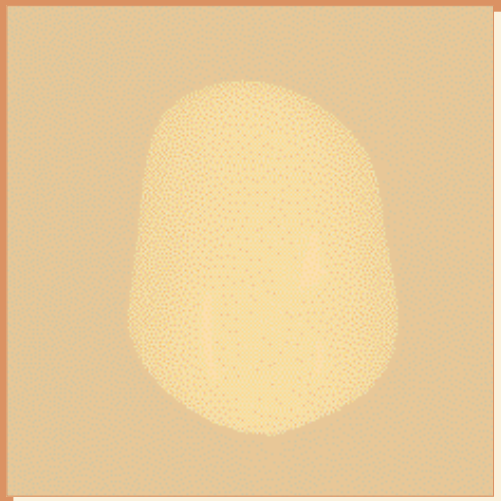
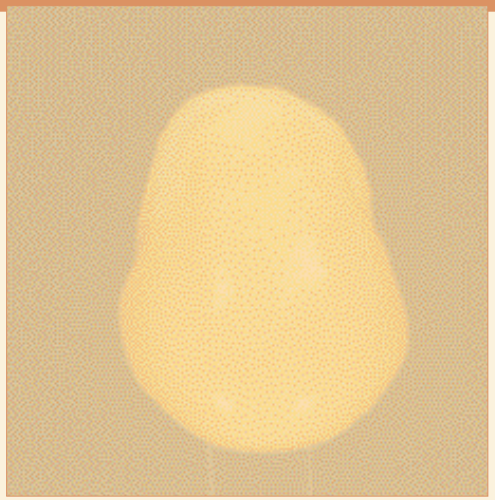
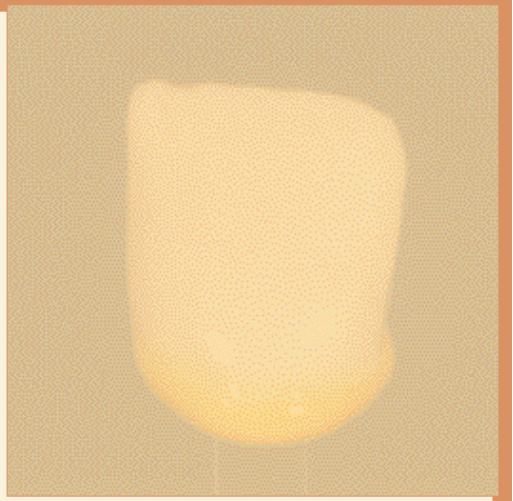
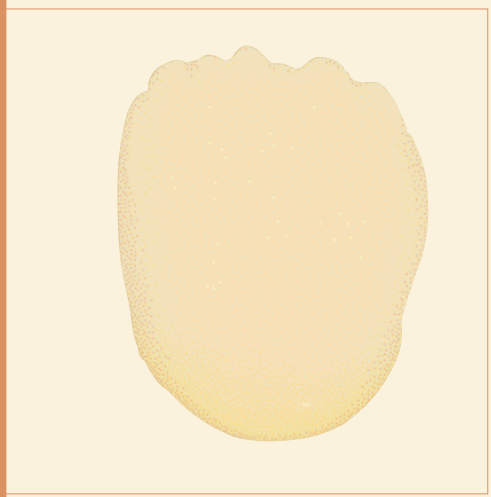
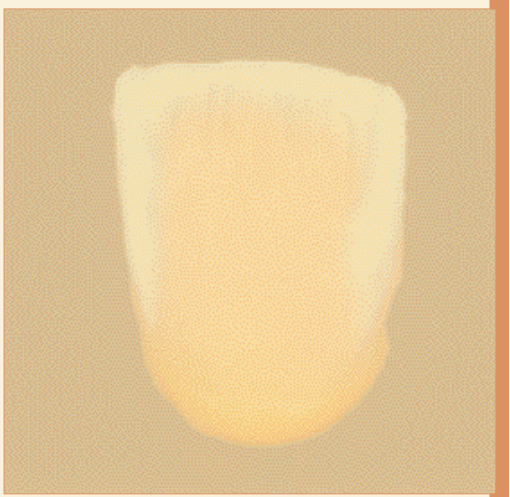
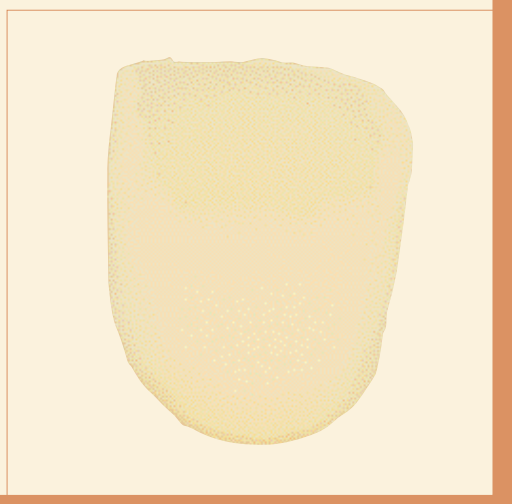






