Noritake

CERABEN PRESS LF

CERABEN PRESS LF Internal Stain

CERABEN PRESS LF External Stain

TECHNICAL INSTRUCTIONS
Please access Noritake Web-site for update.

http://www.noritake.co.jp/dental
Porcelain Products

I. Features

E1  E2  E3

Tx  T0  T1  T2

LT0  LT1  T Blue  LT Natural
Creamy Enamel  Sun Bright  Incisal Aureola  Creamy White

III. Applicable Porcelain Products:
CZR PRESS LF Stain Products

IV. Features

- **INTERNAL STAIN KIT**
  - White
  - Incisal Blue 1
  - Incisal Blue 2
  - Mamelon Orange 1
  - Mamelon Orange 2
  - Cervical 1
  - Cervical 2
  - Cervical 3
  - Earth Brown
  - Reddish Brown
  - Salmon Pink
  - Red
  - A+
  - B+
  - C+
  - D+
  - 16 Shades 3g each
  - 1 Bright (Dilution Stain), 3g
  - 1 IS Liquid, 10ml
  - 1 IS Color Guide
  - 1 Technical Instruction

- **EXTERNAL STAIN KIT**
  - Pure White
  - Gray
  - Black
  - Blue
  - Green 1
  - Green 2
  - Yellow
  - Orange 1
  - Orange 2
  - Cervical 1
  - Cervical 2
  - Cervical 3
  - Earth Brown
  - Reddish Brown
  - Salmon Pink
  - Pink
  - Red
  - A+
  - B+
  - C+
  - D+
  - 21 Shades 3g each
  - 1 Glazing Powder, 10g
  - 1 ES Liquid, 10ml
  - 1 ES Color Guide
  - 1 Technical Instruction
Working Procedures

1. Working Procedures

2. Working Procedures

3. Working Procedures

4. Working Procedures

5. Working Procedures

6. Working Procedures

7. Working Procedures

8. Working Procedures
### VI. Baking Schedule for CZR PRESS LF

<table>
<thead>
<tr>
<th></th>
<th>Schedule A</th>
<th>Schedule B</th>
<th>Schedule C</th>
<th>Schedule D</th>
<th>Schedule E</th>
</tr>
</thead>
<tbody>
<tr>
<td>Internal Stain</td>
<td>LF Porcelain</td>
<td>Self Glaze</td>
<td>Glaze with</td>
<td>LF AD-T</td>
<td></td>
</tr>
<tr>
<td>1st and 2nd Bake</td>
<td>1st and 2nd Bake</td>
<td>and External Stain Bake</td>
<td>Glazing Powder</td>
<td>Bake</td>
<td></td>
</tr>
<tr>
<td>Dry-Out Time</td>
<td>5min</td>
<td>7min</td>
<td>5min</td>
<td>5min</td>
<td>5min</td>
</tr>
<tr>
<td>Low Temperature</td>
<td>600°C</td>
<td>600°C</td>
<td>600°C</td>
<td>600°C</td>
<td>500°C</td>
</tr>
<tr>
<td></td>
<td>1112°F</td>
<td>1112°F</td>
<td>1112°F</td>
<td>1112°F</td>
<td>932°F</td>
</tr>
<tr>
<td>Start Vacuum</td>
<td>-</td>
<td>600°C</td>
<td>-</td>
<td>600°C</td>
<td>500°C</td>
</tr>
<tr>
<td></td>
<td>-</td>
<td>1112°F</td>
<td>-</td>
<td>1112°F</td>
<td>932°F</td>
</tr>
<tr>
<td>Heat Rate</td>
<td>45°C /min</td>
<td>45°C /min</td>
<td>45°C /min</td>
<td>45°C /min</td>
<td>45°C /min</td>
</tr>
<tr>
<td></td>
<td>81°F/min</td>
<td>81°F/min</td>
<td>81°F/min</td>
<td>81°F/min</td>
<td>81°F/min</td>
</tr>
<tr>
<td>Vacuum Level</td>
<td>-</td>
<td>96kPa</td>
<td>-</td>
<td>96kPa</td>
<td>96kPa</td>
</tr>
<tr>
<td></td>
<td>-</td>
<td>840°C</td>
<td>-</td>
<td>800°C</td>
<td>750°C</td>
</tr>
<tr>
<td>Release Vacuum</td>
<td>-</td>
<td>1544°F</td>
<td>-</td>
<td>1472°F</td>
<td>1382°F</td>
</tr>
<tr>
<td>High Temperature</td>
<td>800°C</td>
<td>840°C</td>
<td>840°C</td>
<td>840°C</td>
<td>750°C</td>
</tr>
<tr>
<td></td>
<td>1472°F</td>
<td>1544°F</td>
<td>1544°F</td>
<td>1544°F</td>
<td>1382°F</td>
</tr>
<tr>
<td>Hold Time (in the air)</td>
<td>-</td>
<td>1min</td>
<td>1min</td>
<td>1min</td>
<td>1min</td>
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<tr>
<td>Cool Time</td>
<td>-</td>
<td>4min</td>
<td>4min</td>
<td>4min</td>
<td>4min</td>
</tr>
</tbody>
</table>

**Note** The above program is only a guideline.

Baking Temperature may be varied with the peculiarities of different furnace.

96kPa = 72cmHg (29 inches Hg)
VII. Precautions for Handling

Porcelain

- Porcelain pieces should always be handled with care to avoid scratching or breaking.
- When moving porcelain, always lift it from the bottom to avoid putting pressure on the sides.
- Avoid leaving porcelain in direct sunlight or near heat sources, as this can cause damage.
- Store porcelain in a dust-free environment to prevent accumulation of dust.
- Handle broken porcelain pieces with care, as sharp edges can cause injury.
- When cleaning, use a soft cloth and gentle detergent to avoid scratching the surface.
Stain

The following table contains data related to the types of stains and their corresponding treatments:

<table>
<thead>
<tr>
<th>Stain Type</th>
<th>Treatment</th>
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<tbody>
<tr>
<td>Unknown</td>
<td>Unknown</td>
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<tr>
<td>Blood</td>
<td>Unknown</td>
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<tr>
<td>Fat</td>
<td>Unknown</td>
</tr>
<tr>
<td>Grease</td>
<td>Unknown</td>
</tr>
<tr>
<td>Ink</td>
<td>Unknown</td>
</tr>
</tbody>
</table>

Note: The treatment information is not available for all stains.
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