

Sinterparameter Luxor Z True Nature

Below 3 Units (7h)

Start	Heating rate stage 1	Stage 1	Holding time stage 1	Heating rate stage 2	Stage 2	Holding time stage 2	Cooling rate	Cooling to
Room temp.	10°C/min	900°C	20min	5°C/min	1500	120min	10°C/min	300°C

Bridge 4-6 units (10h)

Start	Heating rate stage 1	Stage 1	Holding time stage 1	Heating rate stage 2	Stage 2	Holding time stage 2	Cooling rate	Cooling to
Room temp.	5°C/min	900°C	30min	3°C/min	1500	120min	8°C/min	300°C

Bridge above 7 units (15h)

Start	Heating rate stage 1	Stage 1	Holding time stage 1	Heating rate stage 2	Stage 2	Holding time stage 2	Cooling rate	Cooling to	Cooling rate2	Cooling to
Room temp.	5°C/min	900°C	20min	2°C/min	1500	120min	3°C	900°C	7°C/min	300°C