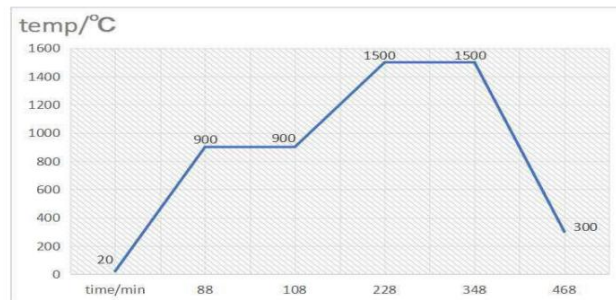


Vsmile 3D P R I S M Multilayer Sintering Program:

Below 3 units bridge (7h):

start temp	phase 1 heating rate	phase 1 Maximum temp	Holding time	phase 2 Maximum temp	phase 2 Maximum temp	Holding time	cooling rate	cooling to
20°C	10°C/min	900°C	20min	5°C/min	1500°C	120min	10°C/min	300°C

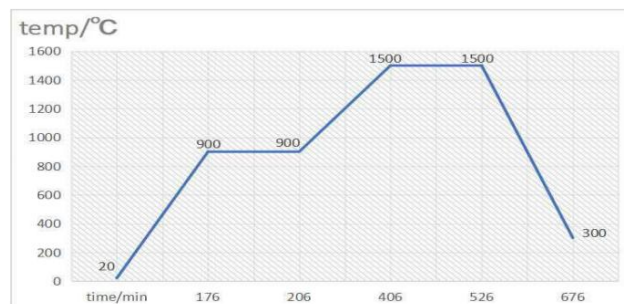
phase	temp/°C	time/min
1	20	88
2	900	20
3	900	120
4	1500	120
5	1500	120
6	300	



From 4 to 6 units bridge(10h):

start temp	phase 1 heating rate	phase 1 Maximum temp	Holding time	phase 2 Maximum temp	phase 2 Maximum temp	Holding time	cooling rate	cooling to
20°C	5°C/min	900°C	30min	3°C/min	1500°C	120min	8°C/min	300°C

phase	temp/°C	time/min
1	20	176
2	900	30
3	900	200
4	1500	120
5	1500	150
6	300	



Above 7 units bridge (15h):

start temp	phase 1 heating rate	phase 1 Maximum temp	Holding time	phase 2 Maximum temp	phase 2 Maximum temp	Holding time	cooling rate	cooling to	cooling rate	cooling to
20°C	5°C/min	900°C	20min	2°C/min	1500°C	120min	3°C/min	900°C	7°C/min	200°C

phase	temp/°C	time/min
1	20	176
2	900	20
3	900	300
4	1500	120
5	1500	200
6	900	100
7	200	

