

CrystalUltrazir

Sintering Instructions



130 minutes | 2 hours 10 minutes

Single Unit & (up to) Three Unit Bridge

Starting Temp	Phase I Heating Rate	Phase I Maximum Temp	Phase II Heating Rate	Phase II Maximum Temp	Holding Time	Cooling Rate	Cooling To
20°C	43°C/min	1200°C	10°C/min	1550°C	55 min	55°C/min	900°C



240 minutes | 4 hours

Four to Six Unit Bridges

Starting Temp	Phase I Heating Rate	Phase I Maximum Temp	Holding Time	Phase II Heating Rate	Phase II Maximum Temp	Phase III Heating Rate	Phase III Maximum Temp	Holding Time	Cooling Rate	Cooling To
20°C	16°C/min	250°C	25 min	40°C/min	1050°C	5°C/min	1550°C	60 min	38°C/min	800°C



689 minutes | 11 hours 29 minutes

Seven+ Unit Bridges/A04-6

Starting Temp	Phase I Heating Rate	Phase I Maximum Temp	Holding Time	Phase II Heating Rate	Phase II Maximum Temp	Holding Time	Phase III Maximum Temp	Phase III Heating Rate	Holding Time	Cooling Rate	Cooling To
20°C	16°C/min	250°C	25 min	7°C/min	900°C	30 min	3°C/min	1530°C	120 min	8°C/min	300°C