



Quick Start Instructions

Build-Up Technique

Porcelain Margins *NOTE: The porcelain margins are applied and fired prior to the liner application.*



Substructure Design



Apply Die Sealer, then
Die Release



First Shoulder Application



First Shoulder Firing



Second Shoulder Application



Shoulder Margin Completed



Liner Applied
Fire and Apply a 2nd Layer



Margin and Liner
Completed

Liner Application



Apply the Powder Liner
Do not use
CeramcoPFZ Press Paste Liner



Fire according to the
Firing Chart



Reapply the Liner



Fire according to the
Firing Chart

Porcelain Application



Apply Opaceous Dentin



Apply the Dentin and
Cut-Back



Apply the Enamel Porcelain



Fire according to the
Firing Chart



Contour using Diamond Burs



Apply the Stain and Glaze
Fire according to the Chart



Completed Basic Build-Up



Completed Advanced
Build-Up

Ceramco® PFZ Build-Up Technique Firing Temperatures

FIRING PROGRAMS IN °C	Time (min)					Vacuum	Set Temp		Temperature				
	Dry	Pre Heat	Vac Hold	Hi Temp Hold	Cool	Set Point (in. Hg)	Idle	Hi Temp	Vac Start	Vac Stop	Heat Rate °C/min	Night	Low Term Cooling (min)
Margin/Margin Modifier	5	5	0	15 sec	0	29	450	970	450	970	60	100	0
Liner, 1st Bake	5	5	0	1 min	0	29	450	930	450	900	60	100	0
Liner, 2nd Bake	5	5	0	0	0	29	450	920	450	900	60	100	0
Op Dentin/Dentin/Mod/Enamels, 1st Bake	5	5	0	15 sec	0	29	450	900	450	900	60	100	0
Op Dentin/Dentin/Mod/Enamels, 2nd Bake	5	5	0	0	0	29	450	890	450	890	60	100	0
Natural Glaze/Stains	5	5	0	30 sec	0	0	450	870			60	100	6
Overglaze/Stains	5	5	0	30 sec	0	0	450	850			60	100	6
Add-On	5	5	0	0	0	29	450	860	450	860	60	100	6

FIRING PROGRAMS IN °F	Time (min)					Vacuum	Set Temp		Temperature				
	Dry	Pre Heat	Vac Hold	Hi Temp Hold	Cool	Set Point (in. Hg)	Idle	Hi Temp	Vac Start	Vac Stop	Heat Rate °F/min	Night	Low Term Cooling (min)
Margin/Margin Modifier	5	5	0	15 sec	0	29	842	1778	842	1778	108	212	0
Liner, 1st Bake	5	5	0	1 min	0	29	842	1706	842	1652	108	212	0
Liner, 2nd Bake	5	5	0	0	0	29	842	1688	842	1652	108	212	0
Op Dentin/Dentin/Mod/Enamels, 1st Bake	5	5	0	15 sec	0	29	842	1652	842	1652	108	212	0
Op Dentin/Dentin/Mod/Enamels, 2nd Bake	5	5	0	0	0	29	842	1634	842	1634	108	212	0
Natural Glaze/Stains	5	5	0	30 sec	0	0	842	1598			108	212	6
Overglaze/Stains	5	5	0	30 sec	0	0	842	1562			108	212	6
Add-On	5	5	0	0	0	29	842	1580	842	1580	108	212	6

Ceramco® PFZ Build-Up Table 1

Shade	Natural Enamel	Opal Effect Enamel	Margin Porcelain	Mamelon	Dentin Modifier
A1	Extra Light	Opal Light	A1	Yellow-Orange	A1
A2	Light	Opal Light	A1	Yellow-Orange	A1
A3	Light	Opal Light	A3	Red-Orange	A1
A3.5	Light	Opal Medium	A3	Red-Orange	A3.5
A4	Medium	Opal Medium	A4	Red-Orange	A3.5
B1	Extra Light	Opal White	B2	Yellow-Orange	B1
B2	Light	Opal Light	B2	Yellow-Orange	B1
B3	Medium	Opal Light	A3	Red-Orange	B3
B4	Medium	Opal Light	A4	Red-Orange	B3
C1	Light	Opal Light	C1	Yellow-Orange	C1
C2	Medium	Opal Light	C1	Yellow-Orange	C1
C3	Medium	Opal Medium	C3	Red-Orange	C3
C4	Medium	Opal Medium	C3	Red-Orange	C3
D2	Extra Light	Opal Light	C1	Yellow-Orange	A1
D3	Medium	Opal Light	A3	Yellow-Orange	B1
D4	Medium	Opal Light	A3	Red-Orange	C3

Ceramco® PFZ PZ Shade Series Build-Up Technique

PFZ PZ Shade Series Shade	Keyed to the Vita® 3D-Master® Shade Series	Liner/ Opaqueous Dentin/ Dentin	Enamel	Margin	Dentin Modifier
101	1M1	101	PFZ Light	A1	A1
102	1M2	102	PFZ Light	B2	A1
203	2L1.5	203	PFZ Light	B2	A1
204	2L2.5	203	PFZ Light	B2	A1
205	2M1	205	PFZ Light	B2	B1
206	2M2	206	PFZ Light	B2	B1
207	2M3	207	PFZ Light	B2	A1
208	2R1.5	208	PFZ Light	B2	B1
209	2R2.5	209	PFZ Light	A3	B1
310	3L1.5	310	PFZ Light	C1	B1
311	3L2.5	311	PFZ Light	A3	B3
312	3M1	312	PFZ Light	C1	B1
313	3M2	313	PFZ Light	C3	B1
314	3M3	314	PFZ Light	A3	B3
315	3R1.5	315	PFZ Light	C3	A1
316	3R2.5	316	PFZ Light	A3	B3
417	4L1.5	417	PFZ Light	C3	B1
418	4L2.5	418	PFZ Light	A4	A3.5
419	4M1	419	PFZ Light	C3	C1
420	4M2	420	PFZ Light	C3	A3.5
421	4M3	421	PFZ Light	A4	A3.5
422	4R1.5	422	PFZ Medium	C3	C3
423	4R2.5	423	PFZ Medium	A4	A3.5
524	5M1	524	PFZ Medium	C3	C3
525	5M2	525	PFZ Medium	A4	A3.5
526	5M3	526	PFZ Medium	A4	A3.5

Ceramco® PFZ Illuminé Build-Up Technique

Shade	Liner/ Margin	Dentin	Opaqueous Dentin	Enamel
i1	illuminé	i1	i1	Natural Enamel Extra Light
i3	illuminé	i3	i3	Natural Enamel Extra Light
i5	illuminé	i5	i5	Opal Enamel White
i7	illuminé	i7	i7	Opal Enamel White

¹Vita® and 3D-Master® are registered trademarks of Vita Zahnfabrik H. Rauter GmbH & Co.

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