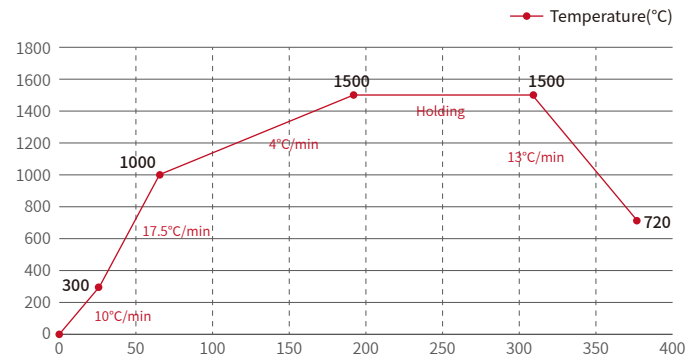


Premium Zirconia Sintering Programme

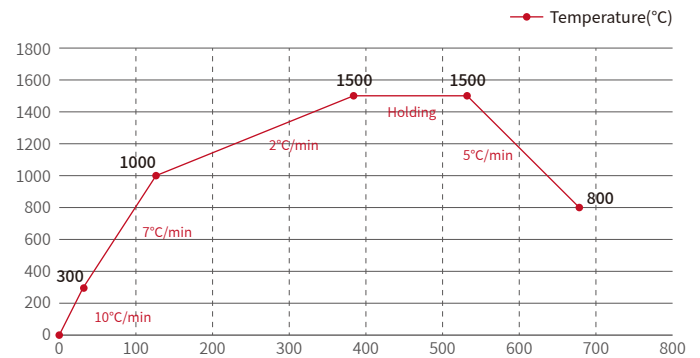
Crowns and bridges(≤5 units)(HS,HT,PLUS,GM,MM-4D)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	0	300	30	10
Step2	300	1000	40	17.5
Step3	1000	1500	125	4
Step4	1500	1500	120	Holding
Step5	1500	720	60	13
Step6	720	Room temperature	Cool naturally	/



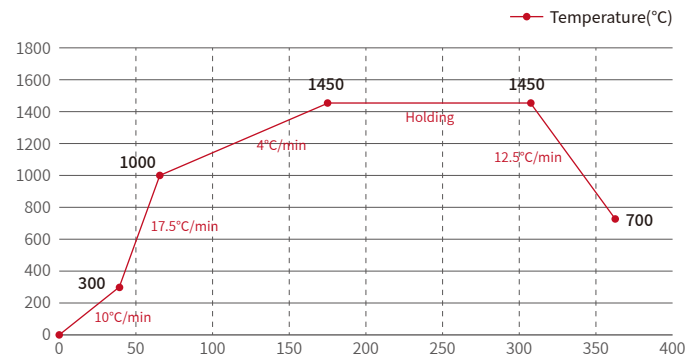
Bridges(>5 units)(HS,HT,PLUS,MM-4D)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	0	300	30	10
Step2	300	1000	100	7
Step3	1000	1500	250	2
Step4	1500	1500	150	Holding
Step5	1500	800	140	5
Step6	800	Room temperature	Cool naturally	/



Crowns and bridges(≤5 units)(HT,AT,MHT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	0	300	30	10
Step2	300	1000	40	17.5
Step3	1000	1450	112.5	4
Step4	1450	1450	120	Holding
Step5	1450	700	60	12.5
Step6	700	Room temperature	Cool naturally	/



Bridges(>5 units)(HT,MHT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	0	300	30	10
Step2	300	1000	100	7
Step3	1000	1450	225	2
Step4	1450	1450	150	Holding
Step5	1450	800	130	5
Step6	800	Room temperature	Cool naturally	/

