



# INSTRUCTIONS FOR OPAQUE USE

## TECHNICAL HINTS

- Make certain that the Opaque brush is only very slightly moist. After cleaning the brush dry it.  
Never dilute Opaque with water!
- The consistency of Opaque can only be adjusted slightly with Universal Fluid (UF).  
Avoid drying the material too quickly prior to and after placing it in the firing chamber (bubbles due to boiling)!  
Pre-drying time: 6 minutes.
- Preheating temperature is dependig on the furnace in use  
400 – 550 °C.
- Once it has dried out, Opaque cannot be adjusted.
- Extruded material must not be drawn up into the syringe again.
- Ensure that Opaque is applied in uniform thickness.
- Opaque is compatible with Clara powder opaque.





### METAL FRAMEWORK

The metal framework should be finished and oxidized according to the manufacturer's instructions.

### MIXING

Mix the paste opaque well with an agate spatula to a homogeneous consistency.

### APPLYING

Use the Opaque brush to apply the paste opaque to the metal framework, ensuring that the brushstrokes are even and that the metal is masked by approximately 75%.

### 1st OPAQUE FIRING

Pre-drying time: 6 minutes. The first firing is carried out at 980 in vacuum.

Non-precious alloys: 1.000 °C!

°C,



### 2<sup>nd</sup> OPAQUE APPLIED

The second coating of the opaque should mask the metal completely. If necessary, the opaque shade can be adjusted slightly with Opaque dentine.

### 2<sup>nd</sup> OPAQUE FIRING

The second opaque firing is carried out at 950°C, in vacuum. Once the final temperature has been attained, the firing chamber is vented once again.

Holding time: 1 minute

Pre-drying time: 6 minutes

After the second firing, the opaque should have an eggshell finish.

### OPAQUE ASSORTMENT

- 16 opaque, Vita® Classic shades
- 1 flat brush

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## FIRING INSTRUCTIONS

	Preheating Temperature	Drying Time	Raise of Temperature	V	Final Temperature	Holding Time	Appearance
WASH Opak Powder Opaque *	550 °C 550 °C	6 min. 6 min.	80 °C/min. 80 °C/min.	+ +	950 °C 980 °C	1 min. 1 min.	Lightly shining
Opaque Firing Powder Opaque	550 °C 600 °C	6 min. 2 min.	80 °C/min. 80 °C/min.	+ +	950 °C 950 °C	1 min. 1 min.	Eggshell shining
1 <sup>st</sup> and 2 <sup>nd</sup> Shoulder Firing	600 °C	2 min.	80 °C/min.	+	950 °C	1 min.	Lightly shining
1 <sup>st</sup> Dentine Firing	580 °C	6 min.	55 °C/min.	+	920 °C	1 min.	
2 <sup>nd</sup> Dentine Firing	580 °C	4 min.	55 °C/min.	+	910 °C	1 min.	
Glaze Firing	600 °C	2 min.	55 °C/min.	–	930 °C	-	Shining

\* When firing non-precious alloy: final temperature 1.000 °C.

The firing parameters given above are guidelines, which always need to be adjusted to the furnace used for firing and the situation of the furnace. The important thing is to obtain the right firing result.

Errors and printing errors excepted. Subject to change at any time.

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