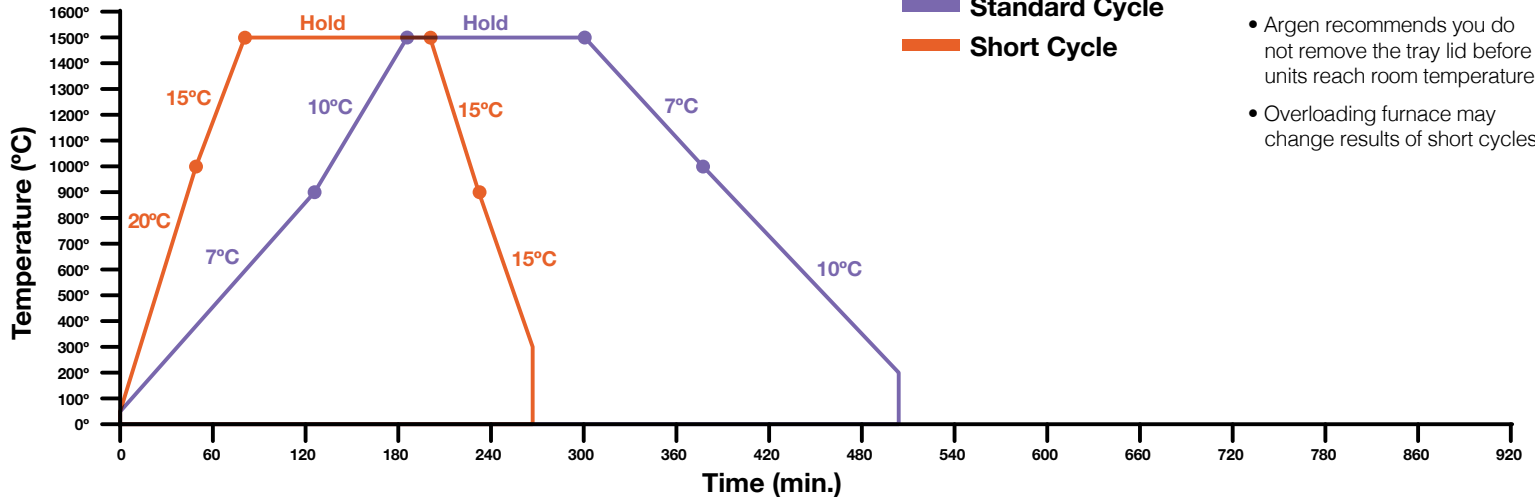


# ARGEN Z<sup>®</sup> ST Sintering Guide



- Oven times may vary, adjust accordingly.
- Do not remove units before your oven has reached the target cool temperature.
- Argen recommends you do not remove the tray lid before units reach room temperature.
- Overloading furnace may change results of short cycles.

## STANDARD CYCLE – 8.5 Hours

Single and bridges

Segment	1	2	3	4	5
Ramp Rate (per min.)	7°C	10°C		7°C	10°C
Time (min.)	125	55	120	75	134
Ramp Temp	900°C	1500°C		1000°C	200°C
Soak Temp			1500°C		

## SHORT CYCLE – 4.5 Hours

Standard thickness, single units only

Segment	1	2	3	4	5
Ramp Rate (per min.)	20°C	15°C		15°C	15°C
Time (min.)	47.5	30	120		76.7
Ramp Temp	1000°C	1500°C			300°C
Soak Temp			1500°C		