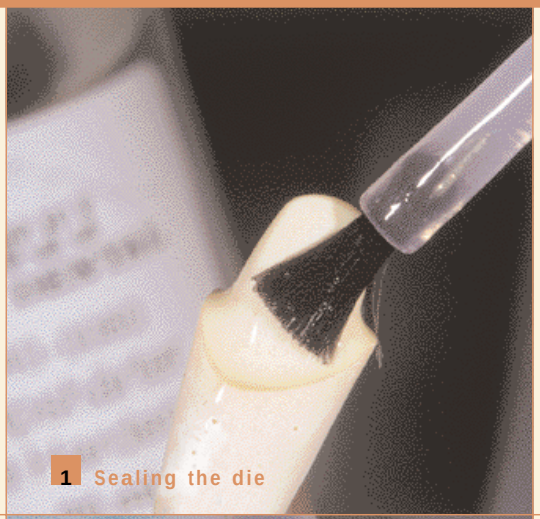
CARRARA
interaction

margin

User instructions

CARRARA interaction margin

Available in the following colours.
margin 1A2, 3A4, 1B2, 3B4, 1C2, 3C4 & Booster
margin correction Bright, Medium & Dark



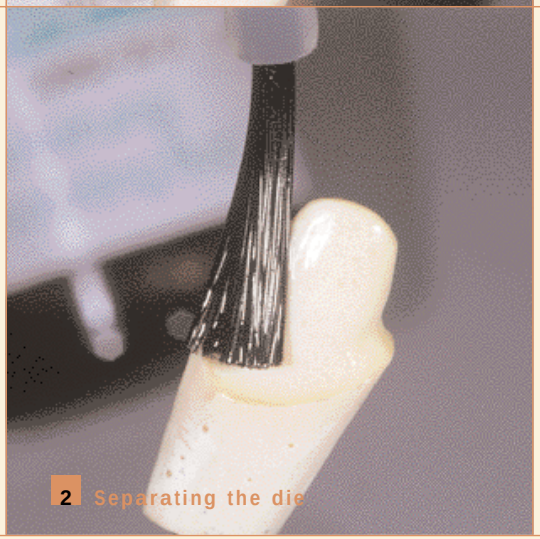
1 Sealing the die

1 Sealing the die:

- Seal the die by applying a die hardner agent and allow to dry well.

Shoulder preparation instructions

These instructions apply to Carrara Interaction ceramic shoulder preparations. For Standard Carrara Interaction preparations, please refer to the Carrara Interaction user instructions.



2 Separating the die

2 Separating the die:

- Apply a ceramic separation agent to the die and dry with compressed air.

