



Orea Plus™ Cosmetic, Multi-Layered Zirconia Sintering Programs

Speed Sintering Program

Stage 1:	12°C Rise	0°	0 Min. Hold Time
Stage 2:	50°C Rise	1480°C High Temp.	70 min. Hold Time
Stage 3:	70°C Decline	1100°C Temp.	0 Min. Hold Time
Stage 4:	70°C Decline	500°C Temp.	0 Min. Hold Time

Speed Sintering Program (Reverse Order Display format: inFire, etc.)

*Note: this is the same program as the one above; it is only provided to make it easier to program ovens with reverse-order displays

Stage 4:	70°C Decline	500°C Temp.	0 Min. Hold Time
Stage 3:	70°C Decline	1100°C Temp.	0 Min. Hold Time
Stage 2:	50°C Rise	1480°C High Temp.	70 min. Hold Time
Stage 1:	12°C Rise	0°	0 Min. Hold Time

Standard Sintering Program

Stage 1:	12°C Rise	0°	0 Min. Hold Time
Stage 2:	10°C Rise	1000°C Temp.	15 min. Hold Time
Stage 3:	4°C Rise	1480°C High Temp.	120 min. Hold Time
Stage 4:	50°C Decline	350°C Temp.	No Hold

Standard Sintering Program (Reverse Order Display format: inFire, etc.)

*Note: this is the same program as the one above; it is only provided to make it easier to program ovens with reverse-order displays

Stage 4:	50°C Decline	350°C Temp.	No Hold
Stage 3:	4°C Rise	1480°C High Temp.	120 min. Hold Time
Stage 2:	10°C Rise	1000°C Temp.	15 min. Hold Time
Stage 1:	12°C Rise	0°	0 Min. Hold Time