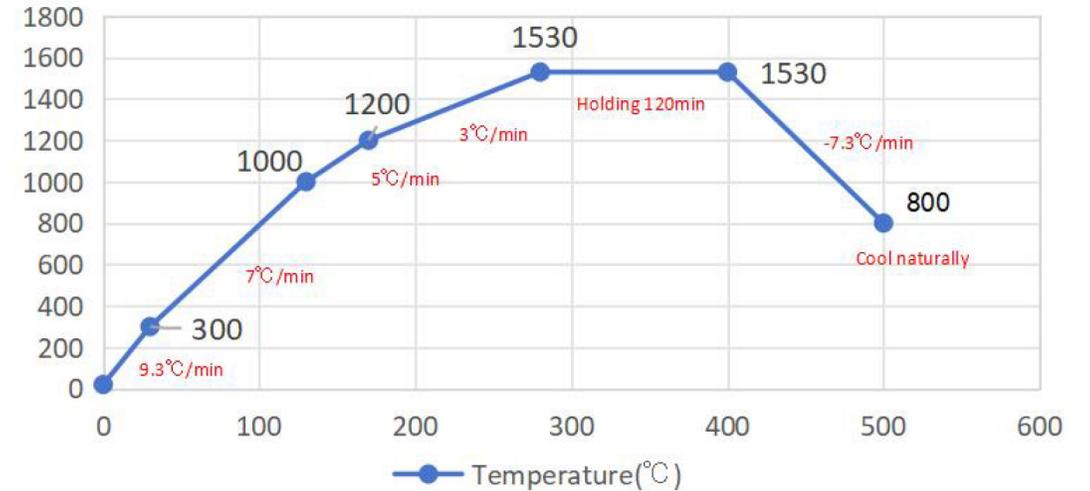


Nobilcam MM4D Zirconia Sintering Programme

Crowns and bridges (≤ 5 units) (HS,HT)

STEP	Start temperature($^{\circ}\text{C}$)	End temperature($^{\circ}\text{C}$)	Time(min)	Rate of Climb($^{\circ}\text{C}/\text{min}$)
Step 1	20	300	30	9.3
Step 2	300	1000	100	7
Step 3	1000	1200	40	5
Step 4	1200	1530	110	3
Step 5	1530	1530	120	Holding
Step 6	1530	800	100	7.3
Step 7	800	Room temperature	Cool naturally	/

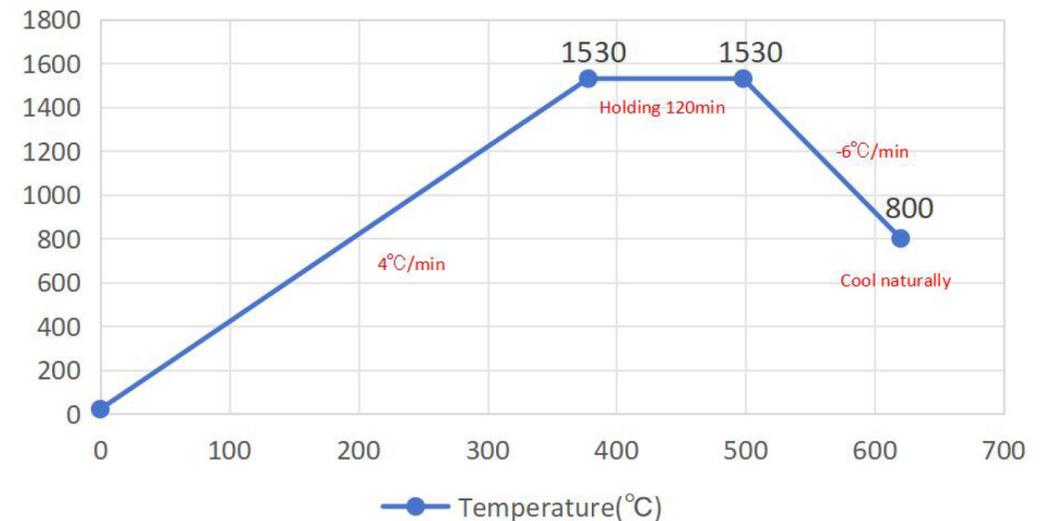
Crowns and bridges (≤ 5 units) (HS,HT)



