

Sintering Parameters for Programat S1, S1 1600 & S2

This document shows you how to correctly implement the NexxZr sintering programs in your Programat* S1, Programat* S1 1600 and Programat* S2 from Ivoclar Vivadent.

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Sintering programs for NexxZr S, NexxZr T and NexxZr+



	Number of units	Duration h	Phase	Temperature	Heating/ Cooling rate	Temperature	Heating/ Cooling rate	Holding time min
				°C	°C/min	°F	°F/min	
Standard	1-5	~ 3.7	1	20-1300	30	68-2372	54	30
			2	1300-1530	40	2372-2786	72	60
			3	1530-900	15	2786-1652	27	-
			4	900-80	20	1652-176	36	-
	5-10	~ 5.2	1	20-1300	30	68-2372	54	60
			2	1300-1530	40	2372-2786	72	120
			3	1530-900	15	2786-1652	27	-
			4	900-80	20	1652-176	36	-
Long	1-20	~ 10.7	1	20-900	10	68-1652	18	10
			2	900-1530	3	1652-2786	5.4	150
			3	1530-80	8	2786-176	14.4	-
	>21	~ 11.7	1	20-900	10	68-1652	18	10
			2	900-1530	3	1652-2786	5.4	210
			3	1530-80	8	2786-176	14.4	-
Over night	unlimited	~ 14.3	1	20-250	2	68-482	3.6	-
			2	250-1530	4	482-2786	7.2	240
			3	1530-80	8	2786-176	14.4	-

Standard program, 1-5 units:

Duration: approx. 3 h 56 min

Max. number of units: 5

Suitable for: NexxZr S, NexxZr T and NexxZr+

Programat S1 & S1 1600

°C

Px					→ 2.
t1	30	T1	1200	H1	00:00
t2	30	T2	1300	H2	00:30
t3	40	T3	1530	H3	01:00

Px					→ 3.
t4	15	T4	900	H4	00:00
t5	20	T5	100	H5	00:00
O	00:15				

°F

Px					→ 2.
t1	54	T1	2192	H1	00:00
t2	54	T2	2372	H2	00:30
t3	72	T3	2786	H3	01:00

Px					→ 3.
t4	27	T4	1652	H4	00:00
t5	36	T5	212	H5	00:00
O	00:15				

Programat S2

°C

	t [°C]	T [°C]	H [hh:mm]
1 ↗	30	1200	00:00
2 ↗	30	1300	00:30
3 ↗	40	1530	01:00
1 ↘	15	900	00:00
2 ↘	20	100	00:00

O [hh:mm]	00:15
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°F

	t [°F]	T [°F]	H [hh:mm]
1 ↗	54	2192	00:00
2 ↗	54	2372	00:30
3 ↗	72	2786	01:00
1 ↘	27	1652	00:00
2 ↘	36	212	00:00

O [hh:mm]	00:15
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Standard program, 5-10 units:

Duration: approx. 5 h 26 min

Max. number of units: 10

Suitable for: NexxZr S, NexxZr T and NexxZr+

Programat S1 & S1 1600

°C

Px					→ 2.
t1	30	T1	1200	H1	00:00
t2	30	T2	1300	H2	01:00
t3	40	T3	1530	H3	02:00

Px					→ 3.
t4	15	T4	900	H4	00:00
t5	20	T5	100	H5	00:00
O	00:15				

°F

Px					→ 2.
t1	54	T1	2192	H1	00:00
t2	54	T2	2372	H2	01:00
t3	72	T3	2786	H3	02:00

Px					→ 3.
t4	27	T4	1652	H4	00:00
t5	36	T5	212	H5	00:00
O	00:15				

Programat S2

°C

	t [°C]	T [°C]	H [hh:mm]
1 ↗	30	1200	00:00
2 ↗	30	1300	01:00
3 ↗	40	1530	02:00
1 ↘	15	900	00:00
2 ↘	20	100	00:00

