



NOBILCAM Zirconia Block Sintering Chart

Chart 1. Crowns and bridges (≤ 5 units) (HT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step 1	20	300	30	9.3
Step 2	300	1000	100	7
Step 3	1000	1200	40	5
Step 4	1200	1530	110	3
Step 5	1530	1530	120	Holding
Step 6	1530	800	100	7.3
Step 7	800	Room temperature	Cool naturally	—

Chart 2. Bridges (>5 units) (HT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step 1	20	1530	378	4
Step 2	1530	1530	120	Holding
Step 3	1530	800	122	6
Step 4	800	Room temperature	Cool naturally	—

Chart 4. Crowns and bridges (≤ 5 units) (MHT, GM)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step 1	20	300	30	9.3
Step 2	300	1000	100	7
Step 3	1000	1200	40	5
Step 4	1200	1500	110	2.7
Step 5	1500	1500	120	Holding
Step 6	1500	800	100	7
Step 7	800	Room temperature	Cool naturally	—

Chart 5. Bridges (>5 units) (MHT)

STEP	Start temperature(°C)	End temperature(°C)	Time(min)	Rate of Climb(°C/min)
Step 1	20	1500	370	4
Step 2	1500	1500	120	Holding
Step 3	1500	800	117	6
Step 4	800	Room temperature	Cool naturally	—