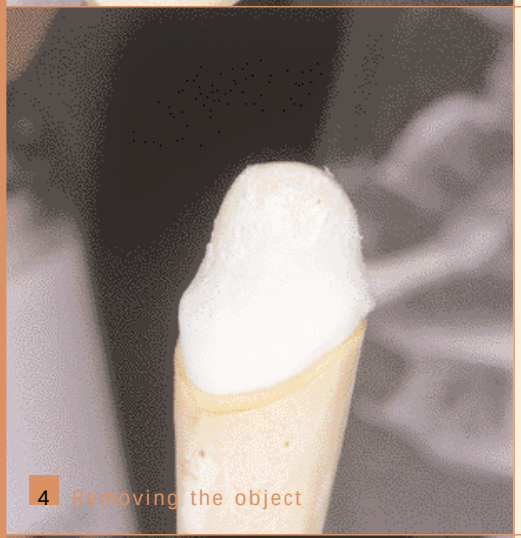
Colour	A1	A2	A3	A3,5	A4	B1	B2	B3	B4	C1	C2	C3	C4	D2	D3	D4
margin	1A2		3A4	50 % 3A4 & 50 % Booster	Booster	1B2		3B4	50 % 3B4 & 50 % Booster	1C2		3C4	50 % 3C4 & 50 % Booster	1A2	3A4	3C4
margin correction	Bright, Medium & Dark															

3a Applying *margin*

3 Applying *margin* for the first shoulder:

- Use margin liquid to mix the margin in question (see the colour schedule on the previous page) into a cream-like consistency.
- Apply the margin material in the usual manner. Before proceeding, condense the material and dry it with a hairdryer, if required.

3b Dry with hairdryer



4 Removing the object

4 Removing the object:

- Remove the object from the die.
- Fire the ceramic in accordance with the firing chart.

4 Firing chart for the first shoulder preparation firing:

Drying	Starting temp	Vacuum-starting temp.	Rate of heat increase
8–10 Min.	450 °C	450 °C	55–80 °C / Min.
Final temp.	**Retention time**		**Surface appearance**
860°C	3 Min.#		Matte finish

2 min. with vacuum and 1 min. without vacuum

5 Shoulder after firing

5 Applying *margin* for the second shoulder preparation firing:

- Use margin liquid to mix the margin into a cream-like consistency.
- Apply the margin material in the usual manner. Before proceeding, condense the material and dry it with a hairdryer, if required.
- Remove the object from the die.
- Fire the ceramic in accordance with the firing chart.

5 Firing chart for the second shoulder preparation firing:

Drying	Starting temp	Vacuum-starting temp.	Rate of heat increase
8–10 Min.	450 °C	450 °C	55–80 °C / Min.
Final temp.	**Retention time**		**Surface appearance**
860°C	2 Min.#		Matte finis

1 min. with vacuum and 1 min. without vacuum

6 Applying margin correction

6 Processing:

Correcting the ceramic shoulder preparation using margin correction:

- Use margin liquid to mix margin correction into a cream-like consistency.
- Apply margin correction to the location to be corrected and condense it. Before proceeding, dry with a hairdryer.
- Remove the object from the die.
- Fire the ceramic in accordance with the firing chart.
- After the firing process, the correction layer should be polished mechanically, using silicone polishing instruments and diamond paste.

Pictures: ZTM Jan Schünemann (Bielefeld, Duitsland)

6 Firing chart for margin correction (Bright, Medium, Dark)

Drying	Starting temp	Vacuum-starting temp.	Rate of heat increase
6 Min.	450 °C	450 °C	55–80 °C / Min.
Final temp.	**Retention time**		**Surface appearance**
795°C	2 Min. without vacuum		Silky gloss

After the firing process, the correction layer should be polished mechanically.

Carrara Interaction: One ceramic for all Carrara System applications.

Ceramic

Carrara Interaction

Universal alloys

Carrara PdF — High gold content

Cera F — Reduced gold content

Cera R plus — Reduced gold content

Cera E — Palladium-silver

Press ceramic

Carrara Press — Full ceramic

One ceramic for both alloys and press ceramics: Carrara Interaction

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Elephant Dental B.V.
Verlengde Lageweg 10
1628 PM Hoorn, The Netherlans
Tel. +31 229 25 90 00
Fax +31 229 25 90 99
E-mail export@elephant.nl
Internet www.elephant-dental.com

CE 0344