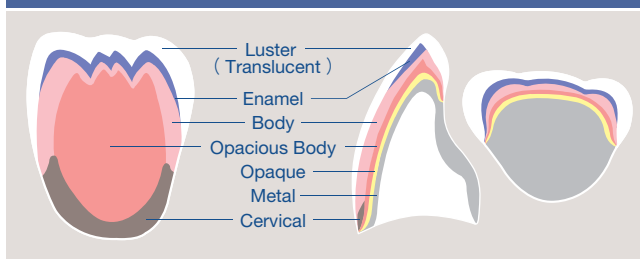


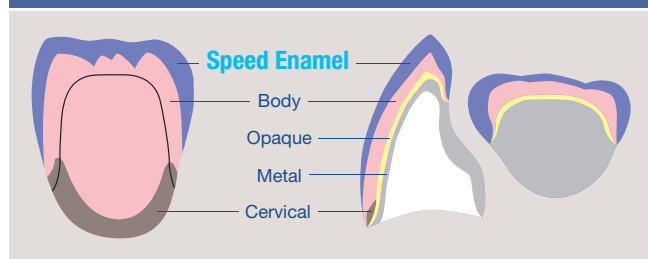
EX-3 LINE-UPS

Paste Opaque	6g	POA1/POnA1 POC1/POnC1 PONP1.5	POA2/POnA2 POC2/POnC2 PONP2.5	POA3/POnA3 POC3/POnC3 PONW0	POA3.5/POnA3.5 POC4/POnC4 PONW0.5	POA4/POnA4 POD2/POnD2 POEW0	POB1/POnB1 POD3/POnD3 POEW	POB2/POnB2 POD4/POnD4 POBA	POB3/POnB3 — —	POB4/POnB4 — —
Paste Opaque Modifier	3g	PO White	PO Gray	PO Orange	PO Earth Brown	PO Reddish Brown	PO Pink	PO Blue	PO Yellow	—
Universal Paste Opaque	6g	UPnA1 UPnC1 UPNP1.5	UPnA2 UPnC2 UPNP2.5	UPnA3 UPnC3 UPNW0	UPnA3.5 UPnC4 UPNW0.5	UPnA4 UPnD2 UPEW0	UPnB1 UPnD3 UPEW	UPnB2 UPnD4 —	UPnB3 — —	UPnB4 — —
Universal Paste Opaque Modifier	3g	UP White	UP Gray	UP Orange	UP Earth Brown	UP Reddish Brown	UP Pink	UP Blue	UP Yellow	—
Powder Opaque	10,50,200g	A1O/nA1O C1O/nC1O NP1.5O	A2O/nA2O C2O/nC2O NP2.5O	A3O/nA3O C3O/nC3O NW0O	A3.5O/nA3.5O C4O/nC4O NW0.5O	A4O/nA4O D2O/nD2O EW0O	B1O/nB1O D3O/nD3O EW0	B2O/nB2O D4O/nD4O —	B3O/nB3O — —	B4O/nB4O — —
Powder Opaque Modifier	10,50g	OM Gray	OM Orange	OM Pink	—	—	—	—	—	—
Body	10,50,200g	A1B/nA1B C1B/nC1B NP1.5B	A2B/nA2B C2B/nC2B NP2.5B	A3B/nA3B C3B/nC3B NW0B	A3.5B/nA3.5B C4B/nC4B NW0.5B	A4B/nA4B D2B/nD2B EW00B	B1B/nB1B D3B/nD3B EW0B	B2B/nB2B D4B/nD4B EWB	B3B/nB3B — EWYB	B4B/nB4B — —
Enamel	10,50,200g	E1	E2	E3	Silky E1	Silky E2	—	—	—	—
Speed Enamel	10,50,200g	S1	S2	S3	S4	—	—	—	—	—
Margin	10,50g	MA1 MC2	MA2 MC4	MA3 MD3	MA3.5 MD4	MA4 MNP1.5	MB1 MNP2.5	MB2 MNW0	MB3 MNW0.5	MB4 —
Margin Modifier	10,50g	M Clear	M Peach	M Orange	—	—	—	—	—	—
Margin Retouching	10,50g	MRP	—	—	—	—	—	—	—	—
Margin Dilution	10,50g	MDL	—	—	—	—	—	—	—	—
Opacious Body	10,50,200g	OBA1 OBC1 OB Enamel	OBA2 OBC2 OB White	OBA3 OBC3 OB Orange	OBA3.5 OBC4 OB Pale Pink	OBA4 OBD2	OBB1 OBD3	OBB2 OBD4	OBB3 OBNP1.5	OBB4 OBNP2.5
Cervical	10,50,200g	CV-1	CV-2	CV-3	CV-4	—	—	—	—	—
Mamelon	10,50g	Mamelon 1	Mamelon 2	—	—	—	—	—	—	—
Translucent	10,50,200g	Tx	T0	T1	T2	—	—	—	—	—
Luster	10,50,200g	LT0 LT Natural	LT1 LT Super Gray	T Blue LT Yellow	Aqua Blue 1 ELT1	Aqua Blue 2 ELT2	Creamy Enamel ELT3	Sun Bright	Incisal Aureola	Creamy White
Clear Cervical	10,50,200g	CCV-1	CCV-2	CCV-3	CCV-4	—	—	—	—	—
Modifier	10,50g	White Dark Pink	Gray Coral Pink	Blue	Green	Yellow	Light Orange	Orange	Brown	Pink
Tissue	10,50g	Tissue 1	Tissue 2	Tissue 3	Tissue 4	Tissue 5	Tissue 6	Tissue 7	—	—
Add-on	10,50g	AD-T	AD-B	—	—	—	—	—	—	—
External Stain	3g	Gray Cervical 2 B+	Black Cervical 3 C+	Blue Earth Brown D+	Green 1 Reddish Brown —	Green 2 Pure White —	Yellow Pink —	Orange 1 Salmon Pink —	Orange 2 Red —	Cervical 1 A+ —
	10,30g	Glaze	—	—	—	—	—	—	—	—
Internal Stain	3g	Incisal Blue 1 White Gray	Incisal Blue 2 Red —	Mamelon Orange 1 Salmon Pink —	Mamelon Orange 2 A+ —	Reddish Brown B+ —	Earth Brown C+ —	Cervical 1 D+ —	Cervical 2 Bright —	Cervical 3 Fluoro —
Addmate	10g	Light Opaque	Dark Opaque	Light Body	Dark Body	Enamel	Translucent	Luster Translucent	—	—

