

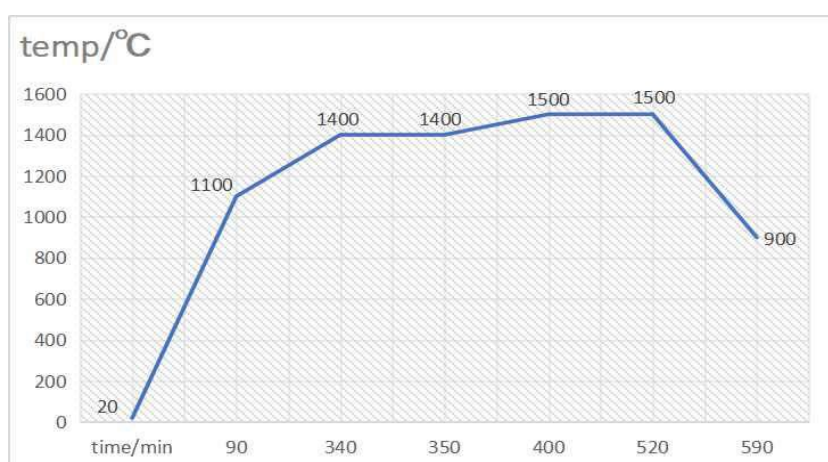
# Aidite Zirconia Sintering Program

## SHT+ preshade firing cycle

Below 6 units bridge (10h):

start temp	phase 1 heating rate	phase 1 Maximum temp	phase 2 Maximum temp	phase 2 Maximum temp	Holding time	phase 3 Maximum temp	phase 3 Maximum temp	Holding time	cooling rate	cooling to
20°C	12°C/min	1100°C	1.2°C/min	1400°C	10min	2°C/min	1500°C	120min	9°C/min	900°C

phase	temp/°C	time/min
1	20	90
2	1100	250
3	1400	10
4	1400	50
5	1500	120
6	1500	70
7	900	



Above 7 units bridge (13h):

start temp	phase 1 heating rate	phase 1 Maximum temp	phase 2 Maximum temp	phase 2 Maximum temp	Holding time	phase 3 Maximum temp	phase 3 Maximum temp	Holding time	cooling rate	cooling to
20°C	6.8°C/min	1100°C	1°C/min	1400°C	10min	1.1°C/min	1500°C	120min	5°C/min	900°C

phase	temp/°C	time/min
1	20	160
2	1100	280
3	1400	10
4	1400	90
5	1500	120
6	1500	120
7	900	

