



Orea Plus™ Cosmetic, Multi-Layered Zirconia Sintering Programs

| Sintering Program | | | |
|--------------------------|---------------------|--------------------------|---------------------------|
| Stage 1: | 12°C Rise | 0° | 0 Min. Hold Time |
| Stage 2: | 25°C Rise | 1460°C High Temp. | 100 min. Hold Time |
| Stage 3: | 50°C Decline | 1100°C Temp. | 0 Min. Hold Time |
| Stage 4: | 50°C Decline | 400°C Temp. | 0 Min. Hold Time |

If you need to adjust the sintering program according to your sintering furnace:

First Option: Adjust Stage 2 rate up or down

Second Option: Increase hold temperature