

ceraMotion®
LiSi



Processing tips.

Dear Customer,

by choosing Dentaaurum products, you have opted for carefully coordinated, quality products for the production of aesthetic ceramics.

To produce good results with ceramics, it is essential to closely follow the instructions for use for lithium disilicate.

In this brochure you will find many practical tips on how to avoid mistakes when processing our products as well as information on possible causes for errors.

Should you nonetheless encounter any problems when processing our products, please do not hesitate to contact us for advice.

In case of questions or ideas, please contact your local representative.

You can find information and instructions for the use of the Dentaaurum ceramic systems and press investment systems at **www.dentaaurum.com**.

Note

- The basis for fabricating good ceramics is the exact firing temperature of your pressing furnace. We therefore recommend you regularly check the temperature controls on your furnace.
- For combination furnaces (pressing and firing), the chambers should be cleaned from time to time to avoid contamination of the ceramic.
- Keep furnaces closed. To avoid moisture entering the chamber, always close the furnace after use and change to night mode where appropriate.

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No.	Problem	Cause	Remedy
1	Objects not pressed	<ul style="list-style-type: none"> ■ Preheating temperature too low ■ Pressing temperature too low or pressing furnace not preheated ■ Objects have been waxed up at different heights in investment ring ■ Too many objects for pressing – too little press ceramic ■ Press ceramic must flow from thick to thin ■ Investment ring temperature loss ■ Wax-up too thin 	<ul style="list-style-type: none"> ■ Increase preheating temperature ■ Increase pressing temperature if necessary, calibrate pressing furnace. Always preheat pressing furnaces ■ Wax up objects to same level ■ Weigh objects for pressing and use corresponding amount of ceramic ■ Always attach sprues at thickest point ■ Investment ring should be moved from preheating furnace to pressing furnace within 30 seconds ■ Observe min. wall thickness of 0.4 mm
2	Flashes on objects	<ul style="list-style-type: none"> ■ Press investment material incorrectly processed ■ Unsuitable investment material used for press technique ■ Too little space between the objects or between the objects and the outer wall of the investment ring ■ Temperature in preheating furnace too high ■ Investment ring placed too closely to the heating of the preheating furnace 	<ul style="list-style-type: none"> ■ Observe processing instructions for press investment material ■ Only use suitable press investment materials ■ Keep distance between the objects (5 mm) and to the outer wall (10 mm) ■ Check temperature and correct if necessary ■ Keep a distance of at least 2 cm to the insulation wall

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No.	Problem	Cause	Remedy
3	Rough surface	<ul style="list-style-type: none"> ■ Pressing temperature too high ■ Pressure too high ■ Pressing time too long ■ Press investment material insufficiently or inadequately mixed 	<ul style="list-style-type: none"> ■ Optimize settings on pressing furnace (begin by reducing pressing temperature) ■ Use ceraMotion® LiSi Press in accordance with the instructions
4	Defect restoration after devesting	<ul style="list-style-type: none"> ■ Devesting with pliers 	<ul style="list-style-type: none"> ■ Only blast with aluminum oxide or glass beads in accordance with instructions ■ Do not use pliers to devest
5	Investment ring breaks during pressing process	<ul style="list-style-type: none"> ■ Press plunger incorrectly placed ■ Not ensured that 2 press ingots are placed exactly one upon the other ■ Top of investment ring is not parallel to press base 	<ul style="list-style-type: none"> ■ Press plunger must stand vertically in pressing sprue ■ Place press ingots exactly one on top of the other ■ Observe that silicone ring and ring leveller sit correctly when investing ■ Investment material not correctly removed from top side of investment ring
6	Ceramic appears to be too transparent	<ul style="list-style-type: none"> ■ Pressing temperature too high 	<ul style="list-style-type: none"> ■ Calibrate furnace ■ Reduce pressing temperature
7	Ceramic appears to be too opaque or milky	<ul style="list-style-type: none"> ■ Pressing temperature too low 	<ul style="list-style-type: none"> ■ Calibrate furnace ■ Increase pressing temperature

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No.	Problem	Cause	Remedy
8	<p>Small, black/blue spots in ceramic</p> <p>White spots in ceramic</p> <p>Cloudy press result</p>	<ul style="list-style-type: none"> ■ Contaminated wax wire or carving wax ■ Sharp edges in wax-up can favor tearing of fragments of investment material ■ Unsuitable carving wax 	<ul style="list-style-type: none"> ■ Ensure wax is clean ■ Avoid sharp edges and undercuts on wax-ups ■ Use organic wax, suitable for pressing
9	<p>Cracked, broken object after veneering</p>	<ul style="list-style-type: none"> ■ Framework too thin or ceramic layer too thick ■ Object was removed from furnace chamber too soon ■ Object stood in cold draft after firing ■ Object touched with metal pliers, blown on or quenched. ■ Unsuitable pins used (thick metal pins or similar) 	<ul style="list-style-type: none"> ■ Wall thickness of framework should never be less than the wall thickness of the fired ceramic. ■ Remove object from the furnace chamber after firing cycle (listen for signal from furnace) ■ Protect objects from drafts ■ Always leave object to cool at room temperature. Do not touch with metal pliers nor blow or quench the object ■ Use pins suitable for all-ceramic restorations (ceramic pins, platinum pins or similar)
10	<p>Cracks or blisters after veneering or glazing</p>	<ul style="list-style-type: none"> ■ Reaction layer possibly not fully removed from framework surface 	<ul style="list-style-type: none"> ■ Remove reaction layer with aluminum oxide abrasive, medium grain, and 1–2 bar pressure

Dentaurum Group

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and in more than 130 countries worldwide.



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QUALITY
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DENTAURUM

Turnstr. 31 | 75228 Ispringen | Germany | Phone +49 72 31/803-0 | Fax +49 72 31/803-295
www.dentaurum.com | info@dentaurum.com