

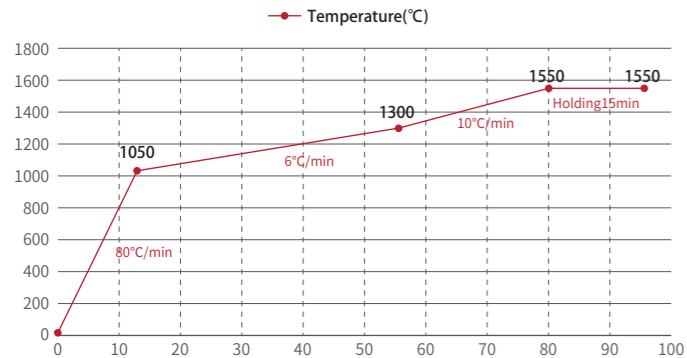
Fast Sintering

HS, HT, MHT, GM, MM-4D

Crowns and bridges (≤ 7 units)

95 minutes

STEP	Start temperature(°C)	Final temperature(°C)	Time(min)	Ramp Rate(°C/min)
Step1	20	1050	13	80
Step2	1050	1300	42	6
Step3	1300	1550	25	10
Step4	1550	1550	15	Holding



-05-

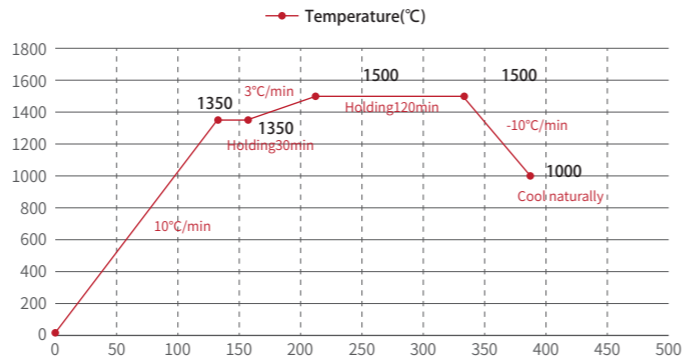
Fast Sintering

MM-4D

Bridges (> 7 units)

383 minutes

STEP	Start temperature(°C)	Final temperature(°C)	Time(min)	Ramp Rate(°C/min)
Step1	20	1350	133	10
Step2	1350	1350	30	Holding
Step3	1350	1500	50	3
Step4	1500	1500	120	Holding
Step5	1500	1000	50	-10



-06-

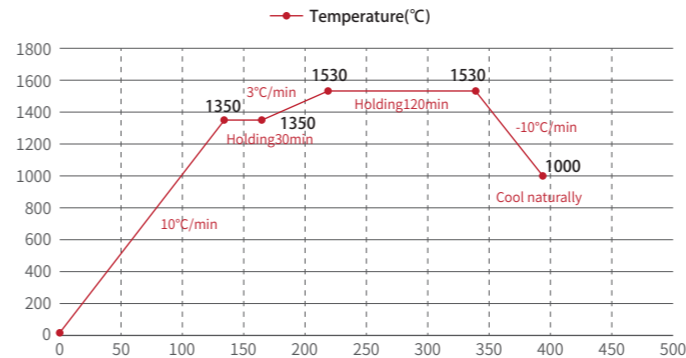
Fast Sintering

HS, HT

Bridges (> 7 units)

393 minutes

STEP	Start temperature(°C)	Final temperature(°C)	Time(min)	Ramp Rate(°C/min)
Step1	20	1350	133	10
Step2	1350	1350	30	Holding
Step3	1350	1530	60	3
Step4	1530	1530	120	Holding
Step5	1530	1000	50	-10



-07-



Prime Zirconia Sintering Programme

ISO 13485:2016

FDA cleared



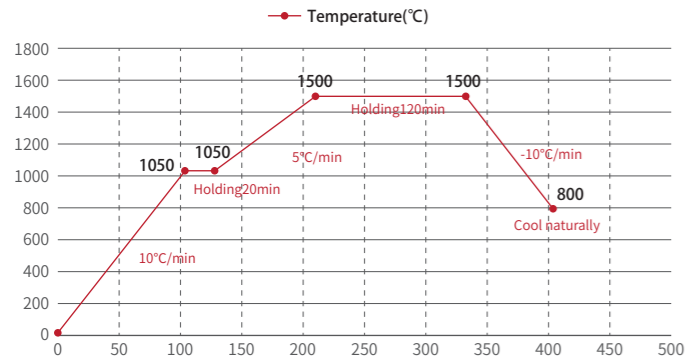
Standard Sintering

MHT, GM, MM-4D

Crowns and bridges (≤ 7 units)

