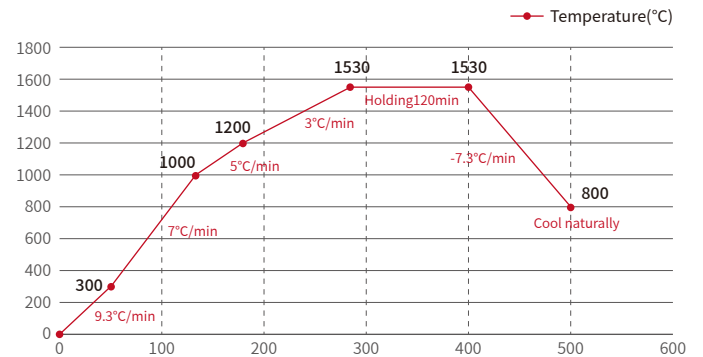


Zirconia Block Sintering Chart

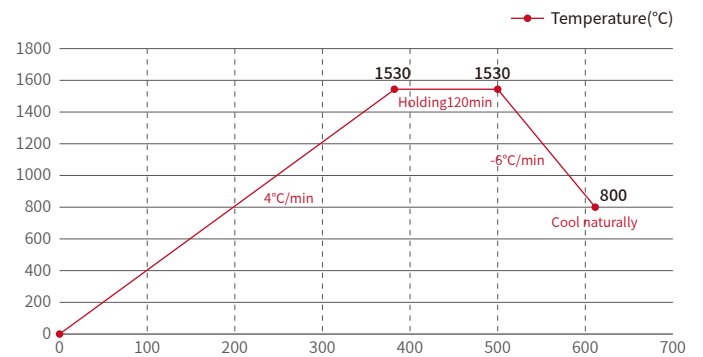
Crowns and bridges(≤5 units)(HS,HT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	20	300	30	9.3
Step2	300	1000	100	7
Step3	1000	1200	40	5
Step4	1200	1530	110	3
Step5	1530	1530	120	Holding
Step6	1530	800	100	7.3
Step7	800	Room temperature	Cool naturally	/



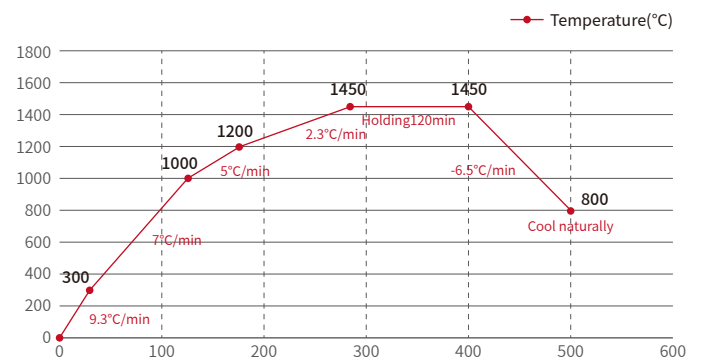
Bridges(>5 units)(HS,HT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	20	1530	378	4
Step2	1530	1530	120	Holding
Step3	1530	800	122	6
Step4	800	Room temperature	Cool naturally	/



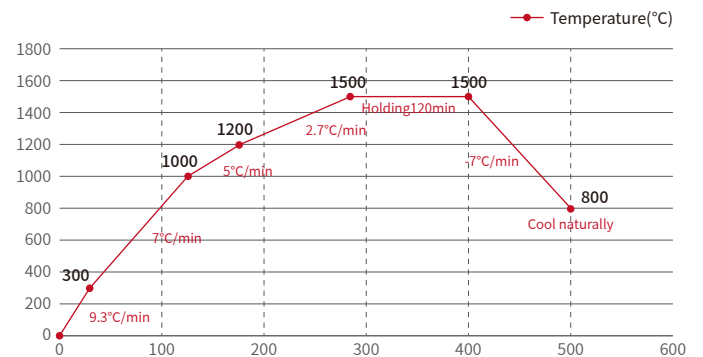
Crowns and bridges(≤3 units)(AT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	20	300	30	9.3
Step2	300	1000	100	7
Step3	1000	1200	40	5
Step4	1200	1450	110	2.3
Step5	1450	1450	120	Holding
Step6	1450	800	100	6.5
Step7	800	Room temperature	Cool naturally	/



Crowns and bridges(≤5 units)(MHT,GM,MM-4D)

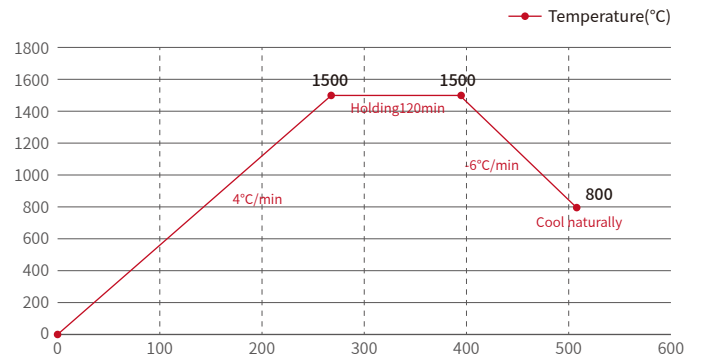
STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	20	300	30	9.3
Step2	300	1000	100	7
Step3	1000	1200	40	5
Step4	1200	1500	110	2.7
Step5	1500	1500	120	Holding
Step6	1500	800	100	7
Step7	800	Room temperature	Cool naturally	/



Zirconia Block Sintering Chart

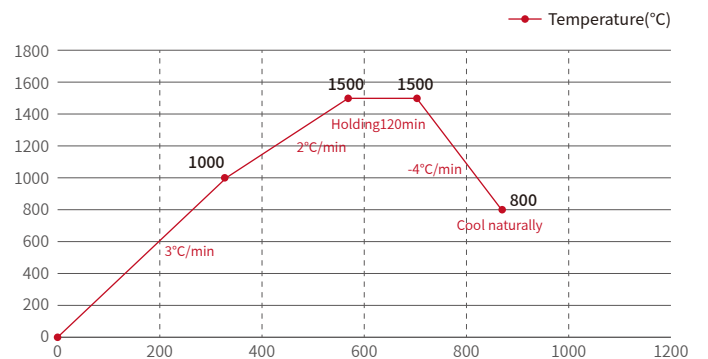
Bridges(>5 units)(MHT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	20	1500	370	4
Step2	1500	1500	120	Holding
Step3	1500	800	117	6
Step4	800	Room temperature	Cool naturally	/



Bridges(>5 units)(MM-4D)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	20	1000	326	3
Step2	1000	1500	250	2
Step3	1500	1500	120	Holding
Step4	1500	800	175	-4
Step5	800	Room temperature	Cool naturally	/



Wall and edge thickness

Type	Anterior	Connector cross section	Posterior	Connector cross section
	Thickness		Thickness	
Single crown	≥0.7mm	≥9mm ²	≥1.0mm	≥12mm ²
3 unit bridges	≥0.8mm			
Long bridges	≥1.2mm			