Bridges (> 5 units) (HT,HS)

STEP	Start temperature($^{\circ}\text{C}$)	End temperature($^{\circ}\text{C}$)	Time(min)	Rate of Climb($^{\circ}\text{C}/\text{min}$)
Step 1	20	1530	378	4
Step 2	1530	1530	120	Holding
Step 3	1530	800	122	6
Step 4	800	Room temperature	Cool naturally	—

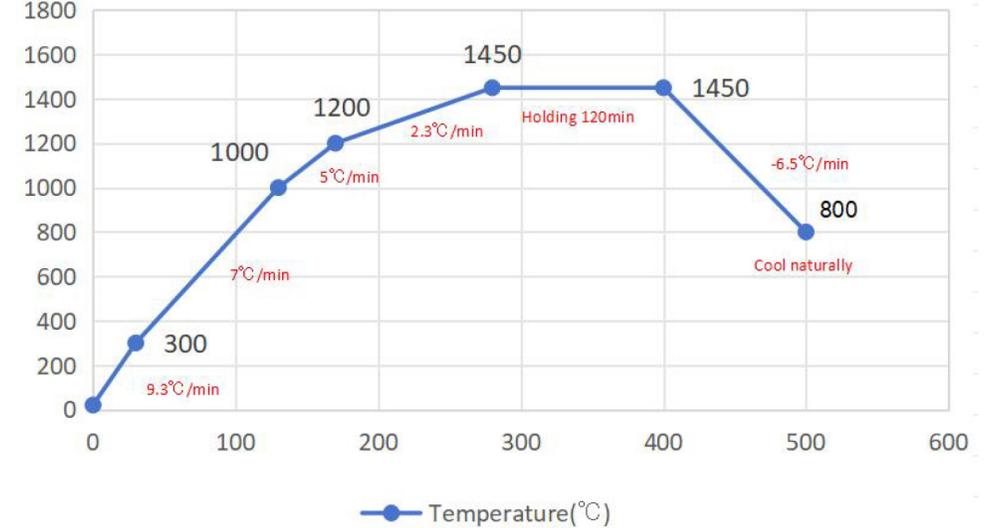
Bridges (> 5 units) (HT, HS)



Crowns and bridges (≤ 3 units) (AT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step 1	20	300	30	9.3
Step 2	300	1000	100	7
Step 3	1000	1200	40	5
Step 4	1200	1450	110	2.3
Step 5	1450	1450	120	Holding
Step 6	1450	800	100	6.5
Step 7	800	Room temperature	Cool naturally	—

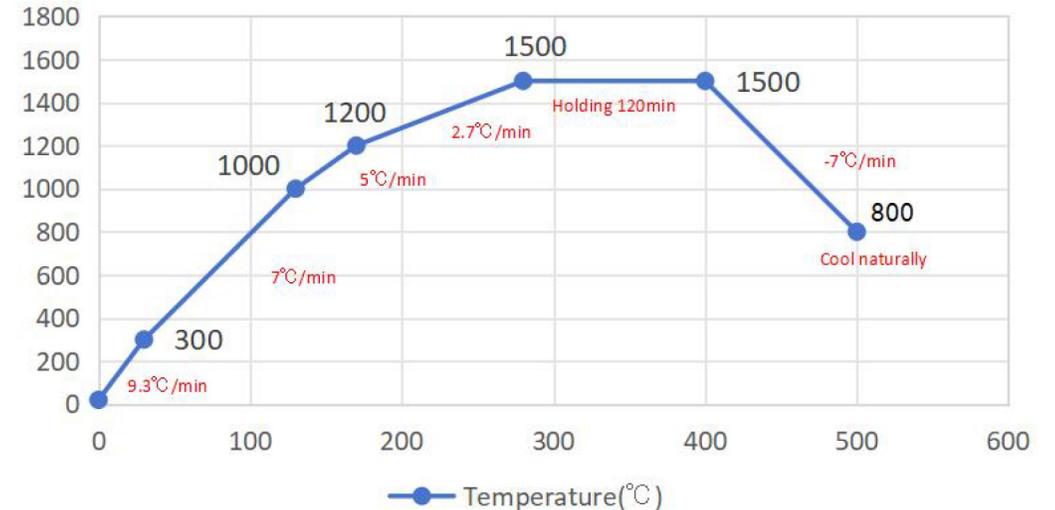
Crowns and bridges (≤ 3 units) (AT)



