

## Program sinterizare CERAMAN 4D functional & estetic

Segment	Start	Stop	Timp	OBS.
1	0	500	1h	
2	500	1200	2h	
3	1200	1200	30 min	Hold
4	1200	1300	45min	
5	1300	1480	1h	
6	1480	1480	2h 30 min	Hold
7	1480	800	1h 30 min	
8	800	Natural Cooling		Program End

- 800 celsius = program end
- 6-9 units holding time 2h30min
- 10 units holding time 3h