

HT&HT-Plus sintering curve VS

ST sintering curve VS

UT sintering curve

Sintering individual crown			
Temperature rising °C/min	Temperature °C	Time span hour	Total time hour
0	20		0
10	900	1.5	1.5
0	900	0.5	2
3.75	1530	2.8	4.8
0	1530	2	6.8
5.25	900	2	8.6
Sintering 3-4 bridge			
Temperature rising °C/min	Temperature °C	Time span hour	Total time hour
0	20		0
5	900	3	3
0	900	0.5	3.5
2.84	1530	3.7	7.2
0	1530	2	9.2
5.25	900	2	11.2
Sintering multi-circular bridge			
Temperature rising °C/min	Temperature °C	Time span hour	Total time hour
0	20		0
2.67	900	5.5	5.5
0	900	0.5	6
1.91	1530	5.5	11.5
0	1530	2	13.5
3.44	600	4.5	18

Sintering individual crown			
Temperature rising °C/min	Temperature °C	Time span hour	Total time hour
0	20		0
10	900	1.5	1.5
0	900	0.5	2
3.45	1480	2.8	4.8
0	1480	2	6.8
4.83	900	2	8.6
Sintering 3-4 bridge			
Temperature rising °C/min	Temperature °C	Time span hour	Total time hour
0	20		0
5	900	3	3
0	900	0.5	3.5
2.61	1480	3.7	7.2
0	1480	2	9.2
4.83	900	2	11.2
Sintering multi-circular bridge			
Temperature rising °C/min	Temperature °C	Time span hour	Total time hour
0	20		0
2.67	900	5.5	5.5
0	900	0.5	6
1.76	1480	5.5	11.5
0	1480	2	13.5
3.26	600	4.5	18

Sintering individual crown			
Temperature rising °C/min	Temperature °C	Time span hour	Total time hour
0	20		0
10	900	1.5	1.5
0	900	0.5	2
3.27	1450	2.8	4.8
0	1450	2	6.8
4.58	900	2	8.6
Sintering 3-4 bridge			
Temperature rising °C/min	Temperature °C	Time span hour	Total time hour
0	20		0
5	900	3	3
0	900	0.5	3.5
2.48	1450	3.7	7.2
0	1450	2	9.2
4.58	900	2	11.2
Sintering multi-circular bridge			
Temperature rising °C/min	Temperature °C	Time span hour	Total time hour
0	20		0
2.67	900	5.5	5.5
0	900	0.5	6
1.67	1450	5.5	11.5
0	1450	2	13.5
3.15	600	4.5	18

Tips:

1. Actual temperature of sintering furnace is distinguished with program temperature, actual temperature can be measured by firing ring. If you need, contact us please.
2. Keep 0.5 hour at 900°C is necessary, it can help decompose organic solvent from coloring liquid with no residual, which is helpful to final zirconia translucency.
3. Each zirconia has a suitable sintering temperature range, we can set peak temperature at this range. At this range, translucency of final zirconia will be better and flexural strength will decrease slightly with the temperature increasing. Sintering temperature of our zirconia is as followed:

Zirconia Type	HT	HT-plus	ST	UT
Sintering temperature (°C)	1500-1550	1500-1550	1480-1530	1450-1530