

### 3. Preparation of the substructure

#### Preparation of frameworks made of titanium grades 4 + 5 for veneering with VITA LUMEX AC



**1** Ceramic-supporting design, bridge unit with cooling fins



**2** Sandblasted framework

#### Please note:

- Crown and bridge frameworks as a reduced tooth shape with anatomical and ceramic-supporting framework design
- Recommended thickness of the framework is at least 0.4 - 0.5 mm; avoid sharp edges and overlapping
- Bridge connectors should have adequate dimensions in the interdental area
- Attach cooling fin to fully veneered bridge units
- Use only cutters suitable for titanium (low speed, approx. 15,000 rpm and reduced pressure), grind in one direction only
- Sandblast at an angle of 45° using high-grade corundum (120 – 150 µm) at 2 bar and a distance of 3 - 5 cm
- Passivation for five minutes is required (leave framework in place, without machining)
- Cleaning the surface with a steam cleaner
- No oxide firing

#### Firing (opaque firing with OPAQUE):

Recommended firing for OPAQUE on titanium frameworks							
Pre-dry °C	→ min.	↗ °C/min.	approx. temp. °C	→ min.	↘ °C	→ min.	VAC
400	4.00	50	800	1.00	–	–	on

#### Please note:

- For shade classification of the OPAQUE materials, see VITA LUMEX AC Instructions for Use
- Carry out two opaque firings with OPAQUE:
  - First opaque firing should be applied thinly (like a wash firing)
  - Second opaque firing should cover the framework completely
- The use of a titanium bonder is not required, but possible.\*
- VITA VM OPAQUE FLUID (BVMOF50, BVMOF250) must be used for mixing OPAQUE.

\*) For products that are not manufactured or approved by VITA Zahnfabrik H.Rauter GmbH & Co. KG, no warranty can be given if they are used; the manufacturer's instructions must be observed.

The valid document for information and processing of the VITA LUMEX AC is the Instructions for Use.

Download at [www.vita-zahnfabrik.com/lumex](http://www.vita-zahnfabrik.com/lumex)

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