

Nori-Vest Zirconia is a refractory die material matched to Noritake's Cerabien ZR porcelain which is used on all zirconia substructures.

By using **Nori-Vest Zirconia** with Noritake's Cerabien ZR porcelain, combination cases (e.g., Cerabien ZR all-ceramic crowns and refractory restorations fabricated with Cerabien ZR) result in a perfect match.

[FEATURES]

1. High strength allows for repeated firings.
2. **Nori-Vest Zirconia** is easily removed after the porcelain is baked, reducing the risk of fracturing the refractory restorations.
3. Having a low viscosity allows the refractory material to flow easily, creating smooth, bubble-free models with excellent fits.

[SPECIFICATIONS]

Mixing Ratio	7.2ml / 30g (1pk.=30grams)
Working Time	3.5min. at 20°C
Compressive Strength	22MPa (after 1 hour) 35MPa (after degassing)

[INSTRUCTIONS]

1. Use 7.2ml of liquid for each 30 gram package of powder. Mix in a vacuum mixer for 40 seconds. Measure the liquid accurately, since the mixing ratio affects the fit.
2. Apply a wetting agent (e.g., Noritake Wax Cleaner) to the impression and dry. Pour the material carefully using a vibrator to avoid bubbles.
3. Allow to set for one hour, remove the refractory model from the impression. Do not leave in the impression for more than 2 hours. Setting time affects both the fit and the surface texture.
4. **Nori-Vest Zirconia** is a phosphate-bonded model material. The gas created by heating will adversely affect a porcelain furnace. Use of a burnout furnace is recommended.

a)Using a Burnout Furnace only

Dry-out Time	Low Temp.	High Temp.	Heat Rate	Hold Time	Vacuum Level
0	20°C	1,080°C	30-40 °C/min.	10-20 min.	0 kPa
0	68°F	1,976°F	54-72 °F/min.	10-20 min.	0 kPa

b)Using both a burnout and a porcelain furnace. First use the burnout furnace, then use the porcelain furnace.

Burnout Furnace Schedule

Dry-out Time	Low Temp.	High Temp.	Heat Rate	Hold Time	Vacuum Level
0	20°C	700°C	30-40 °C/min.	10-20 min.	0 kPa
0	68°F	1292°F	54-72 °F/min.	10-20 min.	0 kPa

Porcelain Furnace Schedule

Dry-out Time	Low Temp.	High Temp.	Heat Rate	Hold Time	Vacuum Level
0	600°C	1,080°C	45-50 °C/min.	10-20 min.	0 kPa
0	1112°F	1,976°F	81-90 °F/min.	10-20 min.	0 kPa

[KIT COMPONENTS]

○1-1 Set

Powder : 30g × 33 packs (990g)

Liquid : 240ml

Syringe : 1pc.

○INDIVIDUAL ITEMS

Powder : 30g × 33 packs (990g)

Liquid : 240ml

[IMPORTANT NOTES]

1. **Nori-Vest Zirconia** is a refractory die material for the porcelain on zirconia substructures. Do **not** use **Nori-Vest Zirconia** for porcelain fused to metal, porcelain for alumina or titanium frameworks.
2. Maintain proper degassing temperatures to avoid cracking and improper fit.
3. Silicon impression Material: The type of impression material will affect the fit. We recommend the [putty/injection] combination type impression procedure.
4. Use only special liquid as provided.
5. Measure the liquid precisely. Mix with a vacuum mixer.
6. Keep the liquid away from freezing temperatures and direct sunlight.
7. Do not inhale dust comprised of this material.
8. Avoid contact with eyes. In the event of eye contact, flush eyes with copious amounts of water.
9. Use protective eyewear.
10. **Nori-Vest Zirconia** investment contains silica. Over exposure to the dust may cause delayed lung injury.

Manufactured by :

Kuraray Noritake Dental Inc.