

Sintering program of zirconia (XT-cera)

Main series :

White zirconia : SHT、HT, NT, TT

Pre-shaded : HT、SHT

Multilayer : 3D Multilayer、SHT Multilayer

3D White : 3D white

Sintering program, applicable to HT, HTpre-shaded, SHT, SHTpre-shaded, SHTMultilayer, NT , 3DML。

Single crown& Short bridge(within 5 units)

Sintering Steps	Temperature(°C)	Time(h)
Phase 1	20-900	1.5
Phase 2	900-900	0.5
Phase 3	900-1530	3.0
Phase 4	1530-1530	2.0
Phase 5	1530-800	1.5
Phase 6	800-Natural cooling 100	Finished

Long bridge (more than 5 units)

Sintering Steps	Temperature(°C)	Time(h)
Phase 1	20-900	2.5
Phase 2	900-900	0.5
Phase 3	900-1530	4.0
Phase 4	1530-1530	2.0
Phase 5	1530-800	2.0
Phase 6	800-Natural cooling 100	Finished

Single crown& Short bridge(within 5 units)

Heating rate(°C/min)	Temperature(°C)	Holding time(min)
10	20-900	
	900-900	30
4	900-1530	
	1530-1530	120
8	1530-800	
	800-Natural cooling 100	Finished

Long bridge (more than 5 units)

Heating rate(°C/min)	Temperature(°C)	Holding time(min)
6	20-900	
	900-900	30
3	900-1530	
	1530-1530	120
6	1530-800	
	800-Natural cooling 100	Finished

Note:The temperature of different furnaces varies,Please refer to the actual furnace temperature

Sintering program applicable to TT,3DWhite。

Single crown& Short bridge(within 5 units)

Sintering Steps	Temperature(°C)	Time (h)
Phase 1	20-900	1.5
Phase 2	900-900	0.5
Phase 3	900-1500	3.0
Phase 4	1500-1500	2.0
Phase 5	1500-800	1.5
Phase 6	800-Natural cooling	Finished

Long bridge (more than 5 units)

Sintering Steps	Temperature(°C)	Time(h)
Phase 1	20-900	2.5
Phase 2	900-900	0.5
Phase 3	900-1500	4.0
Phase 4	1500-1500	2.0
Phase 5	1500-800	2.0
Phase 6	800-Natural cooling	Finished

Single crown& Short bridge(within 5 units)

Heating rate(°C/min)	Temperature(°C)	Holding time(min)
10	20-900	
	900-900	30
4	900-1500	
	1500-1500	120
8	1500-800	
	800-Natural cooling	Finished

Long bridge (more than 5 units)

Heating rate(°C/min)	Temperature(°C)	Holding time(min)
6	20-900	
	900-900	30
3	900-1500	
	1500-1500	120
6	1500-800	
	800-Natural cooling	Finished

Note:The temperature of different furnaces varies,Please refer to the actual furnace temperature