



VITA VIONIC® DENT DISC multiColor

Information for CNC machines

Machining mode: milling

- VITA VIONIC DENT DISC multiColor can be milled dry with air cooling or wet.

Recommended tools:

- Diamond coated ball nose end mills (synonym: carbon or DLC coating) are necessary.
- It is recommended to use the same diamond coated tools as used for milling zirconium dioxide.
- Use appropriate dental tools, e.g. from www.zecha.de, www.emuge-franken.com or www.imes-core.com

Recommended parameters:

Roughing		
Tool	Ø 2.5 mm	Ø 1 mm (residual material)
Tool Speed [rpm]	18000	45000
Tool Feed X Y [mm/min]	2000	500
Tool Feed Z [mm/min]	1500	500
Stepover X Y [mm]	1.875 (75% of tool diameter)	0.4 (40% of tool diameter)
Stepover Z [mm]	1.25	0.2

Finishing		
Tool	Ø 2.5 mm	Ø 1 mm
Tool Speed [rpm]	18000	45000
Tool Feed X Y [mm/min]	2000	1500
Tool Feed Z [mm/min]	1500	1000
Stepover X Y [mm]	0.5	0.1 – 0.15
Stepover Z [mm]	0.5	0.1