403 minutes

STEP	Start temperature(°C)	Final temperature(°C)	Time(min)	Ramp Rate(°C/min)
Step1	20	1050	103	10
Step2	1050	1050	20	Holding
Step3	1050	1500	90	5
Step4	1500	1500	120	Holding
Step5	1500	800	70	-10



-01-

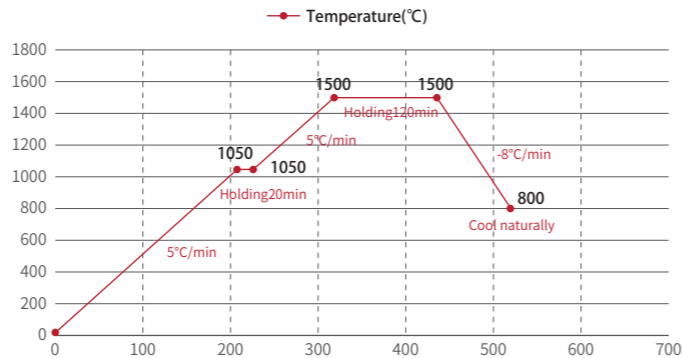
Standard Sintering

MHT, GM, MM-4D

Bridges (> 7 units)

526 minutes

STEP	Start temperature(°C)	Final temperature(°C)	Time(min)	Ramp Rate(°C/min)
Step1	20	1050	206	5
Step2	1050	1050	20	Holding
Step3	1050	1500	90	5
Step4	1500	1500	120	Holding
Step5	1500	800	90	-8



-02-

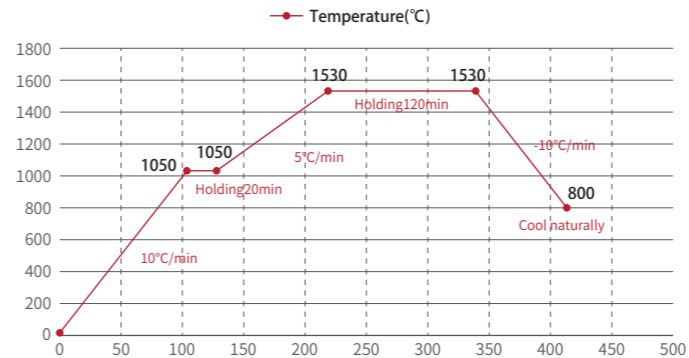
Standard Sintering

HS, HT

Crowns and bridges (≤ 7 units)

412 minutes

STEP	Start temperature(°C)	Final temperature(°C)	Time(min)	Ramp Rate(°C/min)
Step1	20	1050	103	10
Step2	1050	1050	20	Holding
Step3	1050	1530	96	5
Step4	1530	1530	120	Holding
Step5	1530	800	73	-10



-03-

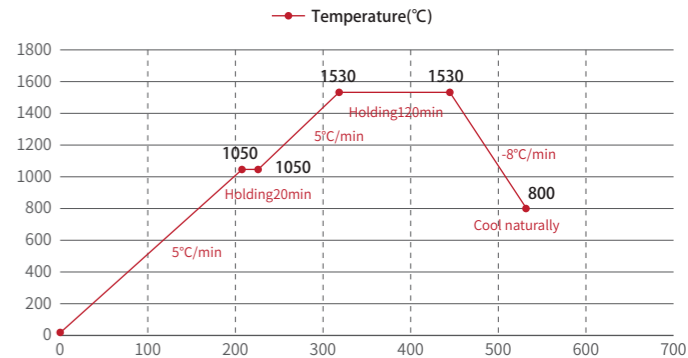
Standard Sintering

HS, HT

Bridges (> 7 units)

534 minutes

STEP	Start temperature(°C)	Final temperature(°C)	Time(min)	Ramp Rate(°C/min)
Step1	20	1050	206	5
Step2	1050	1050	20	Holding
Step3	1050	1530	96	5
Step4	1530	1530	120	Holding
Step5	1530	800	92	-8



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