

# Sintering ArgenZ Zirconia

## Standard Cycle

Total Time = 7.5 hours

For all zirconia material.

Best results for standard units including ArgenZ ST Multilayer bridges. Full tray / full oven

Stage	Program	Rate / Minute	Temperature	Time
1	Heating Ramp	10°C	900°C	
2	Heating Ramp	7°C	1510°C	
3	Hold Time / Heat Soak		1510°C	120 minutes
4	Cooling Ramp	7°C	1000°C	
5	Cooling Ramp	10°C	200°C	

## Long Cycle

Total Time = 14 hours

For HT+ and Ultra ONLY. DO NOT run ArgenZ ST Multilayer or Anterior on this cycle

For large bridges and thick walled units

Stage	Program	Rate / Minute	Temperature	Time
1	Heating Ramp	4°C	1510°C	
2	Hold Time / Heat Soak		1510°C	150 minutes
3	Cooling Ramp	4°C	200°C	

## Short Cycle\*

Total Time = 4.5 hours

For all zirconia material.

Single standard size units. 10-12 units Single tray per sintering cycle

Stage	Program	Rate / Minute	Temperature	Time
1	Heating Ramp	20°C	900°C	
2	Hold Time / Heat Soak		900°C	10 minutes
3	Heat Ramp	10°C	1525°C	
4	Hold Time / Heat Soak		1525°C	120 minutes
5	Cooling Ramp	35°C	400°C	

## Speed Cycle\*

Total Time = 120 minutes

For all zirconia material.\*\*

Single standard size units. 5-7 units Single tray per sintering cycle

Stage	Program	Rate / Minute	Temperature	Time
1	Heating Ramp	55°C	900°C	
2	Heat Ramp	15°C	1535°C	
3	Hold Time / Heat Soak		1535°C	50 minutes
4	Cooling Ramp	65°C	800°C	

## Super Speed Cycle\*

Total Time = 90 minutes

For all zirconia material.\*\*

Single standard size units. 3-5 units Single tray per sintering cycle

Stage	Program	Rate / Minute	Temperature	Time
1	Heating Ramp	60°C	900°C	
2	Heat Ramp	33°C	1555°C	
3	Hold Time / Heat Soak		1555°C	45 minutes
4	Cooling Ramp	65°C	800°C	

\*Speed sintering cycles may affect translucency and shade accuracy. Fast sintering can increase sensitivity to other factors such as the size, thickness of units, and number of units in the furnace.

\*\*Results may vary by material

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