



ZENOSTAR Zr Translucent pure



Full contour ZENOSTAR restorations

ZENOSTAR Zr Translucent pure restorations are shaded by means of color infiltration prior to sintering.



1. Separating

When milling is finished, the work must be trimmed from the blank at the bars.



2. Sanding

Smooth down the cervical and body areas with fine-grain sandpaper. Suitable grinding tools can be used to characterize the occlusal surface.

N.B.

Avoid cracks, edge chipping, sharp edges, grooves and undersized work or areas.



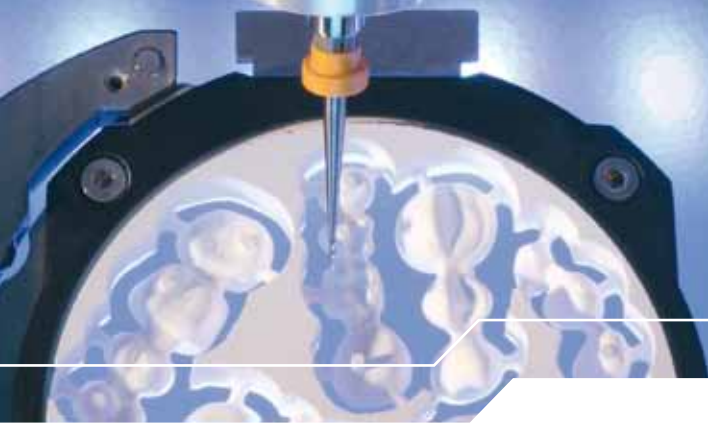
3. Shading the cervical and body zones

The degree of shading is determined by the number of brush strokes. By varying the number of circular passes and the number of times the brush is dipped etc, the tooth shade can be adjusted to achieve the desired esthetic effect. This requires a little experience. The table below shows typical values and can be taken as a guideline.

N.B.

If the work is to be glazed after sintering, the number of passes must be increased.

Procedure	Cervical zone		Body zone	
	without glaze	with glaze	without glaze	with glaze
	3 x	5 x	2 x	3 x
Number of times the brush is dipped per pass	5 x		5 x	
Brush stroke	circular →		vertical ↑	
Brush adapter	ZENOSTAR nylon brush, large 6901999003			



POLISHING BRUSH

EFFECT SHADES



4. Shading the occlusal zone

Eight effect shades are available for individualizing the occlusal surfaces. These shades are dabbed on sparingly with the small nylon brush (6901999002).

Occlusal zone	Effektfarbe
Cusp sides, peak, ridge	Ivory, white, grey-violet
Central fissure, secondary fissure	Brown, orange
Triangular bulges, cusp crests	Ivory, white

Tip

Before each color change, rinse the brush in water and dab dry.

5. Drying at 80 °C

N.B.

The work must be dry before sintering. The drying times given here are only intended as a guide.

Tip

Weigh the work before and after shading. This will give an indication of when the work is dry.

Type of restoration	Drying time [hours]
Single crown	0.5
1-7 unit bridge	0.5
> 7 units	2

The more voluminous the work, the longer it should be allowed to dry. Very heavy and wet restorations can therefore require a drying time of over four hours. This prevents any damage occurring to the furnace and to the restoration itself.



POLISHING PASTE

THREE-ZONE BRUSH TECHNIQUE



6. Sintering: standard program 1450 °C / 2h

	Temp. 1 [°C]	Temp. 2 [°C]	Heat rise [°C/hour]	Dwell time [hours.]
Heating phase	20	900	600	
Dwell phase	900	900	0	0.5
Heating phase	900	1450	200	
Dwell phase	1450	1450	0	2
Cooling phase	1450	900	600	
Cooling phase	900	20	500	

N.B.

- Sinter without cooling
- Sintering conditions apply to all types of restoration



7. Polishing

The restoration must be evenly polished with a Bison hair brush and the ZENOSTAR Polish diamond polishing paste. Here, it is important to polish the occlusal surface to a high shine; this prevents abrasion to the opposing teeth.



8. Individualization through staining and glazing

If required, ZENOSTAR stains can be used to individualize the work still further:

Applying ZENOSTAR Magic Glaze

Apply the spray glaze thinly and evenly. For best results, hold the work in tweezers and rotate it whilst spraying. ZENOSTAR Magic Glaze does not retract from the edges and does not form beads on polished surfaces. This process prepares the work for the subsequent application of the ZENOSTAR Art Module stains.



COLORING SOLUTIONS

Glaze bake

Carry out a glaze bake to fix the glaze (see the firing program below).

Individual shading

Then individually characterize the glazed work with the stains of the ZENOSTAR Art module. After this, carry out a stain bake (see the firing program below).

Tip

To achieve an especially rich glaze and color depth with 3D effect, an additional glaze bake can be carried out (930 °C / 2 min).

Standard firing program ZENOSTAR glaze/stain bake

	Preheat temp. [°C]	Drying time [min]	Heat rise [°C/min]	Firing temp. [°C]	Dwell time [min]	Vacuum [%]	Relief cooling [min]
Glaze bake	575	5	45 / 15	900	1	---	6
Stain bake	575	5	45 / 15	890	1	---	6
2nd glaze bake (optional)	575	5	45 / 15	930	2	---	6

Important: Full contour crowns are fired at a heating rate of 45°C/min. Full contour bridges are fired at a heating rate of 45°C/min

Crown and bridge frameworks in ZENOSTAR Zr Translucent pure:

ZENOSTAR Zr Translucent pure is also ideally suited for the fabrication of crown and bridge frameworks. Individual shading is achieved by using the ZENOTEK Color Zr coloring liquids, which are available in the 16 shades of the classical shade guide, and the ZENOTEK Color Optimizer.

N.B.

For best results, mix the ZENOTEK Color Zr coloring liquid and the ZENOTEK Color Optimizer in a ratio of 2:1.

The shading recommendations standard values. If you prefer a lighter shade, we recommend Zenoflex dimension one light for veneering.

If you prefer darker shades, we recommend Zenoflex dimension one intense.

You also can change the mixing proportion of ZENOTEK Color Zr and ZENOTEK Color Optimizer to your own perception.

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