3 BASIC LAYER BUILD-UP



2 LAYER BUILD-UP with SPEED ENAMEL



Noritake



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Noritake

Super Porcelain EX-3

Baking Schedule and Color Combination Table

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 *1	°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 1 st and 2 nd	8	500	932	500	932	65	117	96	980	1796	1 (without vacuum)	980	1796	0
Universal Paste Opaque 1 st and 2 nd (High Noble, Noble, Ni-Cr w/Be alloys)	8	400	752	400	752	65	117	96	980	1796	1 (without vacuum)	980	1796	0
Universal Paste Opaque 1 st and 2 nd (Ni-Cr w/out Be, Co-Cr alloys)	8	400	752	400	752	65	117	96	1000	1832	1 (without vacuum)	1000	1832	0
Powder Opaque 1 st	3	650	1202	650	1202	55	99	96	950	1742	0 *4	960	1760	0
Powder Opaque 2 nd	5	650	1202	650	1202	55	99	96	950	1742	0 *4	960	1760	0
Margin Porcelain 1 st and 2 nd	5	650	1202	650	1202	55	99	96	935	1715	0	945	1733	0
Body / Enamel / S.Enamel / Translucent (1-3 units)	7	600	1112	600	1112	45	81	96	920	1688	0	930	1706	0
Body / Enamel / S.Enamel / Translucent (4-6 units)	10	600	1112	600	1112	45	81	96	925	1696	0	935	1715	0
Body / Enamel / S.Enamel / Translucent (Over 7 units)	15	600	1112	600	1112	45	81	96	930	1706	0	940	1724	0
Body (Minor Adjustments)	7	600	1112	600	1112	45	81	96	910	1670	0	920	1688	0
Internal Stain 1 st and 2 nd	3	650	1202	—	—	55	99	0	—	—	0	830 *2	1526 *2	0
Self Glaze only	5	650	1202	—	—	50	90	0	—	—	0	930 *3	1706 *3	0
Self Glaze with after-polishing	5	650	1202	—	—	50	90	0	—	—	0	890	1634	0
External Stain / Glaze powder	5	650	1202	—	—	50	90	0	—	—	0	910	1670	0
MRP	5	650	1202	—	—	55	99	0	—	—	0	850	1562	0
Add-on	5	650	1202	—	—	55	99	0	—	—	0	880	1616	0
Addmate (Minor adjustments)	5	450	842	450	842	45	81	96	690	1274	0	700	1292	0
Degassing for NORI-VEST (Using a burnout furnace only)	0	300	572	—	—	30	54	0	—	—	20	1080	1976	0
Wash bake for Refractory	10	600	1112	600	1112	45	81	96	940	1724	0	950	1742	4
Body for Refractory	10	600	1112	600	1112	45	81	96	940	1724	0	950	1742	4
Glaze for Refractory	10	600	1112	—	—	45	81	0	—	—	0	950	1742	4

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

*1 96kPa = 72cmHg (29 inchesHg). *2 This case is for 1-3 units. Set the high temperature the same as Body baking. *3 This case is for 1-3 units. Reduce 40°C (72°F) from the high temperature of Body baking.

