



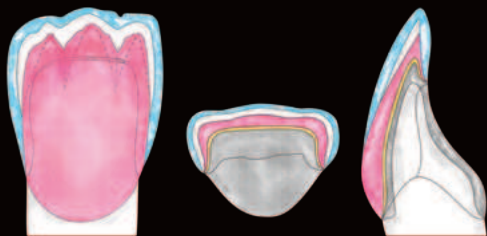
Shade	W0	W1	W2	W3	A1	A2	A3	A3.5	A4	B1	B2	B3	B4	C1	C2	C3	C4	D2	D3	D4	
Base Opaque	 BASE																				
Shade Opaque																					
Cervical							A3B:2 AC:1	A3.5B:1 AC:1	A4B:1 AC:1			B3B:1 BC:1	BC		C2B:2 CC:1	C3B:1 CC:1	CC		D2B:1 DC:1	D3B:1 DC:1	BC:1 DC:2
Margin		W0M:2 NM:1	W0M:1 NM:2							NM:1 B2M:1		B2M:1 B4M:1		NM:1 C2M:1		C2M:1 C4M:1		NM:1 D3M:1		D3M:1 B4M:1	
Opaque Dentin		OD-W0:2 OD-N:1	OD-W0:1 OD-N:2																		
Body																					
Opal			OPAL56:2 OPAL57:1	OPAL56:1 OPAL57:2																	
Incisal																					
Enamel Effect	 T																				

Opal							Opal Effect												
Incisal					Enamel Effect														
Margin Effect								Color Effect											
Uni-Layer			Cervical					Opaque Modifier											
Gum							Correction												

LAYERING DIAGRAM

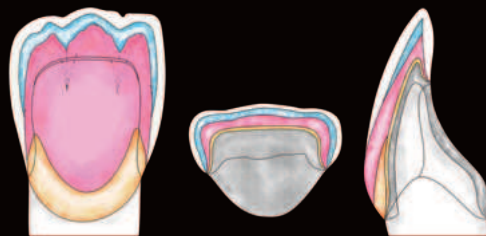
2-LAYER TECHNIQUE (Opalescent layering)

■ OPAL Incisal ■ OPAL T ■ Body
■ Opaque ■ Metal



3-LAYER TECHNIQUE (Non-opalescent layering)

■ T ■ Incisal ■ Body ■ Cervical
■ Opaque ■ Metal



FIRING SCHEDULE

	Drying temp.	Drying time	Pre-heating time	Vacuum-start temp.	Increasing temp.	Final temp.	Vacuum-end temp.	Hold time
Base opaque powder	500 °C	5 min	1 min	500 °C	60 °C/min	960 °C	960 °C	1 min
Shade opaque powder	500 °C	5 min	1 min	500 °C	60 °C/min	950 °C	950 °C	1 min
Base opaque paste	500 °C	5 min	1 min	500 °C	60 °C/min	960 °C	960 °C	1 min
Shade opaque paste	500 °C	5 min	1 min	500 °C	60 °C/min	950 °C	950 °C	1 min
1. Margin	650 °C	5 min	1 min	650 °C	50 °C/min	940 °C	940 °C	0.5 min
2. Margin	650 °C	5 min	1 min	650 °C	50 °C/min	930 °C	930 °C	0.5 min
1. Cervical, Body, Opaque Dentin, Opal, Incisal, Opal Effect, Enamel Effect, Uni-Layer, Color Effect	650 °C	5 min	2 min	650 °C	50 °C/min	910 °C	910 °C	0.5 min
2. Cervical, Body, Opaque Dentin, Opal, Incisal, Opal Effect, Enamel Effect, Uni-Layer, Color Effect	650 °C	5 min	2 min	650 °C	50 °C/min	900 °C	900 °C	0.5 min
VINTAGE Art Glaze	600 °C	5 min	2 min	—	60 °C/min	870 °C	—	—
Gum	650 °C	7 min	2 min	650 °C	50 °C/min	900 °C	900 °C	0.5 min
Gum - Glaze	650 °C	5 min	2 min	—	60 °C/min	900 °C	—	0.5 min
Correction	650 °C	5 min	1 min	650 °C	60 °C/min	870 °C	870 °C	0.5 min
Correction - Glaze	650 °C	5 min	2 min	—	60 °C/min	870 °C	—	0.5 min

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