

Delta Anterior Unshaded Zirconia Sintering Instructions:

The ideal firing temperature for Delta Anterior Zirconia is 1450°C. Virtually all sintering furnaces have variations in temperature due to a variety of factors including the positioning of the temperature monitoring thermocouples, the design of the chamber and possible other factors. For this reason, Aurident suggests that furnace being calibrated by a variety of methods or that several test firings be done to determine the optimum temperature settings. The following tables summarize suggested firing schedules for sintering various configurations of dental restorations using Delta Anterior Zirconia.

Delta Anterior Crowns Shaded with Coloring Liquid (<3mm thickness)

Procedure	Initial Temp(°C)	Final Temp(°C)	Time(min)	Heating Rate(°C /min)
Step1	100	500	100.0	4
Step2	500	1000	62.5	8
Step3	1000	1450	112.5	4
Step4	1450	1450	120.0	0
Step5	1450	800	81.25	-8
Step6	800	150	Natural cooling	

Total time: 7 hours 56.25 minutes plus natural cooling time

Delta Anterior Crowns Shaded with Coloring Liquid (>3mm thickness)

Procedure	Initial Temp(°C)	Final Temp(°C)	Time(min)	Heating Rate(°C /min)
Step1	100	500	100 .0	4
Step2	500	1150	81.25	8
Step3	1150	1150	30.0	0
Step4	1150	1300	75.0	2
Step5	1300	1450	37.5	4
Step6	1450	1450	120.0	0
Step7	1450	800	81.25	-8
Step8	800	150	Natural cooling	

Total time: 8 hours 45 minutes plus natural cooling time

Multilayered Delta Anterior Zirconia Restorations (1 to 3 units)

Procedure	Initial Temp(°C)	Final Temp(°C)	Time(min)	Heating Rate(°C /min)
Step1	100	1150	131.25	8
Step2	1150	1150	30.0	0
Step3	1150	1300	75.0	2
Step4	1300	1450	37.5	4
Step5	1450	1450	120.0	0
Step6	1450	800	81.25	-8
Step7	800	150	Natural cooling	

Total time: 7 hours 55 minutes plus natural cooling time