

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 |