Crowns and bridges (≤ 5 units) (MHT,GM-3D,MM-4D)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step 1	20	300	30	9.3
Step 2	300	1000	100	7
Step 3	1000	1200	40	5
Step 4	1200	1500	110	2.7
Step 5	1500	1500	120	Holding
Step 6	1500	800	100	7
Step 7	800	Room temperature	Cool naturally	—

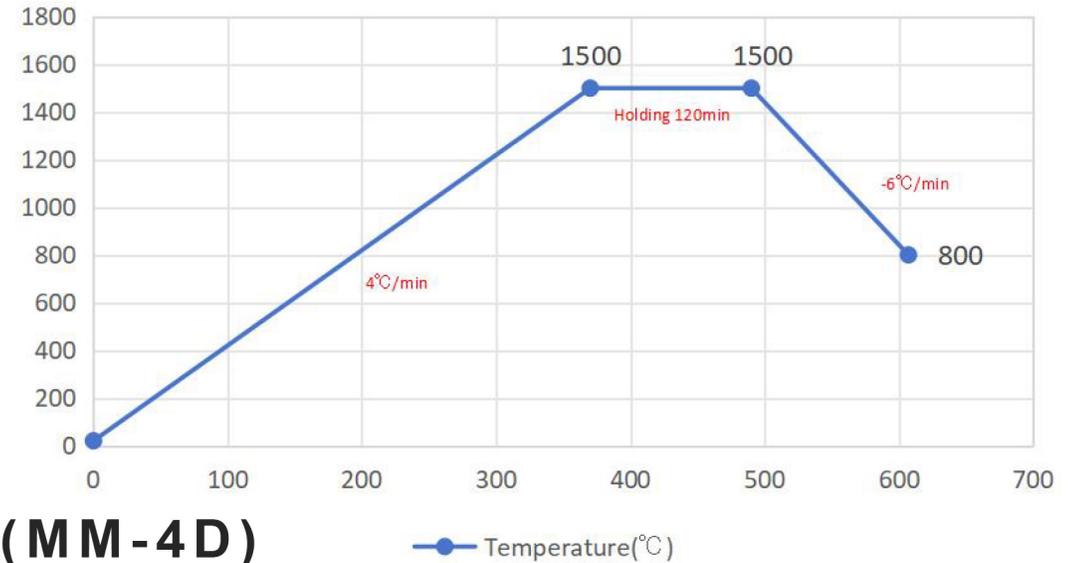
Crowns and Bridges (≤ 5 units) (HT PLUS, MHT,GM)



Bridges (>5 units) (MHT)

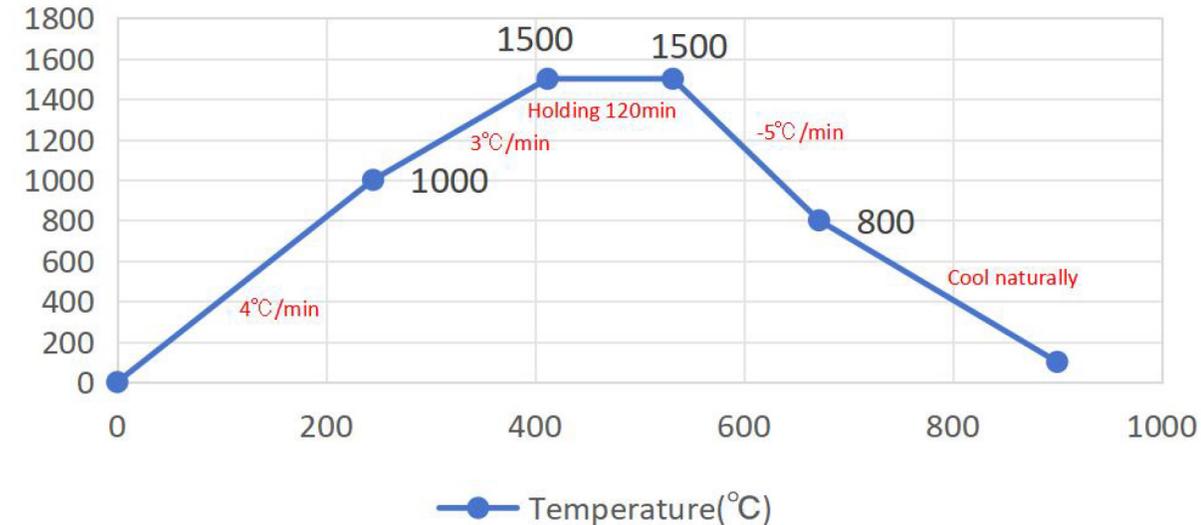
STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step 1	20	1500	370	4
Step 2	1500	1500	120	Holding
Step 3	1500	800	117	6
Step 4	800	Room temperature	Cool naturally	—

