



PRODUCT INFORMATION

Sintering Parameters

Programat* S1 and Programat* S1 1600 (Ivoclar Vivadent)

Zirconia: Sagemax NexxZr S, NexxZr T, NexxZr +



STANDARD	Number of units	Duration in h	Phase	Temperature	Temperature	Heating/cooling rate		Holding time (min)
				in °C	in °F	in °C/(min)	in °F/(min)	
1 - 5	~ 3,7		Phase 1	20 - 1300	68 - 2372	30	54	30
			Phase 2	1300 - 1530	2372 - 2786	40	72	
			Phase 3	1530 - 900	2786 - 1652	15	27	
			Phase 4	900 - 80	1652 - 176	20	36	
5 - 10	~ 5,2		Phase 1	20 - 1300	68 - 2372	30	54	60
			Phase 2	1300 - 1530	2372 - 2786	40	72	
			Phase 3	1530 - 900	2786 - 1652	15	27	
			Phase 4	900 - 80	1652 - 172	20	36	



The "Standard" program can be entered in the Programat S1 and Programat S1 1600 as follows:

Standard program, 1-5 units:

°C

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

°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	15	T4	900	H4	00:00
t5	20	T5	100	H5	00:00
O	00:15				

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

Program duration (hh:mm) 03:56

Standard program, 5-10 units:

°C

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

°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	15	T4	900	H4	00:00
t5	20	T5	100	H5	00:00
O	00:15				

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

Program duration (hh:mm) 05:26



PRODUCT INFORMATION

	Number of units	Duration in h	Phase	Temperature	Temperature	Heating/cooling rate		Holding time (min)
				in °C	in °F	in °C/(min)	in °F/(min)	
LONG	1 - 20	~ 10,7	Phase 1	20 - 900	68 - 1652	10	18	10
			Phase 2	900 - 1530	1652 - 2786	3	5.4	150
			Phase 3	1530 - 80	2786 - 176	8	14.4	-
	>21	~ 11,7	Phase 1	20 - 900	68 - 1652	10	18	10
			Phase 2	900 - 1530	1652 - 2786	3	5.4	210
			Phase 3	1530 - 80	2786 - 176	8	14.4	-



The "Long" program can be entered in the Programat S1 and Programat S1 1600 as follows:

Long program, 1-20 units:

°C

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

°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	8	T4	900	H4	00:00
t5	8	T5	100	H5	00:00
O	00:15				

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

Program duration (hh:mm) 10:54

Long program, >21 units:

°C

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

°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	8	T4	900	H4	00:00
t5	8	T5	100	H5	00:00
O	00:15				

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

Program duration (hh:mm) 11:54



PRODUCT INFORMATION

OVER NIGHT	Number of units	Duration in h	Phase	Temperature in °C	Temperature in °F	Heating/cooling rate		Holding time (min)
	unlimited	~ 14,3	Phase 1	20 - 250	68 - 482	2	3.6	-
			Phase 2	250 - 1530	482 - 2786	4	7.2	240
			Phase 3	1530 - 80	2786 - 176	8	14.4	-



The "Over night" program can be entered in the Programat S1 and Programat S1 1600 as follows:

Over night program, unlimited:

°C

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

°F

Px					→ 2.
t1	3.6	T1	482	H1	00:00
t2	7.2	T2	2786	H2	00:00
t3	7.2	T3	2786	H3	04:00

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

Px					→ 3.
t4	14.4	T4	1652	H4	00:00
t5	14.4	T5	212	H5	00:00
O	00:15				

Program duration (hh:mm) 14:31



PRODUCT INFORMATION

Sintering Parameters

Programat* S1 and Programat* S1 1600 (Ivoclar Vivadent)



Zirconia: Sagemax NexxZr + Multi



SPEED	Number of units	Duration in h	Phase	Temperature in °C	Temperature in °F	Heating/cooling rate in °C/(min)	Heating/cooling rate in °F/(min)	Holding time (min)
			1-5	~ 4.8	Phase 1	20 - 1000	68 - 1832	60
			Phase 2	1000 -1530	1832 - 2786	3	5.4	60
			Phase 3	1530 - 1100	2786 - 2012	50	90	-
			Phase 4	1100 - 80	2012 - 176	60	108	-

The "Speed" program can be entered in the Programat S1 & S1 1600 as follows:

Speed program, 1-5 units:

°C

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

°F

Px					→ 2.
t1	108	T1	1832	H1	00:10
t2	5.4	T2	2372	H2	00:00
t3	5.4	T3	2786	H3	01:00

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

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

Program duration (hh:mm) 05:07



PRODUCT INFORMATION

LONG	Number of units	Duration in h	Phase	Temperature in °C	Temperature in °F	Heating/cooling rate in °C/(min) in °F/(min)		Holding time (min)
	unlimited	~ 9,6	Phase 1	20 - 900	68 - 1652	10	18	30
			Phase 2	900 - 1500	1652 - 2732	3	5.4	120
			Phase 3	1500 - 900	2732 - 1652	10	18	-
			Phase 4	900 - 300	1652 - 572	8	14.4	-



The "Long" program can be entered in the Programat S1 & S1 1600 as follows:

Long program, 1-20 units:

°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				

Program duration (hh:mm) 09:48

°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	18	T5	572	H5	00:00
O	00:15				

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