

Mold Name	Position in the mold	Slurry Cooling Rate (°C/min)	Nucleation Temperature (°C)	Freezing Time (1000 sec)	Time at Equilibrium (sec)	Pore Size (μm)
-20 Set Freezing Temp	base	-0.482	-8.6	5.964	720	111.75
		-0.466	-8.8	5.712	960	106.42
		-0.488	-7.6	5.628	1080	122.83
-20 Set Freezing Temp	top	-0.379	-3.2	4.2	5280	165.93
		-0.353	-2.1	5.376	3840	166.5
		-0.367	-2.1	5.46	5040	175.72
-30 Set Freezing Temp	base	-0.547	-9.1	3.2742	200	87.65
		-0.526	-11.8	3.0816	250	98.7
		-0.543	-10.8	2.9532	220	95.75
-30 Set Freezing Temp	top	-0.386	-0.4	3.1458	2500	146.22
		-0.375	-3.5	2.889	2390	147.52
		-0.384	-2.4	2.9532	2600	159.57
-40 Set Freezing Temp	base	-0.626	-10.2	2.289	200	86.58
		-0.676	-12.7	2.0274	70	88.25
		-0.686	-12.1	2.5506	60	88.43
-40 Set Freezing Temp	top	-0.452	-1.9	1.962	1190	143.52
		-0.457	-2.9	1.956	1620	139.65
		-0.465	-2.4	2.0928	1460	141.4
Thermal Hold	base	-0.543	-12.6	7.4844	200	99.64
		-0.598	-10.9	8.748	240	102.5
		-0.543	-11.4	10.8072	180	103.03
Thermal Hold	top	-0.376	-2.9	7.0956	10200	192.58
		-0.419	-1.5	8.748	9440	203.53
		-0.391	-5.2	9.5256	7360	194.23