Sintering parameters

Normal

ZX Unity

CURVE 1 **≤ 3 UNITS** Normal Sintercurve

START Temp.	PHASE 1 Heating rate	PHASE 1 Maximum temp.	Holding time	PHASE 2 Heating rate	PHASE 2 Maximum temp.	Holding time	COOLING Rate	COOLING To	OPENING Temp.
20°C	**30°C/min**	**1050°C**	**0 min**	**5°C/min**	**1530°C**	**90 min**	**30°C**	**300°C**	**300°C**

CURVE 2 **≤ 6 UNITS** Normal Sintercurve

START Temp.	PHASE 1 Heating rate	PHASE 1 Maximum temp.	Holding time	PHASE 2 Heating rate	PHASE 2 Maximum temp.	Holding time	COOLING Rate	COOLING To	OPENING Temp.
20°C	**20°C/min**	**1050°C**	**0 min**	**5°C/min**	**1530°C**	**120 min**	**20°C**	**200°C**	**200°C**

CURVE 3 **> 6 UNITS / FULL ARCH** Normal Sintercurve

START Temp.	PHASE 1 Heating rate	PHASE 1 Maximum temp.	Holding time	PHASE 2 Heating rate	PHASE 2 Maximum temp.	Holding time	COOLING Rate	COOLING To	OPENING Temp.
20°C	**10°C/min**	**1050°C**	**0 min**	**3°C/min**	**1530°C**	**120 min**	**10°C**	**100°C**	**100°C**

Instructions for use via QR code

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Sintering parameters

Speed

ZX Unity

CURVE 1 **≤ 3 UNIT**S SPEED Sintercurve

START Temp.	PHASE 1 Heating rate	PHASE 1 Maximum temp.	Holding time	PHASE 2 Heating rate	PHASE 2 Maximum temp.	Holding time	PHASE 3 Heating rate	PHASE 3 Maximum temp.	Holding time	COOLING Rate	COOLING To	OPENING Temp.
20°C	**50°C/min**	**1050°C**	**0 min**	**5°C/min**	**1400°C**	**0 min**	**10°C/min**	**1550°C**	**30 min**	**60°C**	**300°C**	**300°C**

CURVE 2 **≤ 6 UNITS** SPEED Sintercurve

START Temp.	PHASE 1 Heating rate	PHASE 1 Maximum temp.	Holding time	PHASE 2 Heating rate	PHASE 2 Maximum temp.	Holding time	COOLING Rate	COOLING To	OPENING Temp.
20°C	**40°C/min**	**1050°C**	**0 min**	**5°C/min**	**1550°C**	**60 min**	**30°C**	**200°C**	**200°C**

CURVE 3 **> 6 UNITS / FULL ARCH** SPEED Sintercurve

START Temp.	PHASE 1 Heating rate	PHASE 1 Maximum temp.	Holding time	PHASE 2 Heating rate	PHASE 2 Maximum temp.	Holding time	COOLING Rate	COOLING To	OPENING Temp.
20°C	**30°C/min**	**1050°C**	**0 min**	**3°C/min**	**1530°C**	**90 min**	**15°C**	**100°C**	**100°C**

Instructions for use via QR code

A long cooling period is recommended!

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