Baking Schedule of Internal Stain & External Stain

| | | Dry-out time | Low Temperature | | Heat Rate | | Vacuum Level | Hold Time | High Ten | nperature | Cool Time |
|-------------------|---|--------------|-----------------|------|-----------|---------|--------------|-----------|----------|-----------|-----------|
| | | min. | °C | °F | °C/min. | °F/min. | kPa | min. | °C | °F | min. |
| EX-3 | Internal Stain | 3 | 650 | 1202 | 55 | 99 | 0 | 0 | 830 | 1526 | 0 |
| | External Stain Glazing Powder | 5 | 650 | 1202 | 50 | 90 | 0 | 0 | 910 | 1670 | 0 |
| EX-3 Press LF | Internal Stain | 5 | 500 | 932 | 50 | 90 | 0 | 0 | 720 | 1328 | 0 |
| | External Stain Glaze with Glazing Powder | 5 | 500 | 932 | 50 | 90 | 0 | 1 | 760 | 1400 | 0 |
| Cerabien | Internal Stain | 5 | 600 | 1112 | 55 | 99 | 0 | 0 | 920 | 1688 | 4 |
| | External Stain Glazing Powder | 5 | 600 | 1112 | 50 | 90 | 0 | 0 | 960 | 1760 | 4 |
| Cerabien ZR | Internal Stain | 5 | 600 | 1112 | 50 | 90 | 0 | 0 | 900 | 1652 | 4 |
| | External Stain Glazing Powder | 5 | 600 | 1112 | 50 | 90 | 0 | 0 | 930 | 1706 | 4 |
| Cerabien ZR LF | Internal Stain | 5 | 600 | 1112 | 45 | 81 | 0 | 0 | 800 | 1472 | 4 |
| | External Stain Self Glaze | 5 | 600 | 1112 | 45 | 81 | 0 | 1 | 840 | 1544 | 4 |

NOTE The above program is only a guideline, Baking temperature may be varied with the peculiarites of defferet furnace,



Notes on Safety

- ①When grinding porcelain,use an approved dust mask and a vacuum air filter to protect the lungs from breathing dust.
- ②When grinding porcelain, wear safety glasses.
- ③It is non-edible.Keep it out of the reach of children.
- contact,immediately rinse with a copious amount of water and consult a physician.
- ⑤Do not touch items heated by furnace with bare hands.
- ©Keep IS Liquid and ES Liquid away from flames and high temperatures. They are flammable.
- TIS Liquid contains ingredients which may dissolve some plastics. Please handle with extreme caution in the presence of plastic materials.
- (4) Avoid eye contact with the liquids. In the event of eye (5) This porcelain is for dental use only. Do not use for other

SYMBOLS USED IN A LABEL

| *** | MANUFACTURER | LOT | BATCH CODE |
|----------|---------------------------------|--------|---|
| <u> </u> | USE BY | REF | CATALOGUE NUMBER |
| (]i | CONSULT INSTRUCTIONS FOR USE | EC REP | AUTHORISED REPRESENTATIVE IN THE EUROPEAN COMMUNITY |

EU Authorized Representative

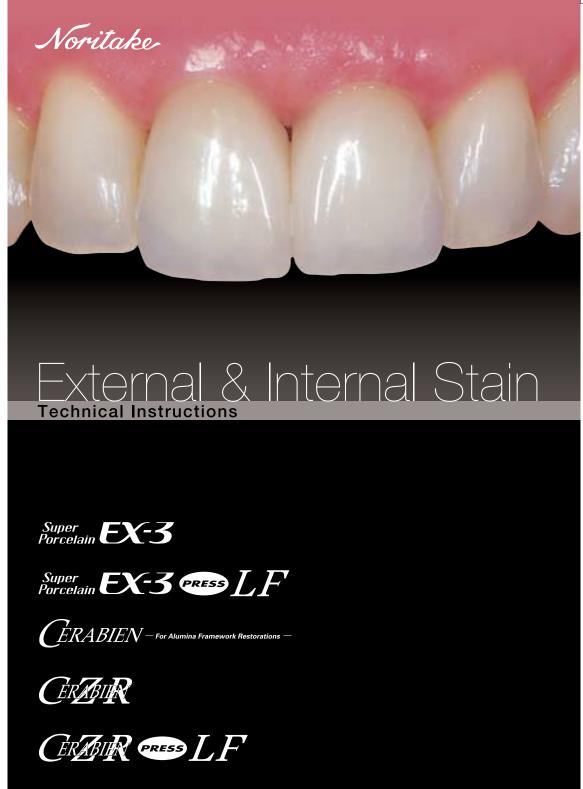
Name: Kurarav Europe GmbH Address: Phillipp-Reis-Str.4 65795 Hattersheim am Main, Germany



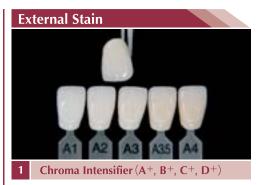
Kuraray Noritake Dental Inc.

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http://www.kuraraynoritake.com



Examples of Staining



When the shade became intermediate between A_2 and A_3 , you can easily make it to A_3 as follows:



After steam or ultrasonic cleaning, wet the whole surface with ES liquid, then apply ES A+.



Adjust the amount of A+ to match A $_3$ of Noritake Shade Guide.



Application of IS directly on cervical, incisal or occlusion area Opaque/SB/OB/Margin is very useful for producing natural color in case the porcelain space is limited.



After baking Body and Enamel, make the mamelon structure and internal shape with discs or points where necessary. After shape correction, sandblast the surface with 50µm aluminum oxide (at 0.3MPa), the ultrasonic or



3 1st IS Application and Baking

stream clean that.

Wet the surface with IS liquid before application of IS. 1st IS application is for horizontal directions. Apply the mixture of Incisarl Blue 2 and Bright (dilution) in ratio 1:1 on the mesial and distal angle. Apply A+ on cervical and central area of lingual side. Bake it according to the baking schedule.



2nd IS application is for vertical directions. To create enamel crack, apply the mixture of Mamelon Orange 2 and White in ratio 2:1. In order to give the natural look, apply Incisal Blue 2 very slightly beside the crack line. After baking, the line may look too white. Wet the surface with Noritake Detail Checker or IS liquid to create the mouth environment and check each characterization.



After baking Translucent or Luster Porcelain, make morphological correction. The characterizations of natural tooth structure is reproduced very easily.

IS Fluoro * IS Fluoro, is the clear Internal Stain to increase the fluorescence. Not only applying it after baking of Body and Enamel porcelains, but also applying to surface of zirconia coping for PFZ (porcelain fused to zirconia) and to surface of opaque for PFM (porcelain

fused to metal)



None of porcelain on the Zirconia Flamework (right)
IS Fluoro on the Zirconia Flamework (center)
Vertical section of the natural tooth (left)
*Nor available in Cerabien

Color Variation

| | External Stain | Internal Stain |
|------------------|----------------|----------------|
| Pure White | | |
| White | | |
| Gray | | * |
| Black | | |
| Blue | | |
| Incisal Blue 1 | | |
| Incisal Blue 2 | | |
| Green 1 | | |
| Green 2 | | |
| Yellow | | |
| Orange 1 | | |
| Orange 2 | | |
| Mamelon Orange 1 | | |
| Mamelon Orange 2 | | |
| Cervical 1 | | |
| Cervical 2 | | |
| Cervical 3 | | |
| Earth Brown | | |
| Reddish Brown | | |
| Salmon Pink | | |
| Pink | | |
| Red | | |
| A+ | | |
| B+ | | |
| C+ | | |
| D+ | | |

*Not available in Cerabien