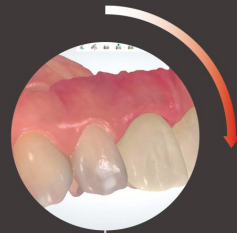




01

Scanning



02

Designing



03

Milling



04

Shape Adjustment



05

Crystallization and Glaze

# 01

## Shape Adjustment



### To cut down the restoration

Use the right trimming tool to separate the UP.CAD restorations from the material support pin. If an unsuitable tool is used, fracture and fissures may occur, especially near the margin.

### Fit check

Place the restoration on the model, or directly into the mouth. Carefully assess the fit and adjust if necessary, ensuring reasonable sealing capability and confirming that the occlusal and proximal contacts of the restoration are correct.



### Attention

- After detachment, the restoration should be polished before sintering.
- Use the appropriate polishing tools, and ensure that the restoration is polished under low speed and with a light force.
- Polish the restoration in one direction only, and at low speed. Avoid localised heating by not polishing for too long in one area. This may cause fissures or cracks.
- The minimum thickness of restoration must be within the prescribed scope of the material mentioned earlier in these instructions.

# 02

## Crystallization and Glaze



A porcelain furnace is used to crystallize the restoration to its final state. Depending on the final aesthetic requirements of the restoration, an appropriate heating program should be chosen. Crystallization and glazing are achieved in two steps, displayed in the two charts below depending on the type of restoration.

Only double crystallization or double crystallization plus glazing sintering program

### — One process —

Starting temp °C	Dry time mm:ss	Temp increasing rate/°C	Holding temp °C	Holding time min	Vacuum start °C	Vacuum finished °C
400	00:30	40	840	07:00	550	840

### — Two process —

Starting temp °C	Dry time mm:ss	Temp increasing rate/°C	Holding temp °C	Holding time min	Vacuum start °C	Vacuum finished °C
400	06:00	90/30*	820/840	00:10/7:00	550/820	820/840

Double crystallization glazing process

### — Glazing process —

Starting temp °C	Dry time mm:ss	Temp increasing rate/°C	Holding temp °C	Holding time min	Vacuum start °C	Vacuum finished °C
400	00:30	40	840	03:00	550	840



### Attention

Two step process temp increasing program is recommended, the data before “/” belongs to the first process, after “/” belongs to the second. Such as the temp increase rate “60/30”, the first process rate is 90°C/min, the second process rate is 30°C/min

If the veneer, inlay, onlay was made by coloring process, then crystallization and glazing together sintering program is recommended.



The glazing paste should be brushed evenly, the glaze must not be too thick, especially the occlusal surface. Avoid thin areas, ensure the surface of the restoration is bright enough after sintering.

#### TIPS:

01 +

Crystallization sintering program can be chosen automatically according to the glazing furnace. Adjust the program according to the manufacturers' instructions.

02 +

Clean the restoration completely before double crystallization, we recommend using an ultrasonic cleaner followed by drying with an oil free and dry air.

03 +

The restoration needs to be placed on pyrocotton or be supported with typical sintering material during crystallization.

04 +

Only low temp glazing paste is recommended, the temp should be less than 840°C.

