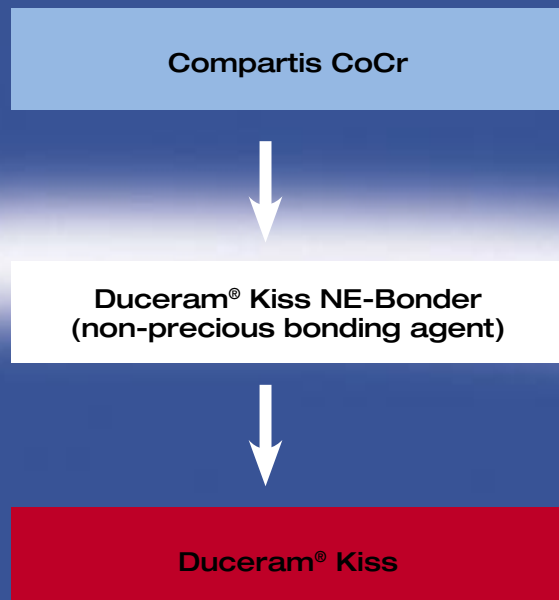


Safe veneering guideline for Compartis CoCr and Duceram[®] Kiss

(When working with Compartis CoCr frameworks, be sure to consult the most recent Compartis instructions for use)

Since non-precious alloys and precious alloys react differently to ceramic firing, ensure that the following parameters are observed for safe veneering of Compartis CoCr:

- Use only cross-cut tungsten-carbide cutters to finish the framework.
- During finishing, make sure the framework is free of sharp edges.
Sandblast the framework using 250 µm alumina at a pressure of 3–4 bar.
- No oxide firing is required.
- Steam down and rinse after each firing. Sandblast if appropriate.



Safe veneering guideline for Compartis CoCr and Duceram® Kiss

(When working with Compartis CoCr frameworks, be sure to consult the most recent Compartis instructions for use)

Make sure to follow the special firing parameters during veneering:

NE-Bonder is mixed with Ducera® Liquid B or OCL universal and applied to the framework in a uniform semi-covering layer. The NE-Bonder is fired at 980 °C, which ensures that it is sintered to the framework in a homogeneous fashion and the subsequent vitrification is performed in a uniform manner. This in turn ensures that the non-precious alloy bonds securely to the ceramic veneer.

Firing recommendations:

Firing	Pre-heating °C	Drying time min	Heating rate °C/min	Final temp. °C	Holding time min	Vacuum hPa	Tempering
NE-Bonder	575	7:00	55	980	2:00	50	–
Paste opaque	575	7:00	55	950	2:00	50	–
Powder opaque	575	5:00	55	950	2:00	50	–
Shoulder 1+2	575	7:00	55	930	1:00	50	–
Dentine 1	575	6:00	55	920	1:00	50	3 min/850 °C
Dentine 2	575	4:00	55	910	1:00	50	3 min/850 °C
Glaze firing	575	3:00	55	890	1:00	–	3 min/850 °C
Korrektur (Final Kiss)	575	4:00	55	880	1:00	50	3 min/850 °C
Final Shoulder	450	4:00	55	660	1:00	50	–

CTE:

25–500 °C $\mu\text{m}/\text{m}\cdot\text{K}$	14,3
25–600 °C $\mu\text{m}/\text{m}\cdot\text{K}$	14,6

Stress relief cooling down to base temperature can be performed independently of the CTE value. To compensate for the low thermal conductivity of the Compartis CoCr alloy, it is recommended to increase the firing temperature or to extend the firing time for all bridges spanning more than six units for all dentine firings.

The values listed here are intended for orientation only and should be regarded only as guidelines. Your firing results may differ. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. Therefore, the guideline values will have to be adapted individually for each firing. We recommend running a test firing cycle to evaluate the performance of the furnace used. We have compiled and checked all values and other data with great care. However, we cannot under any circumstances be liable for your results.