

Baking Schedule of Internal Stain & External Stain

		Dry-out time min.	Low Temperature		Heat Rate		Vacuum Level kPa	Hold Time min.	High Temperature		Cool Time min.
			°C	°F	°C/min.	°F/min.			°C	°F	
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 peculiarities of different furnace.



Notes on Safety

- ① When grinding porcelain, use an approved dust mask and a vacuum air filter to protect the lungs from breathing dust.
- ② When grinding porcelain, wear safety glasses.
- ③ It is non-edible. Keep it out of the reach of children.
- ④ Avoid eye contact with the liquids. In the event of eye contact, immediately rinse with a copious amount of water and consult a physician.
- ⑤ Do not touch items heated by furnace with bare hands.
- ⑥ Keep IS Liquid and ES Liquid away from flames and high temperatures. They are flammable.
- ⑦ IS Liquid contains ingredients which may dissolve some plastics. Please handle with extreme caution in the presence of plastic materials.
- ⑧ This porcelain is for dental use only. Do not use for other purposes.
- ⑨ For use only by dentists and dental technicians.

SYMBOLS USED IN A LABEL

	MANUFACTURER		BATCH CODE	EU Authorized Representative Name: Kuraray Europe GmbH Address: Philipp-Reis-Str. 4 65795 Hattersheim am Main, Germany
	USE BY		CATALOGUE NUMBER	
	CONSULT INSTRUCTIONS FOR USE		AUTHORISED REPRESENTATIVE IN THE EUROPEAN COMMUNITY	

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External & Internal Stain Technical Instructions

Super Porcelain **EX-3**

Super Porcelain **EX-3 PRESS LF**

CERABIEN — For Alumina Framework Restorations —

CZR

CZR PRESS LF

Examples of Staining

External Stain



1 Chroma Intensifier (A+, B+, C+, D+)

When the shade became intermediate between A₂ and A₃, you can easily make it to A₃ as follows:



2

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



3

Adjust the amount of A+ to match A₃ of Noritake Shade Guide.

Internal Stain



1 Internal Staining on Opaque/SB/OB/Margin

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.



2 Surface Treatment of Body and Enamel

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 stream clean that.



3 1st IS Application and Baking

Wet the surface with IS liquid before application of IS. 1st IS application is for horizontal directions. Apply the mixture of Incisal 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.



4 2nd IS Application and Baking

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.



5 Completion

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 Framework (right)
IS Fluoro on the Zirconia Framework (center)
Vertical section of the natural tooth (left) * Not 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