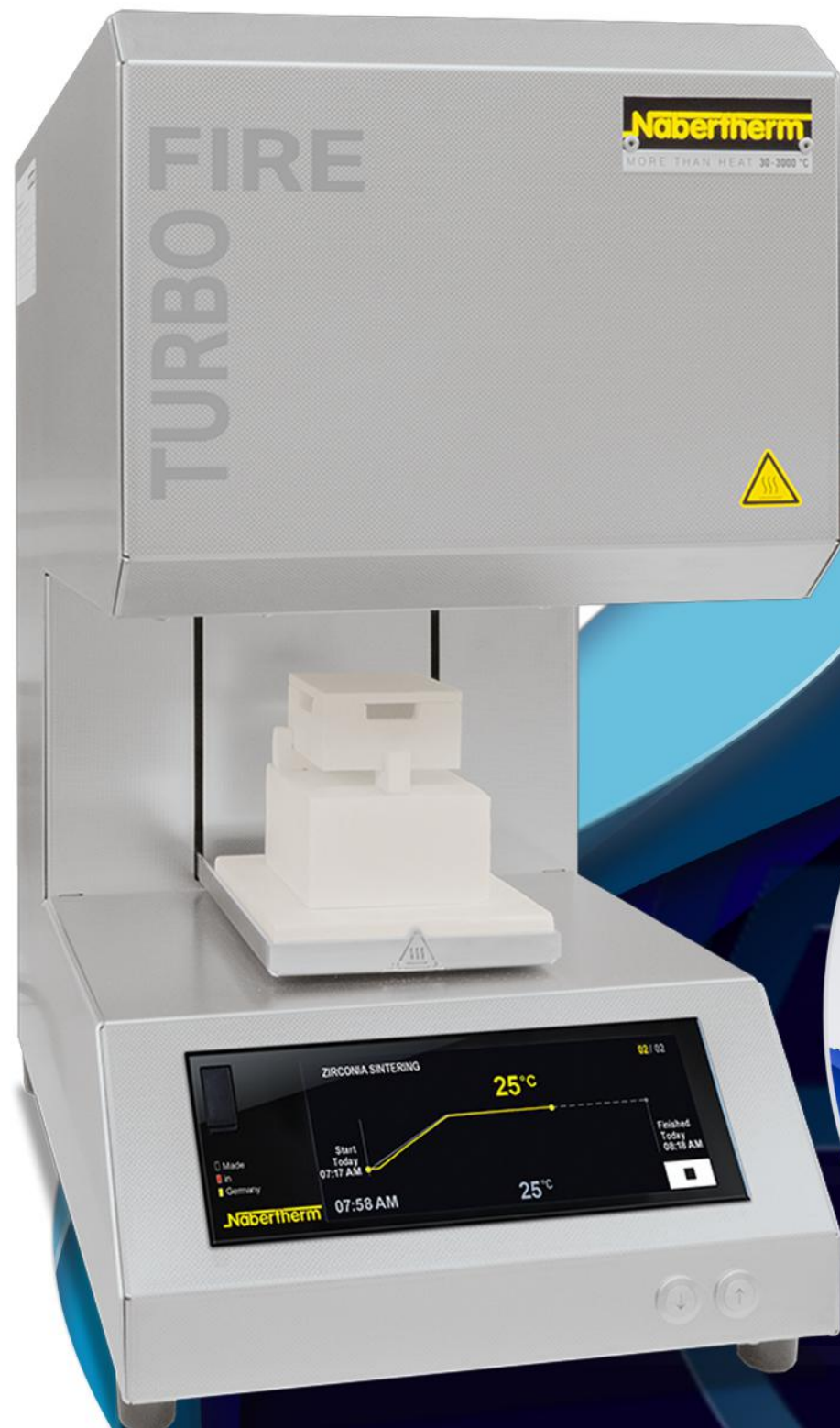


ZIRCONIA

Sintering Cycles

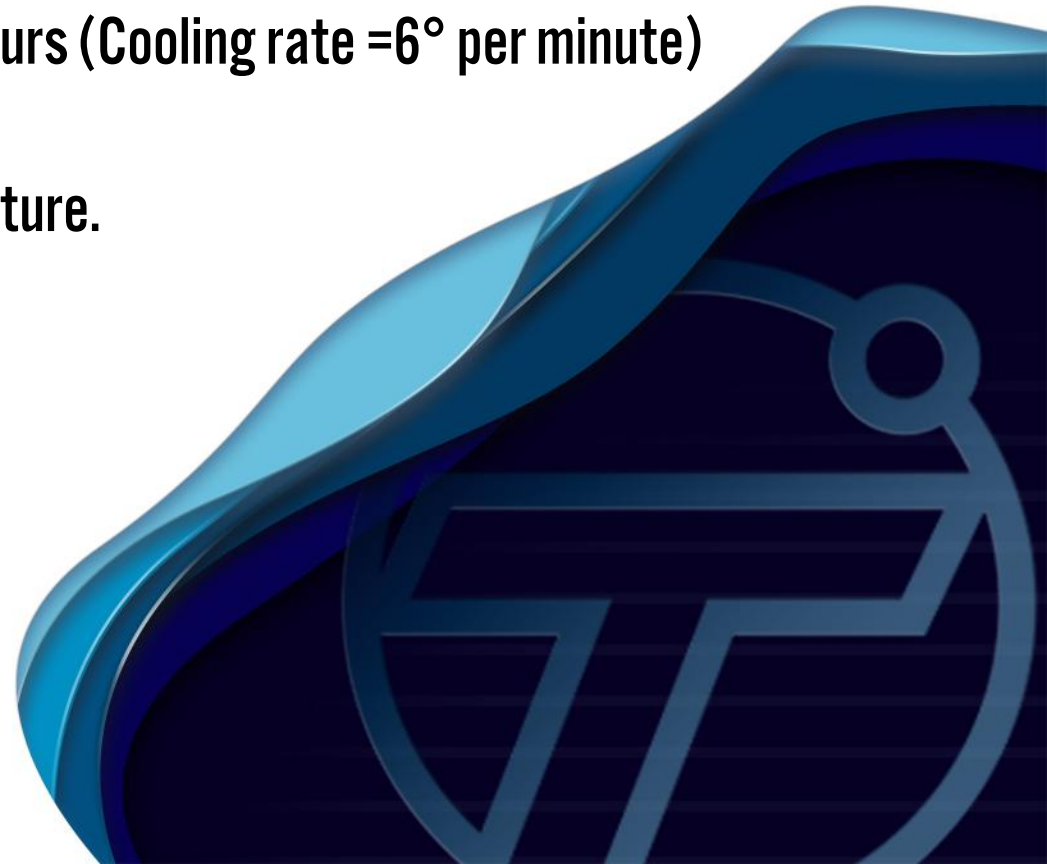
Standard | Same Day | Fast



Standard (overnight) Cycle

For use on all types of zirconia restorations. Highly recommended for bridges: most preferably 6-units or larger to prevent warping and/or cracking.

