



# Sintering Guidelines

## Zirlux Anterior Multi

Program Steps	Starting Temperature (°C/Min)	Finishing Temperature (°C/Min)	Time Min.	Heating Rate (°C/Min)
1	Room Temperature	1150	140.63	8
2	1150	1150	30	0
3	1150	1300	75	2
4	1300	1450	120	0
5	1450	1450	120	0
6	1450	800	81.25	-8
7	800	100	Furnace Cooling	

## Zirlux Esthetic TR and Zirlux Complete

Program Steps	Starting Temperature (°C/Min)	Finishing Temperature (°C/Min)	Time Min.	Heating Rate (°C/Min)
1	Room Temperature	1150	140	8
2	1150	1150	30	0
3	1150	1300	75	2
4	1300	1480	45	4
5	1480	1480	120	0
6	1480	800	85	-8
7	800	100	Furnace Cooling	

\*Always refer to the manufacturer's instructions for proper use and placement of the material in the furnace.

**It is essential to follow these steps and the instructions for the specific sintering furnace you are using.**

1. Dry the restoration completely before sintering.
2. Position the restoration on the sintering crucible leaving space between each unit.
3. Program your furnace according to its instructions for use according to the specific sintering program shown on the chart above.
4. Run the sintering cycle.
5. Wait until cool-down is completed before removing the sintered restoration.
6. Inspect the restoration for flaws such as chips, seating, occlusion, interproximal contacts, and marginal integrity.
7. If necessary, make small adjustments with a water-cooled diamond milling bur using a high-speed handpiece polishing tool for Zirconia and pay attention while polishing to avoid subfissure and edge break.
8. Once all grinding is complete, rinse the restoration with water and dry it completely. Framework is now ready for veneering.
9. Full-contour restoration is ready for glazing. Follow the instructions for use of the stain and glaze system of choice for application and firing parameters.

### Tips for Success

- Reserve 2–4mm in the incisal area.
- Prior to milling, ensure you identify the natural layering shade on the crown after adding the specific layer information.
- This confirms the incisal, cervical, and body areas are correctly balanced post-sintering.