

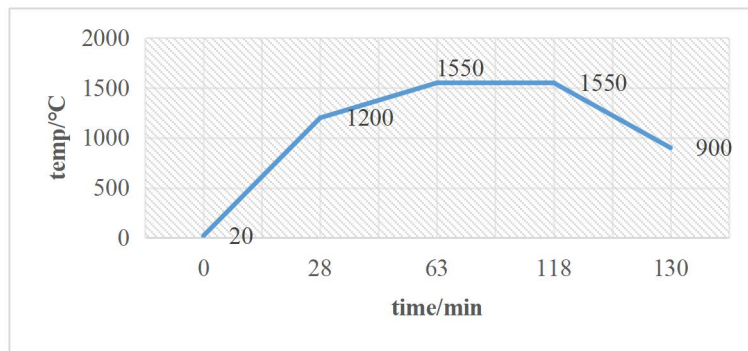
Aidite Zirconia Sintering Program

SHT-PW、SHT-PC、SHT-PM Sintering Program:

Below 3 units bridge (2h)

start temp	phase 1 heating rate	phase 1 Maximum temp	phase 2 heating rate	phase 2 Maximum temp	Holding time	cooling rate	cooling to
20°C	43°C/min	1200°C	10°C/min	1550°C	55min	55°C/min	900°C

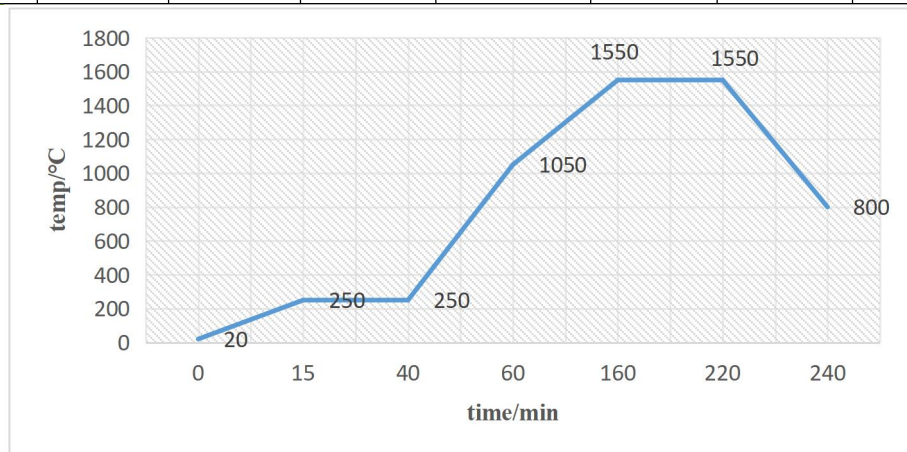
phase	temp/°C	time/min
1	20	28
2	1200	35
3	1550	55
4	1550	12
5	900	-121



Below 6 units bridge (4h)

start temp	phase 1 heating rate	phase 1 Maximum temp	Holding time	phase 2 heating rate	phase 2 Maximum temp	phase 3 heating rate	phase 3 Maximum temp	Holding time	cooling rate	cooling to
20°C	16°C/min	250°C	25min	40°C/min	1050°C	5°C/min	1550°C	60min	38°C/min	800°C

phase	temp/°C	time/min
1	20	15
2	250	25
3	250	20
4	1050	100
5	1550	60
6	1550	20
7	800	-121



Above 7 units bridge (11.5h)

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
20 °C	16°C/min	250°C	25min	7°C/min	900°C	30min	3°C/min	1530°C	120min	8°C/min	300°C

phase	temp/°C	time/min
1	20	20
2	250	25
3	250	130
4	900	30
5	900	210
6	1530	120
7	1530	154
8	300	-121

