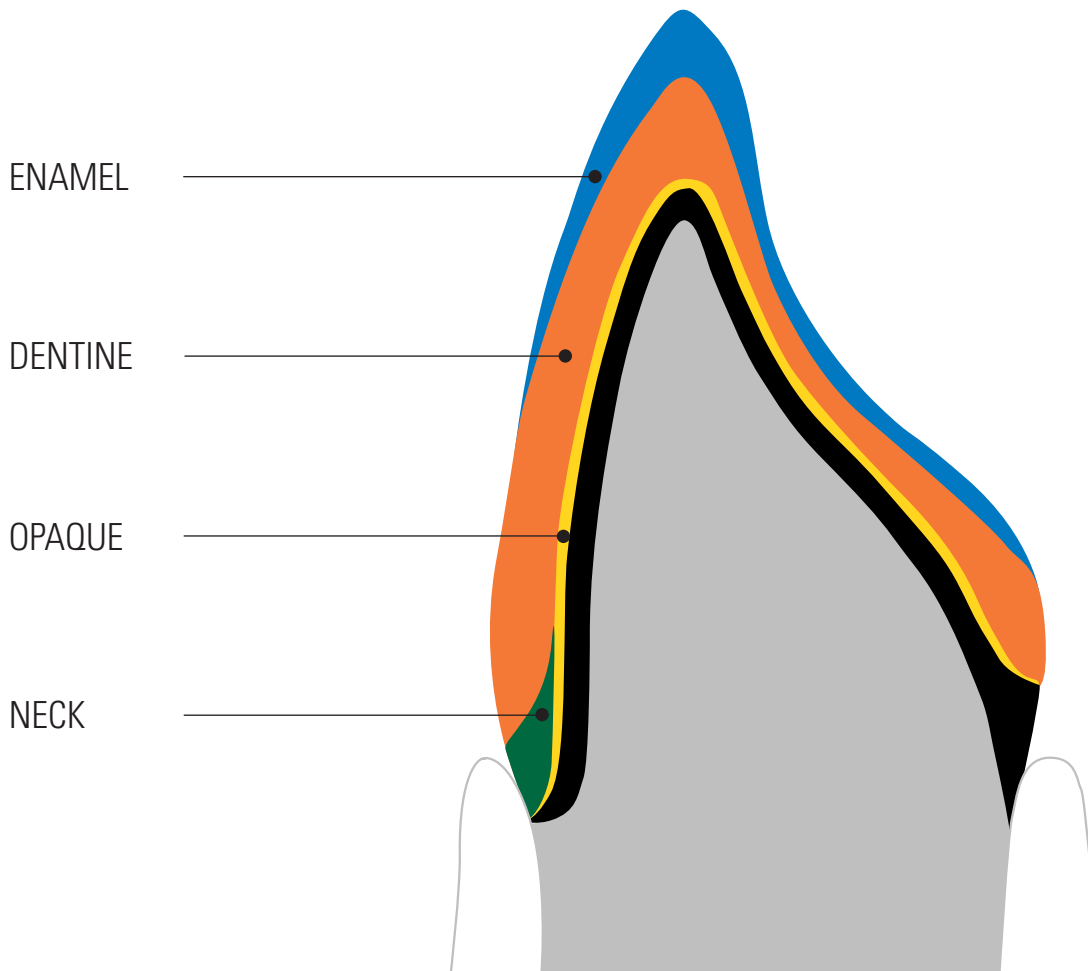


Standard layering of VITA VMK 95 METAL CERAMICS



Information on framework design

In order to produce crowns that are to be veneered with porcelain or pontics, reduced-size anatomical forms must be modelled. The wall thickness of the framework must not be less than 0.4 mm to ensure that the minimum thickness of the metal framework amounts to 0.3 – 0.35 mm after finishing. When modelling, sharp edges, undercuts and deep grooves must be avoided.

Every effort should be made to achieve smooth transition zones. Sufficiently stable modellation of the approximal connections must be ensured. For extra stability (especially for large-span bridges) the palatal side of the pontics should be waxed-up with a thin metal collar or at least with inlay-like proximal reinforcements.

The directions of the manufacturer of the alloy regarding waxing-up, investing, casting, finishing, sandblasting and oxidation must be observed.



Recommended firing cycle

Firing	Preh. Temp. °C	→	↗	Temp. approx. °C	→	VAC
Dentine firing	600	6.00	6.00	930	1.00	6.00

The given values are to be seen only as a guideline for the user. Should the surface characteristics, transparency or the degree of lustre not correspond to the result expected under optimum conditions, the firing cycle should be adjusted accordingly. The decisive factor for the firing cycle is not the firing temperature displayed by the furnace, but the appearance and the surface characteristics of the object after firing.

- Shows the individually built-up crown after firing.

