



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

Shoulder preparation instructions.

These instructions apply to Sakura Interaction ceramic shoulder preparations. For regular Sakura Interaction workflow, we refer to the Sakura Interaction user instructions.

Indication: As Sakura Interaction *margin* was developed for firing ceramic margins in combination with zircon oxide sub-structures, a shoulder or chamfer preparation is required.

Contraindication: All other types of preparation. Sakura Interaction *margin* may only be used on zircon oxide sub-structures with a thermal expansion coefficient between 10.0 and 10.6 µm/m.K (25-500°C).

For dental use only, Rx only,
Type 1 dental ceramic.



1 Sealing the die

1 Sealing the die:

- Apply a die hardener agent onto the die and allow to dry well.



2 Separating the die

2 Separating the die:

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



3a Applying margin

3 Applying margin for the first shoulder preparation firing:

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



3b Dry with a 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	
890°C	1 min. with vacuum	Matte finish	

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



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 well and dry, if required, the material with a hairdryer.
- 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	
890°C	1 min. with vacuum	Matte finish	

Important:

The firing temperatures indicated are target values. Temperatures may vary from one ceramic furnace to another and must be adapted accordingly.



6 Applying margin correction

6 Processing:

Correcting the ceramic shoulder preparation using margin correction:

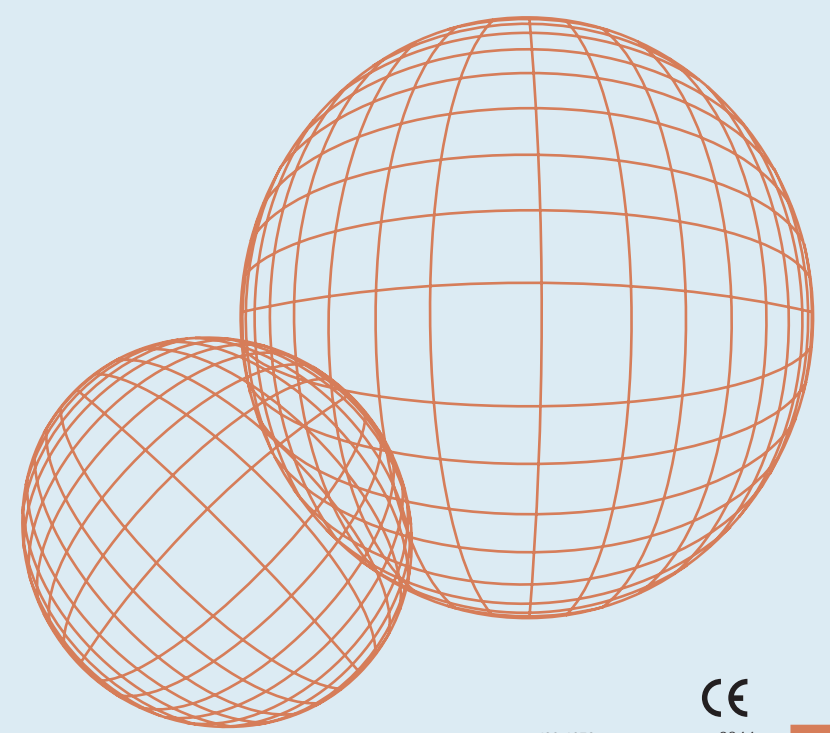
- Use *margin liquid* to mix *margin correction* into a cream-like consistency.
- Apply *margin correction* to the location to be corrected and condense well. Before proceeding, dry with a hairdryer.
- Remove the object from the die.
- Fire the ceramic in accordance with the firing chart.
- After the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

Pictures: ZTM Jan Schünemann (Bielefeld, Germany)

**6 Firing chart for margin corrections
Bright, Medium, Dark:**

Drying	Starting temp.	Vacuum starting temp.	Rate of heat increase
8 min.	450°C	450°C	55–80°C/min.
Final temp.	Retention time	Surface appearance	
780°C	1 min. with vacuum	Silky gloss	

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



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