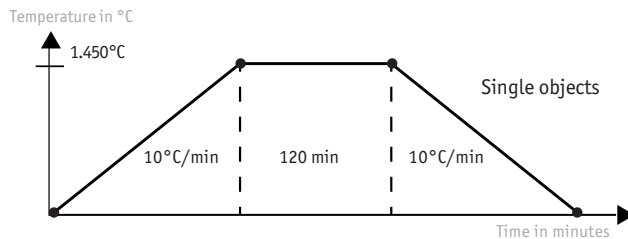


## Z-CAD® Sinter-parameters

The recommended sintering temperature is 1.450 °C (Tab. 1 + 2) for all Z-CAD materials. Speed sintering (Tab. 3) and a higher standard sintering temperatures (Tab. 4) are possible.

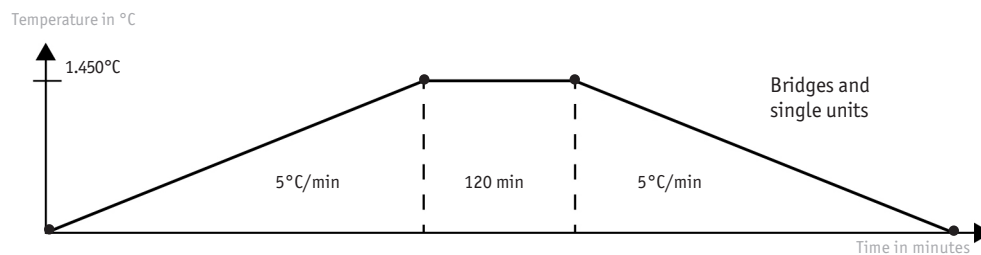
1)

	Heatrate °C/min	T max °C	Holding time min	Cooling °C/min
Single objects				
ALL Z-CAD® materials	10	1.450°C	120	Naturally furnace cooling (10°C/min)



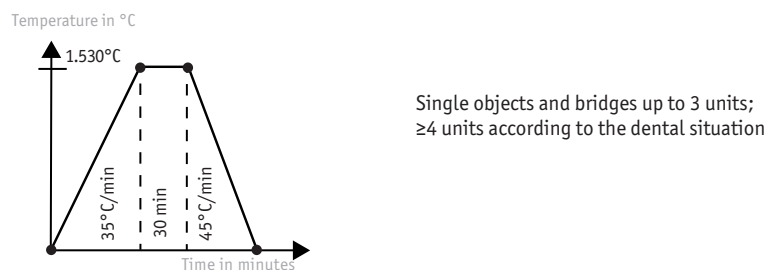
2)

	Heatrate °C/min	T max °C	Holding time min	Cooling °C/min
Bridges				
ALL Z-CAD® materials	5	1.450°C	120	Naturally furnace cooling (5°C/min)



3)

	Heatrate °C/min	T max °C	Holding time min	Cooling °C/min
Speed				
ALL Z-CAD® materials	35	1.530°C	30	max. 45°C/min



4)

	Heatrate °C/min	T max °C	Holding time min	Cooling °C/min
Sinter-bandwidth				
ALL Z-CAD® materials	1) + 2)	1.450°C–1.550°C	1) + 2)	Naturally furnace cooling

All Z-CAD® materials can be sintered between 1.450 °C and 1.550 °C. The requirements of ISO 6872: 2019 for flexural strength are fully given. Depending on the selected furnace type, the translucency and the color saturation can be influenced individually.

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