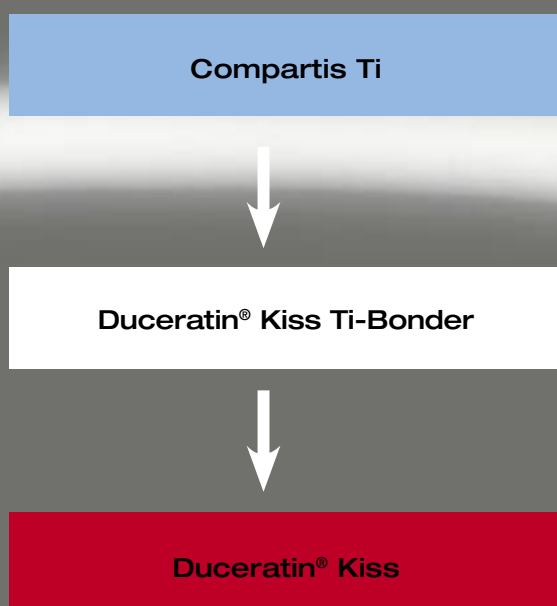


Instructions for secure veneering of Compartis Ti with Duceratin[®] Kiss

(The current Compartis finishing Instructions must be followed when finishing Compartis Ti frameworks)

Because of the different behaviour of base-metal alloys and precious-metal alloys during the ceramic firing process, the following points for secure trimming of Compartis Ti should be noted:

- Use only cross-serrated hard-metal cutters suitable for titanium to trim the framework.
- The thickness of the crown wall must not be less than 0.5 mm because of the high ductility of the metal.
- Ensure no sharp edges remain after trimming the framework. The framework must be sand-blasted with 100-150 µm aluminium oxide at 2 bar pressure.
- Trimmed titanium surfaces must be left for 10 to 15 minutes after being worked on and sandblasting for passivation before they are cleaned with water or steam-cleaned.
- Allow to evaporate or rinse off after every firing.



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(The current Compartis finishing Instructions must be followed when finishing Compartis Ti frameworks)

Please note the special firing parameters for the veneering:

The titanium bonder is mixed with the Ducera[®] Liquid B and applied in a uniform coating to the framework. Then the titanium bonder is fired at 750 °C, during which it is homogenously sintered to the framework for a uniform glaze on the surface of the framework. This ensures a secure adhesion bond between the Ti alloy and the veneering ceramic.

Firing recommendation:

General firing program	Preheat temp.	Drying and preheat time	Heat rate	Firing temp.	Holding time	Vacuum
	°C	min	°C/min	°C	min	hPa
Ti adhesion bonder	600	6:00	100	750	1:00	50
Opaque firing 1	450	10:00	100	760	0:30	50
Opaque firing 2	450	10:00	100	760	0:30	50
Shoulder compound	450	8:00	55	780	1:00	50
Dentine firing 1	450	9:00	55	760	1:00	50
Dentine firing 2	450	8:00	55	750	1:00	50
Glaze firing	450	6:00	55	730	1:00	–
Correction (Final Kiss)	450	8:00	55	680	1:00	50
Final Shoulder	450	8:00	55	680	1:00	50

Heat expansion coefficient:

25–500 °C $\mu\text{m}/\text{m}\cdot\text{K}$	9.5
25–600 °C $\mu\text{m}/\text{m}\cdot\text{K}$	9.6

For bridges of more than six components we recommend increasing the temperature or extending the firing time for all dentine firings.

These values are reference values and are for guidance purposes only. Different firing results may be achieved. The firing results depend on the furnace output and are therefore dependent on the manufacturer and the age of the furnace. The reference values must be adjusted as required for every firing. We recommend a test firing to check the furnace. We have prepared and checked all information carefully, but cannot accept any liability.