

# Sintering ArgenZ Zirconia for KDF

## 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	Temperature	Time
1	Heating Ramp	900°C	1 hour 30 minutes
2	Heating Ramp	1510°C	1 hour 27 minutes
3	Hold Time / Heat Soak	1510°C	2 hours
4	Cooling Ramp	1000°C	1 hour 12 minutes
5	Cooling Ramp	200°C	1 hour 20 minutes

## 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	Temperature	Time
1	Heating Ramp	1510°C	6 hours 17 minutes
2	Hold Time / Heat Soak	1510°C	2 hours 30 minutes
3	Cooling Ramp	200°C	5 hours 27 minutes

## 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	Temperature	Time
1	Heating Ramp	900°C	45 minutes
2	Hold Time / Heat Soak	900°C	10 minutes
3	Heat Ramp	1525°C	1 hour 2 minutes
4	Hold Time / Heat Soak	1525°C	2 hours
5	Cooling Ramp	400°C	32 minutes

## Speed Cycle\*

**Total Time = 120 minutes**

For all zirconia material.\*\*

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

Stage	Program	Platform Position	Temperature	Time
1	Heating Ramp	0	900°C	16 minutes
2	Heat Ramp	0	1535°C	42 minutes
3	Hold Time / Heat Soak	0	1535°C	50 minutes
4	Cooling Ramp	3	800°C	11 minutes
5	Cooling Ramp	5	200°C	9 minutes

## 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	Platform Position	Temperature	Time
1	Heating Ramp	0	900°C	15 minutes
2	Heat Ramp	0	1555°C	20 minutes
3	Hold Time / Heat Soak	0	1555°C	45 minutes
4	Cooling Ramp	3	800°C	11 minutes
5	Cooling Ramp	5	200°C	9 minutes

\*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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