

Processing information



LASERMELTING



MILLING



3D-PRINTING



SERVICE



LASERMELTING

Processing information Cobalt-chrome (CoCr)

In terms of production technology occlusally on your construction a first layer of material is **additionally** created, which is not homogeneous.

We offer 3 delivery options:



Supports grinded

The extra layer will be removed from us. In order not to jeopardize your occlusion in the case of fully anatomical design, occlusal surfaces are only very carefully grinded. We recommend these to be reworked in any case.



Supports not grinded

We leave this extra layer on your work. If the work is not veneered with plastic, it should be grinded clean with a tungsten carbide burr.

Please remember not to use the same burr for CoCr and titanium!



With Supports

In addition to the extra occlusal layer, the support structures also remain on your work. We leave the sandblasting to you in your laboratory. The supports can be easily removed with pliers or a rotating tool. The majority of the added value and the individual processing remains with you.

Ceramics: Ideal are high-melting ceramics that are matched to alloys with a CTE of $14,1 \cdot 10^{-6} \text{ K}^{-1}$. There may be differences in the firing process (long-term cooling, tempering, etc.).

The instructions of the respective ceramic manufacturer should be strictly observed.

Oxide firing: We recommend an oxide firing as control and cleaning, although this is not strictly necessary.

Sandblasting: With pure aluminium oxide, min. 125μ at 2 - 3 bar in disposable radiator.



LASERMELTING

Processing information Titanium

In terms of production technology occlusally on your construction a first layer of material is **additionally** created, which is not homogeneous.

We offer 2 delivery options:



Supports grinded

The extra layer will be removed from us. In order not to jeopardize your occlusion in the case of fully anatomical design, occlusal surfaces are only very carefully grinded. We recommend these to be reworked in any case.



Supports not grinded

We leave this extra layer on your work. If the work is not veneered with plastic, it should be grinded clean with a tungsten carbide burr.

Please remember not to use the same burr for CoCr and titanium!

Ceramics: Ideal are high-melting ceramics that are matched to alloys with a CTE of $10,16 \cdot 10^{-6} \text{ K}^{-1}$. There may be differences in the firing process (long-term cooling, tempering, etc.).

The instructions of the respective ceramic manufacturer should be strictly observed.

Oxide firing: We recommend an oxide firing as control and cleaning, although this is not strictly necessary.

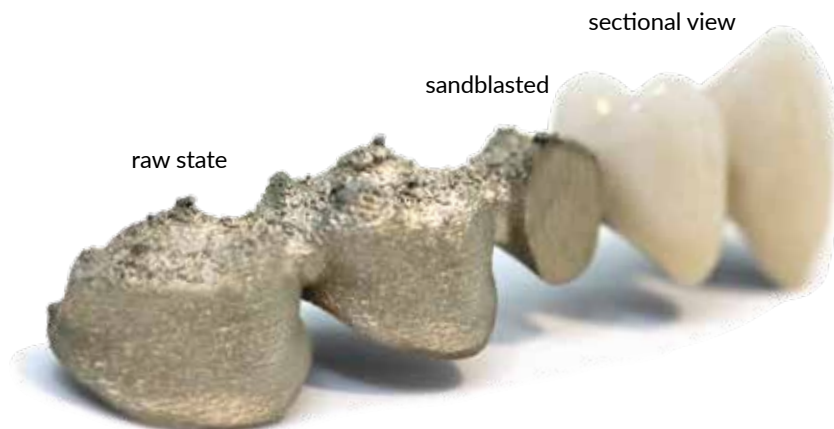
Sandblasting: With pure aluminium oxide, min. 125μ at 2 - 3 bar in disposable radiator.



LASERMELTING

Processing information Gold

In terms of production technology occlusally on your construction a first layer of material is **additionally** created, which is not homogeneous.



Supports not grinded

We leave this extra layer on the work. It should be grinded clean with a tungsten carbide burr.

Ceramics: Ideal are high-melting ceramics that are matched to alloys with a CTE of $14,2 \cdot 10^{-6} \text{ K}^{-1}$. There may be differences in the firing process (long-term cooling, tempering, etc.).

The instructions of the respective ceramic manufacturer should be strictly observed.

Oxide firing: In our CADgold 84 work, an oxide firing must be carried out at $880^\circ/5 \text{ min.}$ in order to achieve the required material properties for dental work. Each pillar of a bridge should be supported by a carrier pin on the firing tray. For large-span bridges, we recommend an individual firing tray. Before the oxide firing, the framework must be cleaned (e.g. with a steam jet).

Sandblasting: With pure aluminium oxide, min. 125μ at 2 - 3 bar in disposable radiator. Please make sure that this is done at an angle of approx. 45° to the object.

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from technician to technician

W W W . C A D D E N T . E U