O [hh:mm]	00:15
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°F

	t [°F]	T [°F]	H [hh:mm]
1 ↗	54	2192	00:00
2 ↗	54	2372	01:00
3 ↗	72	2786	02:00
1 ↘	27	1652	00:00
2 ↘	36	212	00:00

O [hh:mm]	00:15
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Long program, 1-20 units:

Duration: approx. 10 h 54 min

Max. number of units: 20

Suitable for: NexxZr S, NexxZr T and NexxZr+

Programat S1 & S1 1600

°C

Px					→ 2.
t1	10	T1	900	H1	00:10
t2	3	T2	1530	H2	00:00
t3	3	T3	1530	H3	02:30

Px					→ 3.
t4	8	T4	900	H4	00:00
t5	8	T5	100	H5	00:00
O	00:15				

°F

Px					→ 2.
t1	18	T1	1652	H1	00:10
t2	5	T2	2786	H2	00:00
t3	5	T3	2786	H3	02:30

Px					→ 3.
t4	14	T4	1652	H4	00:00
t5	14	T5	212	H5	00:00
O	00:15				

Programat S2

°C

	t [°C]	T [°C]	H [hh:mm]
1 ↗	10	900	00:10
2 ↗	3	1530	00:00
3 ↗	3	1530	02:30
1 ↘	8	900	00:00
2 ↘	8	100	00:00

O [hh:mm]	00:15
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°F

	t [°F]	T [°F]	H [hh:mm]
1 ↗	18	1652	00:10
2 ↗	5	2786	00:00
3 ↗	5	2786	02:30
1 ↘	14	1652	00:00
2 ↘	14	212	00:00

O [hh:mm]	00:15
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Long program, >21 units:

Duration: approx. 11 h 54 min

Max. number of units: >21

Suitable for: NexxZr S, NexxZr T and NexxZr+

Programat S1 & S1 1600

°C

Px					→ 2.
t1	10	T1	900	H1	00:10
t2	3	T2	1530	H2	00:00
t3	3	T3	1530	H3	03:30

Px					→ 3.
t4	8	T4	900	H4	00:00
t5	8	T5	100	H5	00:00
O	00:15				

°F

Px					→ 2.
t1	18	T1	1652	H1	00:10
t2	5	T2	2786	H2	00:00
t3	5	T3	2786	H3	03:30

Px					→ 3.
t4	14	T4	1652	H4	00:00
t5	14	T5	212	H5	00:00
O	00:15				

Programat S2

°C

	t [°C]	T [°C]	H [hh:mm]
1 ↗	10	900	00:10
2 ↗	3	1530	00:00
3 ↗	3	1530	03:30
1 ↘	8	900	00:00
2 ↘	8	100	00:00

O [hh:mm]	00:15
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°F

	t [°F]	T [°F]	H [hh:mm]
1 ↗	18	1652	00:10
2 ↗	5	2786	00:00
3 ↗	5	2786	03:30
1 ↘	14	1652	00:00
2 ↘	14	212	00:00

O [hh:mm]	00:15
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Over night program, unlimited:

Duration: approx. 14 h 31 min

Max. number of units: unlimited

Suitable for: NexxZr S, NexxZr T and NexxZr+

Programat S1 & S1 1600

°C

Px					→ 2.
t1	5	T1	700	H1	00:00
t2	4	T2	1530	H2	00:00
t3	4	T3	1530	H3	04:00

Px					→ 3.
t4	8	T4	900	H4	00:00
t5	8	T5	100	H5	00:00
O	00:15				

°F

Px					→ 2.
t1	9	T1	1292	H1	00:00
t2	7	T2	2786	H2	00:00
t3	7	T3	2786	H3	04:00

Px					→ 3.
t4	14	T4	1652	H4	00:00
t5	14	T5	212	H5	00:00
O	00:15				

Programat S2

°C

	t [°C]	T [°C]	H [hh:mm]
1 ↗	5	700	00:00
2 ↗	4	1530	00:00
3 ↗	4	1530	04:00
1 ↘	8	900	00:00
2 ↘	8	100	00:00

