

Noritake

Super Porcelain EX-3

Paste Opaque

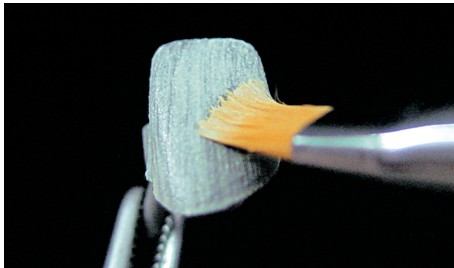


Scoop out the desired amount and the desired shade of Paste Opaque or base paste (POBA) and put it on the palette. The surface of Paste Opaque is covered with extra liquid in order to avoid drying. Please incline the jar and clip up from the no-liquid part.

Don't mix liquid with paste opaque inside the jar.
Don't dispose liquid from the jar.

attention

When using semi-precious alloys containing high palladium with copper or Ni-Cr alloys without Beryllium or Co-Cr alloys, use Base Paste (POBA) for the first application to prevent greening of the porcelain. After POBA is applied, 100% of the metal coping's color should be hidden.

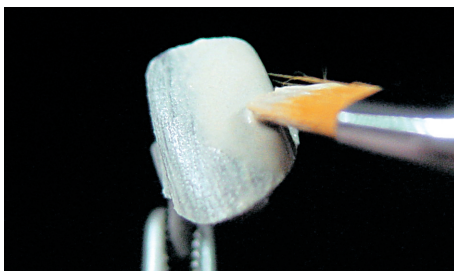


Wash Application (Shade Paste Opaque or POBA)

Be sure the surface of the metal framework is completely free of moisture. Using the tip of the brush, rub the surface with a small amount of Paste Opaque to form a very thin layer.

attention

Only dry brush should be used. DO NOT mix with even a small amount of water.



1st Application (Shade Paste Opaque or POBA)

After a thin layer is rubbed, keep coating the metal framework with Paste Opaque.

Shade Paste Opaque : 70% of the metal color should be hidden.
POBA : 100% of the metal color should be hidden with thicker application.

Do not need too much condensation for paste opaque.

attention

Dilute the desired amount of Paste Opaque with Paste Opaque Liquid. Be careful that over-dilute will lead to fractures after baking.



Clean Up the Internal Surface

Bake the metal framework after making sure that no residue remains. If Paste Opaque residue is found, use a dry brush to remove it from inside of the metal framework. After the first baking, the surface of the opaque should be a little glossy.

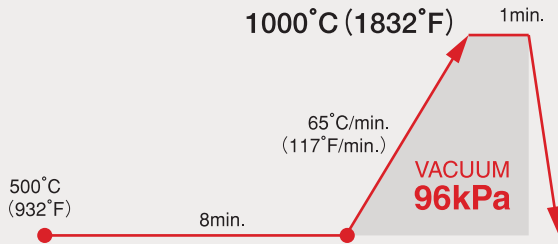
attention

Set the idle temperature of the furnace to under 500°C (932°F) in order to avoid the rapid heating.

POBA Application

for Co-Cr alloys
Ni-Cr without Beryllium alloys
Semi-precious alloys containing high palladium with copper

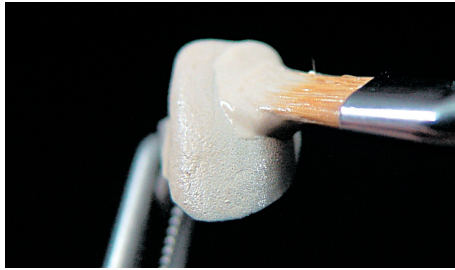
Baking Schedule



Ideal Surface Situation



If you can't see glossy surface after POBA baking, please extend holding time by one more minute at 1000°C (1832°F) without vacuum.



2nd Application (Shade Paste Opaque)

Apply the second layer of Paste Opaque until the color of the metal framework is completely covered. When the first application was formed with POBA, the second application should be done with the desired shade of Paste Opaque.

Be sure that no Paste Opaque residue remains inside of the metal framework. After the second baking, the surface should be a little glossy as seen after the first baking.



Paste Opaque Modifier Application

The Paste Opaque EX-3 Modifier can be mixed with Paste Opaque EX-3 to customize the shade or can be applied alone for minor modifications. When Base Paste (POBA) is applied as the first layer, only use Modifier during the second application after the base paste is baked. When Modifier is used as a stain, dilute it with Paste Opaque Liquid (PO Modifier Liquid) to make desired viscosity and apply during the second application.

attention

Apply earth brown or reddish brown separately. If earth brown or reddish brown is mixed with other shades, the desired color can not be obtained after baking. The desired color can be changed after baking due to the storage condition. Internal Stain can be used on Paste Opaque also.

Baking Schedule	Dry-out time	Low Temperature		Start Vacuum		Heat Rate		Vacuum Level	Release Vacuum		Hold Time	High Temperature		Cool Time
	min.	°C	°F	°C	°F	°C/min.	°F/min.	kPa*	°C	°F	min.	°C	°F	min.
POBA	8	500	932	500	932	65	117	96	1000	1832	1 (with vacuum)	1000	1832	0
Paste Opaque 1st and 2nd	8	500	932	500	932	65	117	96	980	1796	1 (without vacuum)	980	1796	0

Note The above program is only a guideline. Baking temperature may be varied with the peculiarities of different furnace.

*96kPa = 72cmHg (29 inchesHg)

SYMBOLS USED IN A LABEL

	MANUFACTURER		BATCH CODE
	USE BY		CATALOGUE NUMBER
	CONSULT INSTRUCTIONS FOR USE		AUTHORISED REPRESENTATIVE IN THE EUROPEAN COMMUNITY

EU Authorized Representative
Name: Kuraray Europe GmbH
Address: Philipp-Reis-Str.4 65795 Hattersheim am Main, Germany



Warning If the patient is hypersensitive to Dental Porcelain or any of the other components, this medical product should not be used. Or it should be only used under the strict supervision of the patient's doctor/dentist.



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