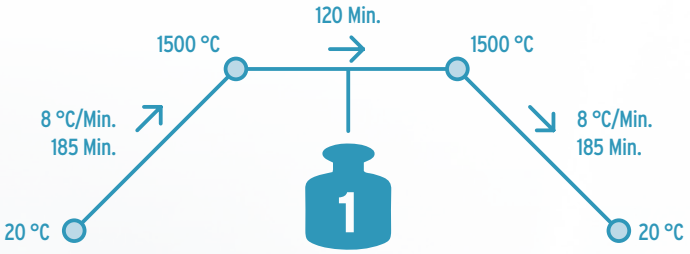
Quick Guide
Zirconia Sintering

Nacera™

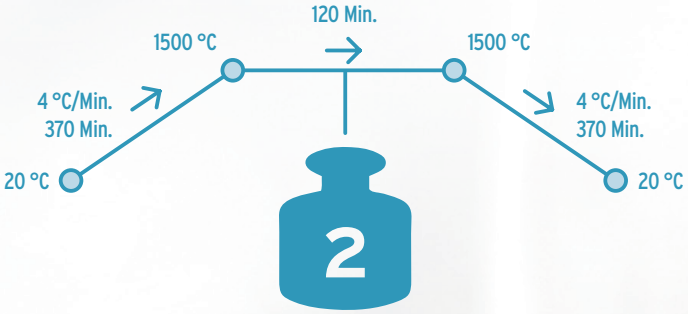
TIPS AND HINTS

LIGHT CONSTRUCTION / SMALL MASS



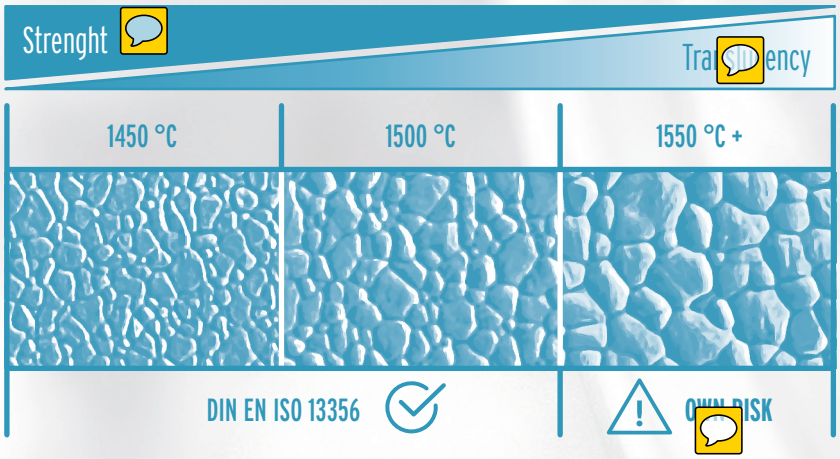
Mass	Crown Thickness	Pontic Thickness
1	0.50 mm - 2.00 mm	3.00 mm - 5.00 mm
	Heat/ Cool - Rate /min.	
	8 °C	
	Holding Time	
	120 min.	

MASSIVE CONSTRUCTION / LARGE MASS



Mass	Crown Thickness	Pontic Thickness
2	2.00 mm - 5.00 mm	5.00 mm - 9.00 mm
	Heat/ Cool - Rate /min.	
	4 °C	
	Holding Time	
	120 min.	
Toronto:	Heat/ Cool - Rate /min.	
	4 °C	
Toronto:	Holding Time	
	150 - 180 min.	

STRENGTH VS. TRANSLUCENCY



- Higher sintering temperature will generate grain growth and raises the translucency.
- The grain growth will decrease the strength and increase the translucency.
- A bigger grain will have a higher low temperature degradation and therefore a negative effect on the long-term strength and durability.
- Zirconium is a poor heat conductor. The transport of energy in and out of the material takes time. (Lower the heat rates for massive constructions)
- Slow cooling can improve translucency and will work against tensions in the material.

DOCERAM Medical Ceramics GmbH
Hesslingsweg 65 - 67 | D-44309 Dortmund / Germany
info@doceram-medical.com | www.doceram-medical.com

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