

Sintering program of zirconia (XT-cera)

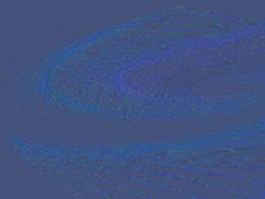
Main series:

White zirconia: SHT、 HT

Pre-shaded: SHT、 HT

Multilayer: 3D Multilayer、 SHT Multilayer

3D White: 3D white





Sintering program, applicable to HT, HTpre-shaded, SHT, SHTpre-shaded, SHTMultilayer, 3DML, 3DWhite.

Single crown		
Sintering Steps	Temperature(°C)	Time(h)
Phase 1	20-900	0.4
Phase 2	900-900	0.25
Phase 3	900-1530	0.7
Phase 4	1530-1530	1.5
Phase 5	1530-800	0.4
Phase 6	800-Natural cooling 100	Finished

Single crown		
Heating rate(°C/Min)	Temperature(°C)	Holding time(Min)
40	20-900	
	900-900	15
15	900-1530	
	1530-1530	90
30	1530-800	
	800-Natural cooling 100	Finished

≈ 5 hours (Inclusive cooling time)

The maximum temperature of the fast sintering program is recommended to slightly increase the temperature according to the actual situation (≈1530-1540)

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



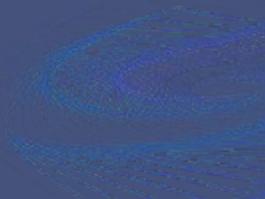
Sintering program, applicable to HT, HTpre-shaded, SHT, SHTpre-shaded, SHTMultilayer, 3DML, 3DWhite.

Three units		
Sintering Steps	Temperature(°C)	Time(h)
Phase 1	20-900	1.0
Phase 2	900-900	0.5
Phase 3	900-1530	1.5
Phase 4	1530-1530	2.0
Phase 5	1530-800	1.0
Phase 6	800-Natural cooling 100	Finished

Three units		
Heating rate(°C/Min)	Temperature(°C)	Holding time(Min)
15	20-900	
	900-900	30
7	900-1530	
	1530-1530	120
12	1530-800	
	800-Natural cooling 100	Finished

≈ 8 hours (Inclusive cooling time)

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





Sintering program, applicable to HT, HTpre-shaded, SHT, SHTpre-shaded, SHTMultilayer, 3DML, 3DWhite.

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	3.0
Phase 4	1530-1530	2.0
Phase 5	1530-800	2.5
Phase 6	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
5	1530-800	
	800-Natural cooling 100	Finished

≈ 12 hours (Inclusive cooling time)

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

