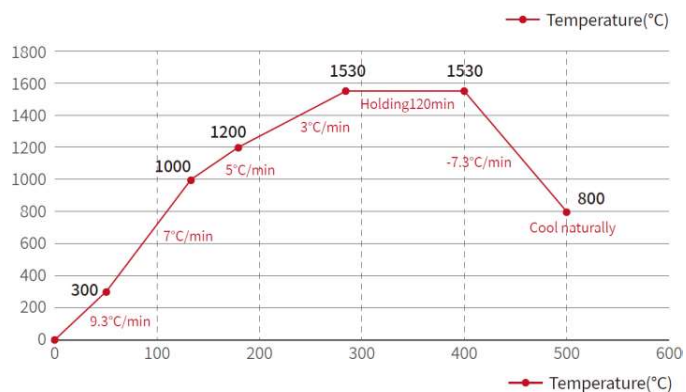


Programa de sinterización Zirconia Prime

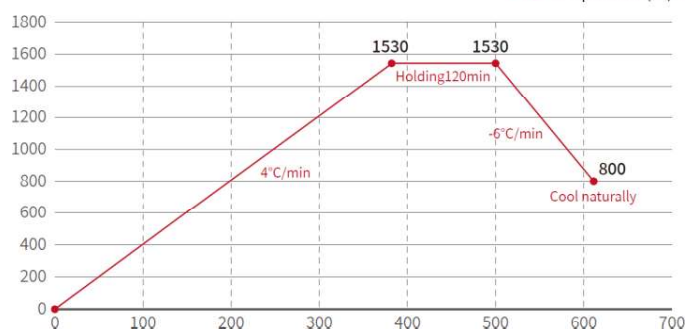
Coronas y puentes (≤ 5 unidades) (HS, HT)

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	/



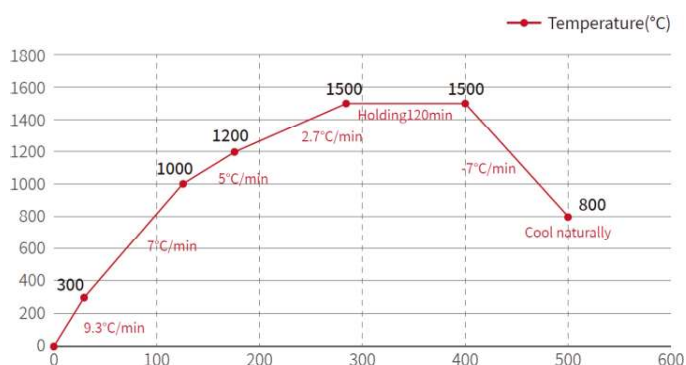
Puentes (≤ 5 unidades) (HS, HT)

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	/



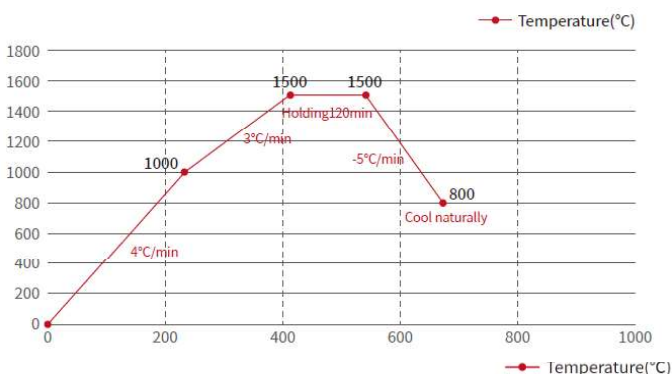
Coronas y puentes (≤ 5 unidades) (GM-3D, MM-4D)

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	/



Puentes (6-10 unidades) (MM-4D)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step1	20	1000	245	4
Step2	1000	1500	167	3
Step3	1500	1500	120	Holding
Step4	1500	800	140	-5
Step5	800	Room temperature	Cool naturally	/



Puentes (11-14 unidades) (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	/