O [hh:mm]	00:15
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°F

	t [°F]	T [°F]	H [hh:mm]
1 ↗	9	1292	00:00
2 ↗	7	2786	00:00
3 ↗	7	2786	04:00
1 ↘	14	1652	00:00
2 ↘	14	212	00:00

O [hh:mm]	00:15
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Sintering programs for NexxZr T Multi and NexxZr+ Multi



	Number of units	Duration h	Phase	Temperature	Heating/ Cooling rate	Temperature	Heating/ Cooling rate	Holding time
				°C	°C/min	°F	°F/min	min
Speed	1 - 5	~ 4.8	1	20 - 1000	60	68 - 1832	108	10
			2	1000 - 1530	3	1832 - 2786	5.4	60
			3	1530 - 1100	50	2786 - 2012	90	-
			4	1100 - 80	60	2012 - 176	108	-
Long	unlimited	~ 9.6	1	20 - 900	10	68 - 1652	18	30
			2	900 - 1500	3	1652 - 2732	5.4	120
			3	1500 - 900	10	2732 - 1652	18	-
			4	900 - 300	8	1652 - 572	14.4	-

Speed program, 1-5 units:

Duration: approx. 5 h 07 min

Max. number of units: 5

Suitable for: NexxZr T Multi and NexxZr+ Multi

Programat S1 & S1 1600

°C

Px					→ 2.
t1	60	T1	1000	H1	00:10
t2	3	T2	1300	H2	00:00
t3	3	T3	1530	H3	01:00

Px					→ 3.
t4	50	T4	1100	H4	00:00
t5	50	T5	100	H5	00:00
O	00:15				

°F

Px					→ 2.
t1	108	T1	1832	H1	00:10
t2	5	T2	2372	H2	00:00
t3	5	T3	2786	H3	01:00

Px					→ 3.
t4	90	T4	2012	H4	00:00
t5	90	T5	212	H5	00:00
O	00:15				

Programat S2

	t [°C]	T [°C]	H [hh:mm]
1 ↗	60	1000	00:10
2 ↗	3	1300	00:00
3 ↗	3	1530	01:00
1 ↘	50	1100	00:00
2 ↘	50	100	00:00

O [hh:mm]	00:15
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	t [°F]	T [°F]	H [hh:mm]
1 ↗	108	1832	00:10
2 ↗	5	2372	00:00
3 ↗	5	2786	01:00
1 ↘	90	2012	00:00
2 ↘	90	212	00:00

O [hh:mm]	00:15
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Long program, unlimited:

Duration: approx. 9 h 48 min

Max. number of units: unlimited

Suitable for: NexxZr T Multi and NexxZr+ Multi

Programat S1 & S1 1600

°C

Px					→ 2.
t1	10	T1	900	H1	00:30
t2	3	T2	1500	H2	00:00
t3	3	T3	1500	H3	02:00

Px					→ 3.
t4	10	T4	900	H4	00:00
t5	8	T5	300	H5	00:00
O	00:15				

°F

Px					→ 2.
t1	18	T1	1652	H1	00:30
t2	5	T2	2732	H2	00:00
t3	5	T3	2732	H3	02:00

Px					→ 3.
t4	18	T4	1652	H4	00:00
t5	14	T5	572	H5	00:00
O	00:15				

Programat S2

°C

	t [°C]	T [°C]	H [hh:mm]
1 ↗	10	900	00:30
2 ↗	3	1500	00:00
3 ↗	3	1500	02:00
1 ↘	10	900	00:00
2 ↘	8	300	00:00

O [hh:mm]	00:15
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°F

	t [°F]	T [°F]	H [hh:mm]
1 ↗	18	1652	00:30
2 ↗	5	2732	00:00
3 ↗	5	2732	02:00
1 ↘	18	1652	00:00
2 ↘	14	572	00:00

O [hh:mm]	00:15
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