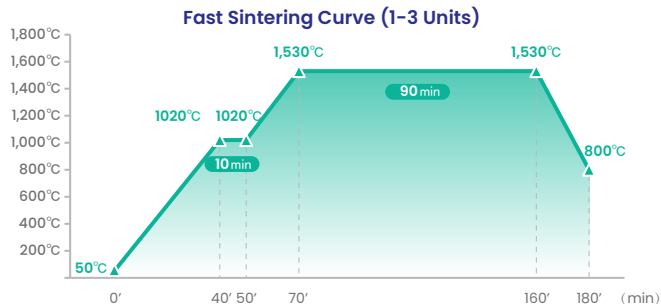
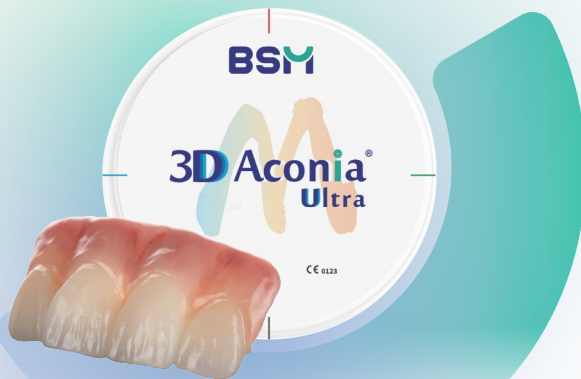




Fast Sintering Parameters (1-3 Units)

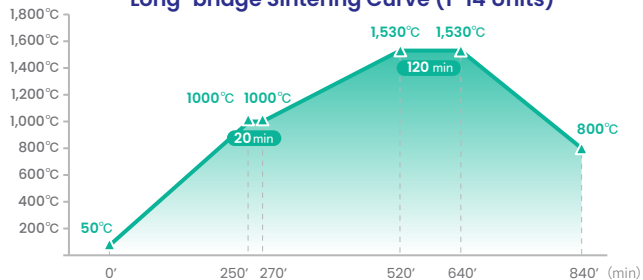
Step	Initial temperature(°C)	Final temperature(°C)	Time(min)	Heating rate(°C/min)
1	50	1020	40	24
2	1020	1020	10	Holding
3	1020	1530	20	25
4	1530	1530	90	Holding
5	1530	800	20	-36
6	800	Natural cooling		

BSM | Aconia®



3D Aconia Ultra
Sintering Curve

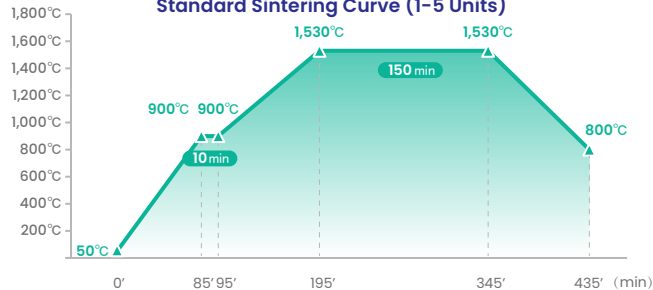
Long-bridge Sintering Curve (1-14 Units)



Long-Bridge Sintering Parameters (1-14 Units)

Step	Initial temperature(°C)	Final temperature(°C)	Time(min)	Heating rate(°C/min)
1	50	1000	250	4
2	1000	1000	20	Holding
3	1000	1530	250	2
4	1530	1530	120	Holding
5	1530	800	200	-4
6	800	Natural cooling		

Standard Sintering Curve (1-5 Units)



Standard Sintering Parameters (1-5 Units)

Step	Initial temperature(°C)	Final temperature(°C)	Time(min)	Heating rate(°C/min)
1	50	900	85	10
2	900	900	10	Holding
3	900	1530	100	6
4	1530	1530	150	Holding
5	1530	800	90	-8
6	800	Natural cooling		