



Glass composition	Step 1 time (min)	Step 2 heating (min)	Step 3 temperature (C°)	Step 3 Time (min)	Step 4 heating (min)	Step 5 temperature (C°)	Step 5 Time (min)
33,1	5 min	20 min	85 C°	25 min	12 min	125 C°	45 min
44,2	10 min	22 min	90 C°	30 min	12 min	130 C°	50 min
55,2	10 min	22 min	90 C°	35 min	12 min	132 C°	55 min
66,2	10 min	22 min	90 C°	40 min	12 min	132 C°	60 min
88,2	15 min	32 min	90 C°	45 min	17 min	132 C°	65 min
10,10,2	15 min	40 min	90 C°	50 min	23 min	135 C°	75 min
12,12,2	15 min	40 min	90 C°	60 min	23 min	135 C°	85 min

For every additional EVA layer of 0.4 mm second hold temperature (step 5) must be increased of 5 min.