Firing Chart VITA VMK 95

Recommended firing cycle

Firing	Preh. Temp. °C	→	↗	Temp. approx. °C	→	VAC
Oxidation	Follow alloy manufacturer's instructions!					
Wash firing	600	2.00	4.00	950	1.00	4.00
PASTE WASH OPAQUE	500	6.00	6.00	950	1.00	6.00
OPAQUE firing	600	2.00	4.00	930	1.00	4.00
PASTE OPAQUE	500	6.00	6.00	930	1.00	6.00
MARGIN						
(Shoulder porcelain firing)	600	6.00	6.00	930	1.00	6.00
DENTINE firing	600	6.00	6.00	930	1.00	6.00
2 nd DENTINE firing	600	6.00	6.00	930	1.00	6.00
3 rd DENTINE firing	600	6.00	6.00	920	1.00	6.00
CORRECTIVE	600	4.00	6.00	900	1.00	0.00
Glaze firing	600	0.00	4.00	930	1.00	0.00
Glaze firing						
using Akzent Fluid	600	4.00	4.00	930	1.00	0.00
Glaze firing using Akz 25	600	4.00	4.00	900	1.00	0.00

To obtain an optimal metal/ceramic bond, the ceramic should be under slight compressive strain.

A good result also depends on the size of the workpiece, the type, hardness and heat conducting properties of the alloy used, and particularly on the way each individual technician carries out the firing.

Our practical experience has shown that good results can be achieved when the thermal expansion coefficient of the alloy – measured between 25 °C and 600 °C – lies in the range of $14.0 - 14.4 \times 10^{-6} \times K^{-1}$ and that of the VITA VMK ceramic between $13.4 - 13.8 \times 10^{-6} \times K^{-1}$. With higher thermal expansion coefficients, it is often necessary to use a slow cooling programme in order to ensure that cooling from 900 °C – 700 °C is not faster than 3 minutes.

Presentation VITA VMK 95 in the VITA SYSTEM 3D-MASTER®



STANDARD SET 12 with POWDER OPAQUE *

Quantity	Content	Material
1	12 g	WASH OPAQUE
26	12 g	OPAQUE
26	12 g	DENTINE
5	12 g	NECK
2	12 g	ENAMEL
1	12 g	TRANSLUCENT
1	12 g	WINDOW
1	50 ml	OPAQUE FLUID
1	50 ml	MODELLING FLUID
1	pack	Firing supports A + B
1	pack	Firing trays G
1		Shade indicator VITA VMK 95 3D-MASTER with 112 laminae
2		VITA Toothguide 3D-MASTER
1		Working instructions

* VITA VMK 95 STANDARD SET 12 also available with PASTE OPAQUE



PASTE OPAQUE SET

Quantity	Content	Material
1	7 g	PASTE WASH OPAQUE
26	5 g	PASTE OPAQUE
1	15 g	PASTE OPAQUE LIQUID
1		Mixing spatula
1		Flat brush
1		Working instructions



OPAQUE DENTINE SET

Quantity	Content	Material
26	12 g	OPAQUE DENTINE
1		Working instructions



STARTER KIT 3M2 with Powder opaque*

Quantity	Contents	Material
1	12 g	OPAQUE
1	12 g	DENTINE
1	12 g	NECK
1	12 g	ENAMEL
1	15 g	OPAQUE FLUID
1	50 ml	MODELLING FLUID
1	50 ml	VITA Toothguide 3D-MASTER
1		Working instructions

* VITA VMK 95 STARTER KIT 3M2 also available with paste opaque



ADDITIONAL SET

Quantity	Content	Material
3	12 g	TRANSLUCENT
4	12 g	DENTINE MODIFIER
7	12 g	MARGIN
2	12 g	CORRECTIVE
1	12 g	CERVICAL
2	12 g	GINGIVA
2		Shade sample blades
1		Working instructions



MARGIN KIT

Quantity	Content	Material
7	12 g	MARGIN
1		Shade sample blade
1		Working instructions

COLOR OPAQUE

C03, C06, C07 are available separately as 12g Powder and 5g Paste.

Presentation VITA VMK 95 classical

STANDARD SET

containing:

Material	VITAPAN classical with Powder opaque*	
	Set 12	SET 50
WASH OPAQUE	1 x 12g	1 x 12g
OPAQUE	16 x 12g	16 x 12g
DENTINE	16 x 12g	16 x 50g
ENAMEL	2 x 12g	2 x 50g
NECK	4 x 12g	4 x 12g
TRANSLUCENT	1 x 12g	1 x 12g
WINDOW	1 x 12g	1 x 12g
MODELLING FLUID	1 x 50ml	1 x 50ml
OPAQUE FLUID	1 x 50ml	1 x 50ml
VMK 95 Shade indicator	1	1
Firing trays G	1 set	1 set
Working instructions Nr. 905	1	1

* each also available with PASTE OPAQUE.

VITA VMK 95 classical 6-COLOR-SET [◇] with Powder opaque *

containing:

Contents	Material
1 x 12g	WASH OPAQUE
6 x 12g	OPAQUE
6 x 12g	DENTINE
2 x 12g	ENAMEL
1 x 12g	TRANSLUCENT T4
1 x 50ml	OPAQUE FLUID
1 x 50ml	MODELLING FLUID
1	Shade indicator
1	Working instructions

[◇] available in the VITAPAN shades A2/A3/A3,5/B2/B3 and D3

* each also available with PASTE OPAQUE

VITA VMK 95 classical PASTE OPAQUE SET

containing:

Contents	Material
1 x 7g	PASTE WASH OPAQUE
16 x 5g	PASTE OPAQUE
1 x 15ml	PASTE OPAQUE LIQUID
1	Flat brush
1	Mixing spatula
1	Working instructions

VITA VMK 95 classical OPAQUE DENTINE SET

containing:

Contents	Material
16 x 12g	OPAQUE DENTINE
1	Working instructions