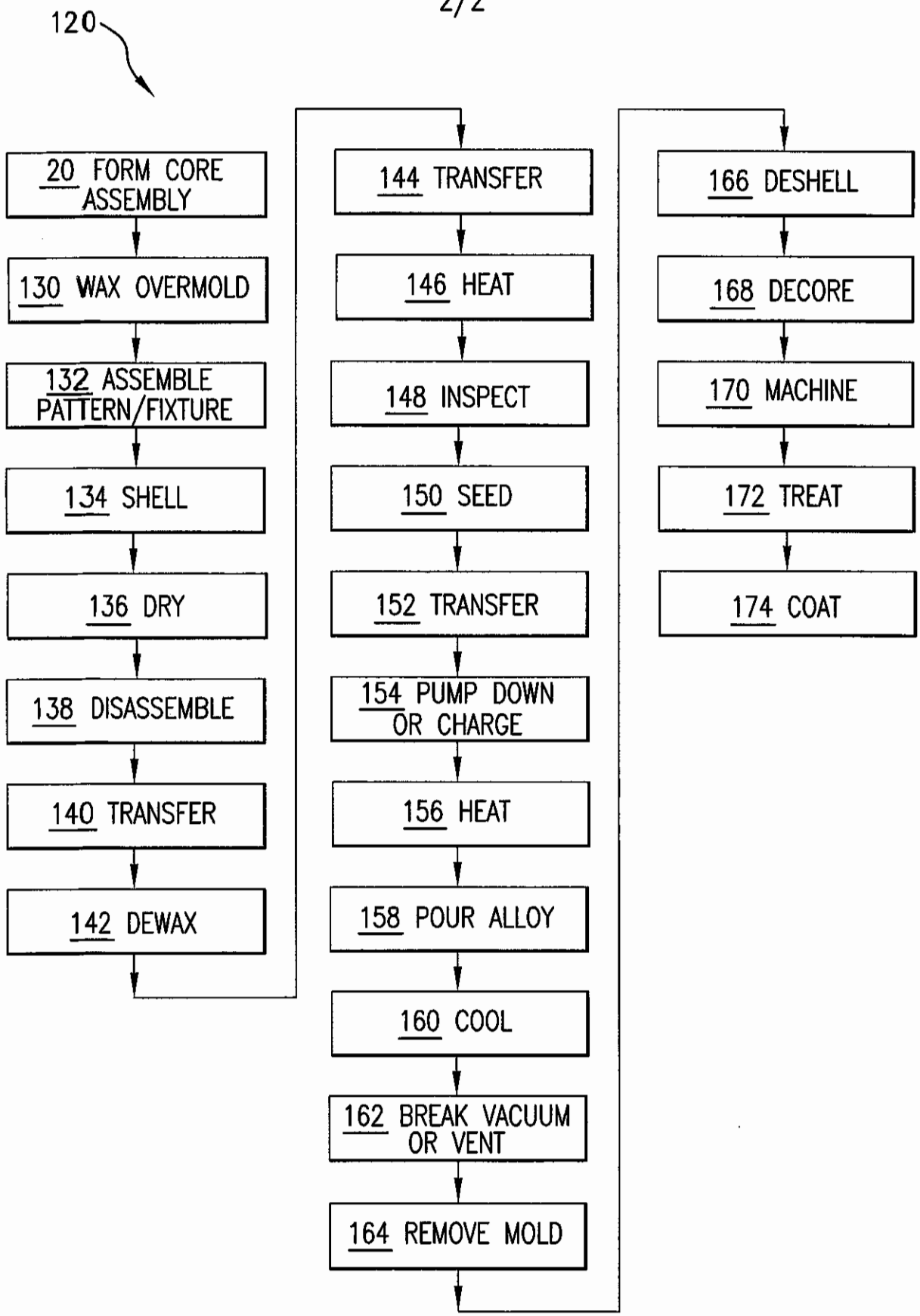

120
20 FORM CORE ASSEMBLY
130 WAX OVERMOLD
132 ASSEMBLE PATTERN/FIXTURE
134 SHELL
136 DRY
138 DISASSEMBLE
140 TRANSFER
142 DEWAX
144 TRANSFER
146 HEAT
148 INSPECT
150 SEED
152 TRANSFER
154 PUMP DOWN OR CHARGE
156 HEAT
158 POUR ALLOY
160 COOL
162 BREAK VACUUM OR VENT
164 REMOVE MOLD
166 DESHELL
168 DECORE
170 MACHINE
172 TREAT
174 COAT

FIG.2