*4 1min. holding-time might be necessary depending on the peculiarities of different furnace.

Color Combination Table

	A1	A2	A3	A3.5	A4	B1	B2	B3	B4	C1	C2	C3	C4
Paste Opaque	POA1 P0nA1	POA2 P0nA2	POA3 P0nA3	POA3.5 P0nA3.5	POA4 P0nA4	POB1 P0nB1	POB2 P0nB2	POB3 P0nB3	POB4 P0nB4	POC1 P0nC1	POC2 P0nC2	POC3 P0nC3	POC4 P0nC4
Universal Paste Opaque	UPnA1	UPnA2	UPnA3	UPnA3.5	UPnA4	UPnB1	UPnB2	UPnB3	UPnB4	UPnC1	UPnC2	UPnC3	UPnC4
Powder Opaque	A10 nA10	A20 nA20	A30 nA30	A3.50 nA3.50	A40 nA40	B10 nB10	B20 nB20	B30 nB30	B40 nB40	C10 nC10	C20 nC20	C30 nC30	C40 nC40
Margin	MA1	MA2	MA3	MA3.5	MA4	MB1	MB2	MB3	MB4	MC2+MDL (1+1)	MC2	MC4+MDL (1+1)	MC4
Opacious Body	OBA1	OBA2	OBA3	OBA3.5	OBA4	OBB1	OBB2	OBB3	OBB4	OBC1	OBC2	OBC3	OBC4
Body	A1 B nA1 B	A2 B nA2 B	A3 B nA3 B	A3.5 B nA3.5 B	A4 B nA4 B	B1 B nB1 B	B2 B nB2 B	B3 B nB3 B	B4 B nB4 B	C1 B nC1 B	C2 B nC2 B	C3 B nC3 B	C4 B nC4 B
Cervical	—	A2B+CV-1 (2+1)	A3B+CV-1 (1+1)	A3.5B+CV-1 (1+1)	CV-1	—	B2B+CV-2 (2+1)	B3B+CV-2 (1+1)	CV-2	—	C2B+CV-3 (2+1)	C3B+CV-3 (1+1)	CV-3
Enamel	E2	E2	E3	E3	E3	E1	E2	E3	E3	E2	E3	E3	E3
Speed Enamel	S2	S3	S3	S3	S4	S1	S3	S3	S4	S3	S3	S3	S4
Luster (Translucent)	LT1 (T1)					LT1 (T1)				LT1 (T1)			

	D2	D3	D4	NP1.5	NP2.5	NW0	NW0.5	EW00	EW0	EW	EWY
Paste Opaque	POD2 P0nD2	POD3 P0nD3	POD4 P0nD4	PONP1.5	PONP2.5	PONW0	PONW0.5	POEW0	POEW0	POEW	POEW
Universal Paste Opaque	UPnD2	UPnD3	UPnD4	UPNP1.5	UPNP2.5	UPNW0	UPNW0.5	UPEW0	UPEW0	UPEW	UPEW
Powder Opaque	D20 nD20	D30 nD30	D40 nD40	NP1.50	NP2.50	NW00	NW0.50	EW00	EW00	EWO	EWO
Margin	MD3+MDL (1+1)	MD3	MD4	MNP1.5	MNP2.5	MNW0	MNW0.5	MDL	MDL	MNW0+MDL (1+1)	MNW0+MDL (2+1)
Opacious Body	OBD2	OBD3	OBD4	OBNP1.5	OBNP2.5	—	—	—	—	—	—
Body	D2 B nD2 B	D3 B nD3 B	D4 B nD4 B	NP1.5 B	NP2.5 B	NW0 B	NW0.5 B	EW00 B	EW0 B	EW B	EWY B
Cervical	D2B+CV-4 (2+1)	D3B+CV-4 (1+1)	CV-4	—	NP2.5B+CV-1 (2+1)	—	—	—	—	—	—
Enamel	E2	E3	E3	E2	E2	Silky E2	Silky E2	Silky E1	Silky E1	Silky E2	Silky E2
Speed Enamel	S3	S3	S4	S2	S3	S1	S1	Silky E1	Silky E1	Silky E2	Silky E2
Luster (Translucent)	LT1 (T1)			LT1 (T1)		LT1 (T1)		ELT2		ELT1	