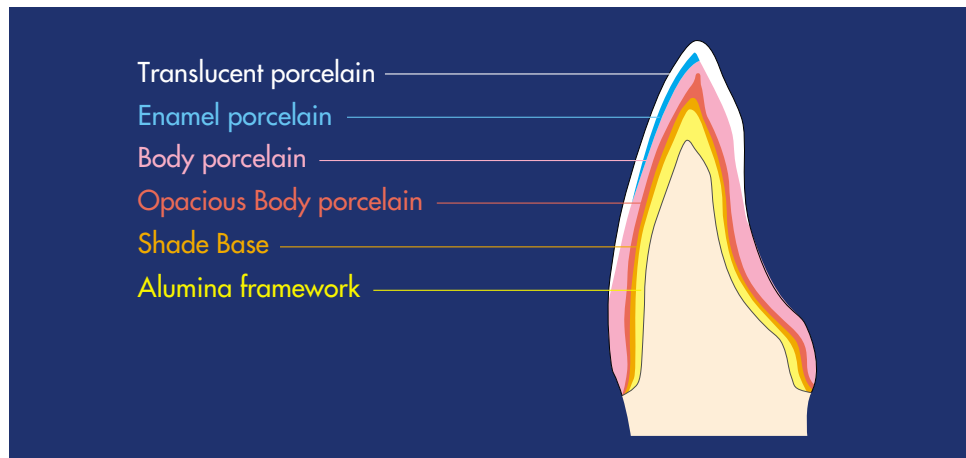


Baking Schedule for Cerabien

		1	2	3	4	5	6	7	8
Dry-Out Time	min.	5	5	7	5	7	5	5	5
Low Temperature	°C	600	600	600	600	600	600	600	600
	°F	1112	1112	1112	1112	1112	1112	1112	1112
Start Vacuum	°C	600	600	600	—	600	—	—	—
	°F	1112	1112	1112	—	1112	—	—	—
Heat Rate	°C/min.	50	45	45	55	45	50	50	45
	°F/min.	90	81	81	99	81	90	90	81
Vacuum Level	kPa *	96	96	96	0	96	0	0	0
Release Vacuum	°C	1030	960	960	—	960	—	—	—
	°F	1886	1760	1760	—	1760	—	—	—
Hold Time	with vacuum	min.	—	—	1	—	—	—	—
	in the air	min.	1	1	1	—	1	0.5	—
High Temperature	°C	1030	960	960	920	960	960	960	900
	°F	1886	1760	1760	1688	1760	1760	1760	1652
Cool Time	min.	4	4	4	4	4	4	4	4

Note The above program is only a guideline.
 Baking Temperature may be varied with the peculiarities of different furnace.
 ※96kPa = 72cmHg (29inchesHg)

Layering of Cerabien



PORCELAIN GUIDELINE

1. Margin Porcelain 1st and 2nd Bake
2. Shade Base Porcelain 1st and 2nd Bake
3. Body and Enamel (and Translucent) Bake
4. Internal Stain 1st and 2nd Bake
5. Translucent Overlay Bake and Minor Adjustments
6. Self Glaze
7. Glazing Powder and External Stain Bake
8. MRP and Add-on Bake

Noritake

Sold by
Noritake Dental Supply Co., Limited
 320-3 Higashiyama, Miyoshi-cho, Nishikamo-gun, Aichi, 470-0293 Japan
 Phone +81-5613-2-8953 Fax +81-5613-2-8976

Manufactured by
Noritake Kizai Co., Limited
 3-1-36 Noritake-shinmachi, Nishi-ku, Nagoya, 451-8501 Japan

Shade	A ₁	A ₂	A ₃	A _{3.5}	A ₄	B ₁	B ₂	B ₃	B ₄	C ₁	C ₂	C ₃	C ₄	D ₂	D ₃	D ₄	NW ₀	NW _{0.5}	NP _{1.5}	NP _{2.5}
Shade Base	SBA ₁	SBA ₂	SBA ₃	SBA _{3.5}	SBA ₄	SBB ₁	SBB ₂	SBB ₃	SBB ₄	SBC ₁	SBC ₂	SBC ₃	SBC ₄	SBD ₂	SBD ₃	SBD ₄	SBNW ₀	SBNW _{0.5}	SBNP _{1.5}	SBNP _{2.5}
Margin	MA ₁	MA ₂	MA ₃	MA _{3.5}	MA ₄	^{※1} MB ₁	MB ₂	MB ₃	MB ₄	^{※1} MC ₁	MC ₂	^{※1} MC ₃	MC ₄	^{※1} MD ₂	MD ₃	MD ₄	MNW ₀	MNW _{0.5}	MNP _{1.5}	MNP _{2.5}
Opacious Body	OBA ₁	OBA ₂	OBA ₃	OBA _{3.5}	OBA ₄	OBB ₁	OBB ₂	OBB ₃	OBB ₄	OBC ₁	OBC ₂	OBC ₃	OBC ₄	OBD ₂	OBD ₃	OBD ₄	-	-	OBNP _{1.5}	OBNP _{2.5}
Body	A ₁ B	A ₂ B	A ₃ B	A _{3.5} B	A ₄ B	B ₁ B	B ₂ B	B ₃ B	B ₄ B	C ₁ B	C ₂ B	C ₃ B	C ₄ B	D ₂ B	D ₃ B	D ₄ B	NW ₀ B	NW _{0.5} B	NP _{1.5} B	NP _{2.5} B
Cervical	-	^{※2} CV-1	^{※3} CV-1	^{※3} CV-1	CV-1	-	^{※2} CV-2	^{※3} CV-2	CV-2	-	^{※2} CV-3	^{※3} CV-3	CV-3	^{※2} CV-4	^{※3} CV-4	CV-4	-	-	-	^{※2} CV-1
Enamel	E ₂	E ₂	E ₃	E ₃	E ₃	E ₁	E ₂	E ₃	E ₃	E ₂	E ₃	E ₃	E ₃	E ₂	E ₃	E ₃	E ₁	E ₁	E ₂	E ₂

※1.To acquire shades of B₁,C₁,C₃,D₂ use B₂,C₂,C₄,D₃ and dilution powder (MDL) . The proportion is 1:1.

※2.Mix Body with Cervical at the ratio of 2:1

※3.Mix Body with Cervical at the ratio of 1:1

Translucent	Tx	T ₀	T ₁	T ₂
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Luster	LT ₀	LT ₁	TBlue	LT Natural	Creamy Enamel	Sun Bright	Incisal Aureola	Creamy White
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Among the translucent porcelains, the degree of translucency is as follows : Tx > T₀ > T₁ > T₂

Margin	M Clear	M Orange	M Peach	MDL	MRP
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Opacious Body	OB White	OB Orange	OB Pale Pink
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Add-on	AD-T	AD-B
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MRP is retouching powder for margin.

MDL is dilution powder.

Modifier	White	Gray	Blue	Yellow	Light Orange	Orange	Brown	Pink	Dark Pink	Coral Pink	Mamelon-1	Mamelon-2	Light Tissue	Dark Tissue
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