



**HEIMERLE+MEULE**

**INSPIRATION**  
**press**

## Press Ceramik

The perfect frame material for all ceramic dental restorations.  
The best possible supplement for **INSPIRATION** – the up-to-date leucite-glass-ceramic with reduced fusing temperature.

- **Natural vividness**
- **High ratio of fluorescence**
- **Quick results due to simple handling**
- **Precise fit with the new DURO-CONT investment material**
- **Outstanding results due to colour variety of the press pellets**
- **Perfectly matching the INSPIRATION**
- **Cost-efficient way to all ceramic dental restorations**

**Instruction for use**





## Instruction for use INSPIRATIONpress

### 1 Indication

The technical characteristics of the material make indications of all ceramic individual crowns within the dental front and molar area as well as single- and multi-faced inlays, onlays, and veneers possible. The frame material INSPIRATIONpress is perfectly harmonising with the up-to-date leucite-glass-ceramic INSPIRATION.

### 2 Modell/Work Stump

The master model can be prepared as usual. Apply the distance varnish for the composite cement evenly up to 1 mm to the preparation margin.

### 3 Modelling

Wax: Burning residue-free, for example with PLATINA®press modelling wax.

Shape: Work up wax model to final shape in accordance with the anatomical and functional aspects.

Wall thickness of the ceramic:

Steps	minimum 1,0 mm
Cups and chewing area made of 2/3 press ceramic and 1/3 layering ceramic	minimum 1,5 mm

### 4 Spruing of the Pressing Cone

Direct spruing	wax wire Ø	2 – 3 mm
	wax wire length	7 – 9 mm

NOTE: The root points of the wax wire have to be rounded. The wax wires have to be aligned in flow direction.

### 5 Material Input

Wax weight:	weight the modelled object with pressing cone
Up to max. 0.6 g wax weight:	1 blank
Up to max. 1.4 g wax weight:	2 blanks

### 6 Investment

Use only phosphate-bound investment materials.

Speed precision investment material: DUROCONT new

Mixing ratio: 100 g powder : 25 ml liquid/distilled water

Concentration: liquid : distilled water

Inlays, MOD's: 40 % : 60 %

Onlays: 50 % : 50 %

Crowns and caps: 60 % : 40 %

Note: Higher concentration of the DUROCONT liquid will increase the total expansion. Less DUROCONT liquid results in less setting expansion.

Carefully pour the investment material into the muffle former.

Setting time for speed investment material:

Muffle 1 (100 g)	17 minutes
Muffle 2 (200 g)	19 minutes

Put the muffle into the pre-heated to 850 °C furnace.

### 7 Pre-Heating

Speed: Muffle 1 at least 60 minutes  
Muffle 2 at least 75 minutes

Standard: After more than 25 minutes setting time, put muffle into the furnace at room temperature.  
Heat with 5 °C per minute to 290 °C. Hold 30 minutes (muffle 2 – 45 minutes), further heat with 5 °C per minute to 590 °C and hold 30 minutes (muffle 2 – 45 minutes), then heat with 5 °C per minute to 850 °C and hold 30 minutes (muffle 2 – 45 minutes).

### 8 Pressing

Use suitable press ceramic furnace:

Pre-heating temperature:	700 °C
Heating rate:	60 °C/min.
End temperature:	1080 °C
Holding time:	20 minutes
Pressing time:	9 minutes

**Important Note:** Use only alox plungers for the pre-heating furnace. Put press blanks cold – alox plunger hot into the converted muffle. Put disposable plungers cold into the hot muffle.

### 9 Divesting

Pre-blast with gloss-blast pearls under 4 bar pressure until the ceramic objects become visible. Then clean-blast with 2 bar pressure.

### 10 Finishing Staining- and Layering Technique

Separate pressing cones with a thin diamond disk. Carefully put objects onto the stump, remove impurities with a diamond abrasive wheel, if necessary create surface structure with suitable abrasive tools, clean thereafter.

Staining technique:  
Stir glaze material to creamy consistence and perform 2 glaze firing circles (see firing chart).

Layering technique:  
Reduce crowns with diamonds/grinders.  
Keep minimum strength of the dentin core of at least 0.8 mm.  
Clean thereafter and layer with ceramic – INSPIRATION (see firing chart).

Attention: Avoid local overheating during grinding.

Note: Use only very thin metal pins or firing wool.

Lead: INSPIRATIONpress is compatible with every layering material, staining colour and Shade of the INSPIRATION assortment.

### 11 Information for the Dentist

Use all ceramic restorations with composite bonding materials only. Inorganic cements are contraindicated and increase breakage risks.

In order to ensure sufficient bonding, the acid-active inner ceramic side has to be silane-treated prior to insertion.

## INSPIRATION-Firing Chart

	Basic temperature [°C]	Pre-drying time [min]	Heating rate [°C/min]	Vacuum start [°C]	End temperature [°C]	Holding time [min]
<b>Layering Technique</b>						
Dentin/enamel firing circle	400	4 – 6	60	450	880	1
Glaze firing circle	400	4	60	–	840 – 850	1
<b>Staining Technique</b>						
Staining colours/Shade	400	4	60	–	860 – 865	1
Glaze firing circle	400	4	60	–	860 – 865	1