

## CrystalML+

### Sintering Instructions

#### Speed Cycle

210 minutes | 3.5 hours



Single Unit & (up to) Three Unit Bridge

Stage 1 18 min	Stage 2 15 min	Stage 3 120 min	Stage 4 45 min	Stage 5 12 min	Stage 6 -121 min
50°C	900°C	1200°C	1550°C	1550°C	900°C

420 minutes | 7 hours

Single Unit & (up to) Three Unit Bridge

Stage 1 88 min	Stage 2 20 min	Stage 3 120 min	Stage 4 120 min	Stage 5 120 min	Stage 6 -121 min
20°C	900°C	900°C	1500°C	1500°C	300°C



780 minutes | 13 hours

Four to Six Unit Bridges

Stage 1 176 min	Stage 2 30 min	Stage 3 200 min	Stage 4 120 min	Stage 5 150 min	Stage 6 -121 min
50°C	900°C	900°C	1500°C	1500°C	300°C



780 minutes | 13 hours

Seven+ Unit Bridges/A04-6

Stage 1 176 min	Stage 2 20 min	Stage 3 300 min	Stage 4 120 min	Stage 5 200 min	Stage 6 100 min	Stage 7 -121 min
50°C	900°C	900°C	1500°C	1500°C	900°C	200°C