Bridges (>5 units) (MHT, HT PLUS)



Bridges (6-10 units) (MM-4D)

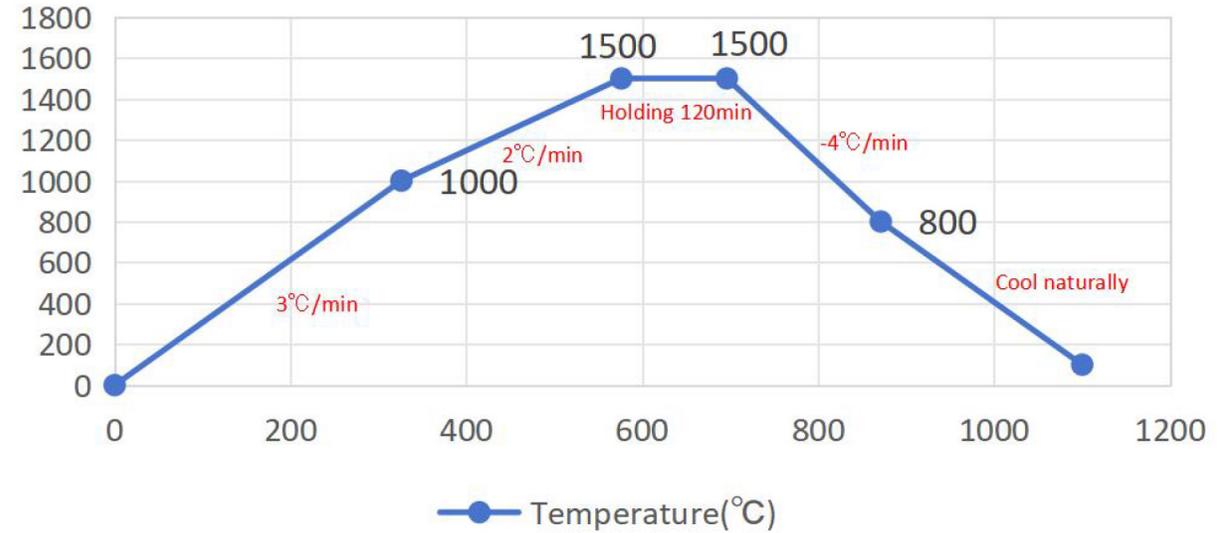
STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step 1	20	1000	245	4
Step 2	1000	1500	167	3
Step 3	1500	1500	120	0
Step 4	1500	800	140	-5
Step 5	800	natural cooling 20	/	/



※ Wall thickness should be no less than 0.7mm and connectors no thinner than 9mm².

Bridges (11-14 units) (MM-4D)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step 1	20	1000	326	3
Step 2	1000	1500	250	2
Step 3	1500	1500	120	0
Step 4	1500	800	175	-4
Step 5	800	natural cooling 20	/	/



Wall and edge thickness

Type	Anterior	Connector cross section	Posterior	Connector cross section
	Thickness		Thickness	
single crown	≥0.9mm	≥9mm ³	≥1.0mm	≥12mm ³
3 unit bridges	≥0.9mm			
long bridges	≥0.9mm			