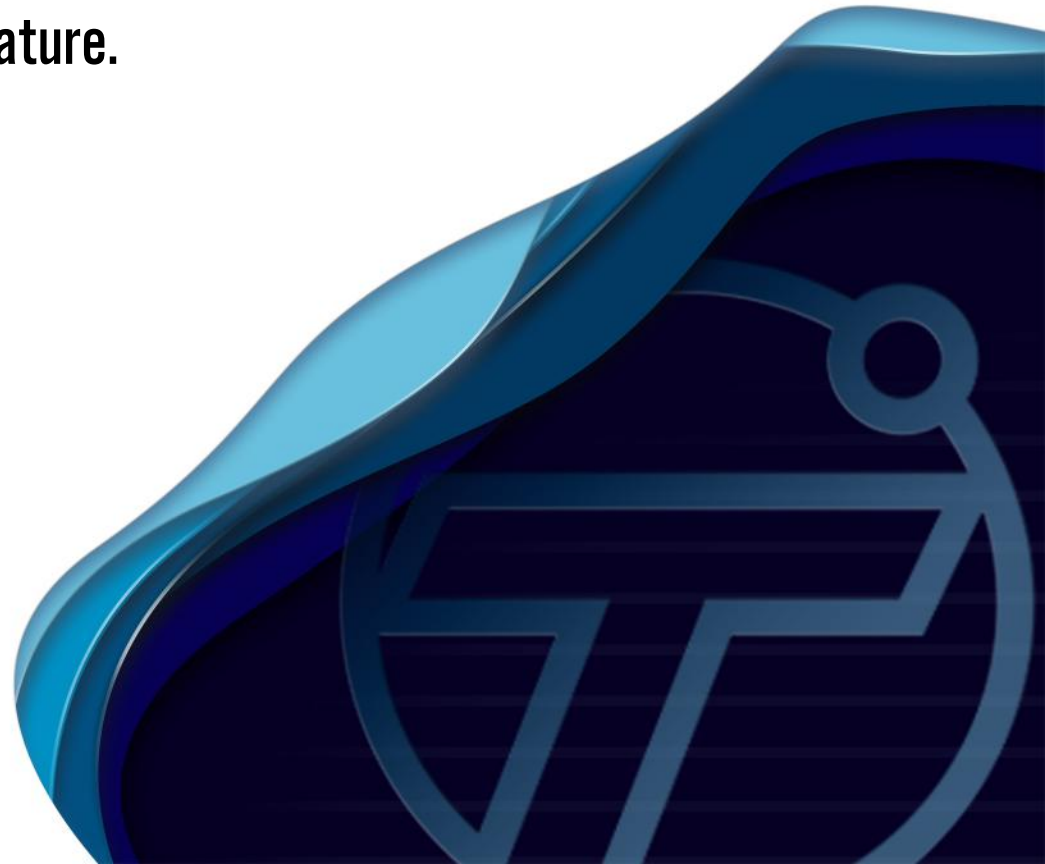
- 20°C increase to 800°C over 1 hour (heat rate = 13°C per minute)
- Increase from 800°C to 1200°C over 1 hour (heat rate= 7°C per minute)
- Increase from 1200°C to 1530°C over 2 hours (heat rate = 5°C per minute)
- Hold at 1530°C for 2 hours
- Decrease heat from 1530°C to 400°C over 3 hours (Cooling rate =6° per minute)
- End program and allow to cool to room temperature.



Same Day Cycle

For use on zirconia restorations up to 5-units. For best results, load 25 units or less and place an empty sintering tray under the loaded sintering tray. Note: Large and thick restorations are recommended for Standard (overnight) Cycle as they may appear less translucent using this cycle.

- 20°C increase to 1200°C over 1 hour (heat rate = 20°C per minute)
- Increase from 1200°C to 1550°C over 1 hour (heat rate= 6°C per minute)
- Hold at 1550°C for 90 minutes
- End program and allow to cool to room temperature.



Fast Fire Cycle

For use on all types of zirconia except for splinted units of any size as they may warp. Very large or thick restorations may appear less translucent or opaque. Color results will vary when using this cycle. Limit of 10 units or less when using this cycle. Use an empty sintering tray under the loaded sintering tray for best results. We recommend using a sintering tray specifically designed for rapid heating and cooling. Using this cycle will greatly reduce the useful life of regular sintering trays.

- 20°C increase to 1577°C over 45 minutes (heat rate = 35°C per minute)
- Hold at 1577°C for 45 minutes
- Decrease heat from 1577°C to 1200°C in 15 minutes (heat rate = 25°C per minute)
- End program and allow to cool to room temperature.

