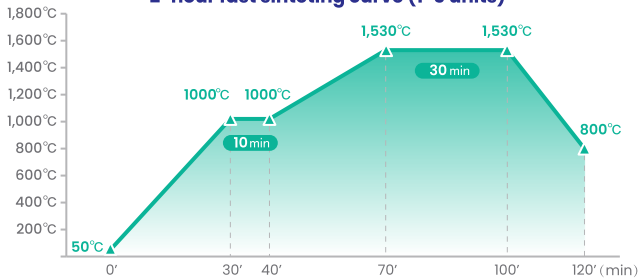
## • Special Sintering Curve

### 2-hour fast sinteting curve (1-3 units)

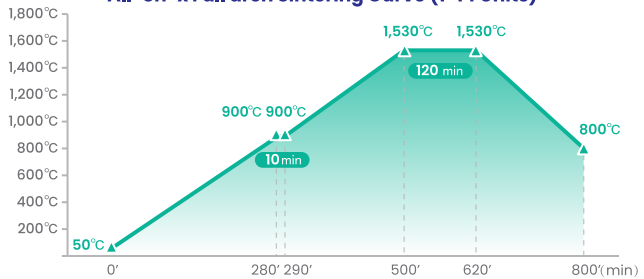



### 2-hour fast sinteting Parameters (1-3 units)

| Step | Initial temperature(℃) | Final temperature(℃) | Time(min) | Heating rate(℃/min) |
|---|---|---|---|---|
| 1 | 50 | 1000 | 30 | 32 |
| 2 | 1000 | 1000 | 10 | Holding |
| 3 | 1000 | 1530 | 30 | 18 |
| 4 | 1530 | 1530 | 30 | Holding |
| 5 | 1530 | 800 | 20 | -36 |
| 6 | 800 | Natural cooling | | |

*The 2-hour fast sintering program is specifically designed for BSM FC series fast-sintering furnace, or other furnaces with fast-sintering furnace. Actual sintering time may vary depending on each furnace.

### All-on-x Full arch Sintering Curve (1-14 Units)




### All-on-x Full arch Sintering Parameters (1-14 Units)

| Step | Initial temperature(℃) | Final temperature(℃) | Time(min) | Heating rate(℃/min) |
|---|---|---|---|---|
| 1 | 50 | 900 | 280 | 3 |
| 2 | 900 | 900 | 10 | Holding |
| 3 | 900 | 1530 | 210 | 3 |
| 4 | 1530 | 1530 | 120 | Holding |
| 5 | 1530 | 800 | 180 | -4 |
| 6 | 800 | Natural cooling | | |

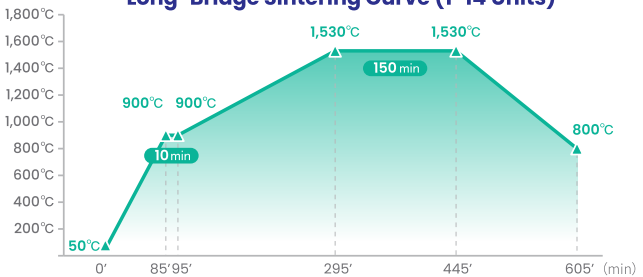
BSM | Aconia®




# 3D Aconia Master Plus
## Sintering Curve

## • Standard Sintering Curve

### Long-Bridge Sintering Curve (1-14 Units)

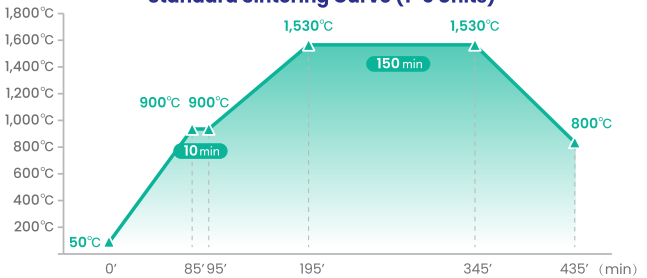



### Long-Bridge Sintering Parameters (1-14 Units)

| Step | Initial temperature(℃) | Final temperature(℃) | Time(min) | Heating rate(℃/min) |
|---|---|---|---|---|
| 1 | 50 | 900 | 85 | 10 |
| 2 | 900 | 900 | 10 | Holding |
| 3 | 900 | 1530 | 200 | 3 |
| 4 | 1530 | 1530 | 150 | Holding |
| 5 | 1530 | 800 | 160 | -5 |
| 6 | 800 | Natural cooling | | |

*It's recommended to use BSM sintering furnaces in Standard mode.

### Standard Sintering Curve (1-5 Units)

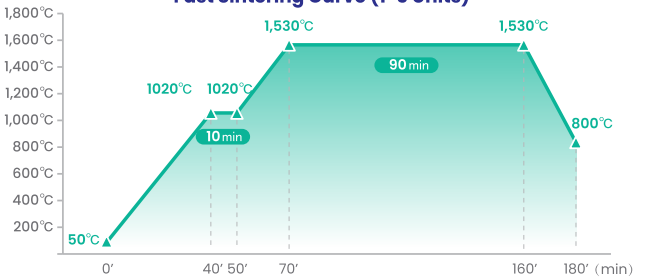



### Standard Sintering Parameters (1-5 Units)

| Step | Initial temperature(℃) | Final temperature(℃) | Time(min) | Heating rate(℃/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 | | |

*It's recommended to use BSM sintering furnaces in Standard mode.

### Fast Sintering Curve (1-3 Units)




### Fast Sintering Parameters (1-3 Units)

| Step | Initial temperature(℃) | Final temperature(℃) | Time(min) | Heating rate(℃/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 | | |

*It's recommended to use BSM sintering furnaces in Standard mode.