

# DALE DENTAL

## PRODUCT TECH SPECS

### IPS EMax

**MANUFACTURER** – Ivoclar Vivadent, www.ivoclarvivadent.com, 800.533.6825

**YEAR LAUNCHED** – 2006

**AVAILABLE AT DALE DENTAL SINCE** – 2006

**CERTIFICATIONS** – Dale Dental is a Certified IPS Empress Laboratory

**DESCRIPTION** – All Empress restorative products are fabricated using the lost wax technique. Using this technique, waxed patterns of crowns, inlay/onlays or laminates are invested and put through a burn-out process. Small ingots of the desired shaded glass material are then placed into the heated ring, molten and pressed into the pattern using specialized Ivoclar pressing equipment. The process yields accurate, highly esthetic units that can be layered with additional porcelains or pressed to full contour and stained to achieve the desired color.

IPS e.max® delivers the ultimate in metal free esthetics and strength utilizing both Pressable and CAD/CAM technologies. IPS e.max lets you select from multiple framework materials giving you the versatility you want while always veneering with the same ceramic giving you the simplicity you need.

Learn more at [www.DaleDental.com](http://www.DaleDental.com)

### RESTORATION SELECTOR SMARTCHART

Indications		
<b>Single Unit</b> Yes	<b>Bridges</b> Up to 3 units	<b>Laminates</b> No
<b>Inlay/Onlay</b> No	<b>Material</b> Lithium Disilicate Glass Ceramic	<b>Flexural Strength</b> —
<b>Thickness</b> .08 mm	<b>Span</b> Up to 3 units	<b>Prep Type</b> Any
<b>Coping Color</b> Shaded	<b>Translucency</b> Medium or Opaque	<b>Cements</b> Contact manufacturer for details
<b>Turnaround</b> Next Day, 2 Day, 3 Day, 4 Day, 5 Day	<b>Porcelain Type</b> Contact manufacturer for specific details and compatibility	<b>Porcelain Trial Sizes</b> <b>Available at Dale Dental</b> Yes

### LABORATORY PREPARATION

Start with a model made from a class IV, or equivalent die stone.

**Bridges** – Connector areas should be no less than 4mm vertical (incisal-gingival) by 4 mm horizontally (buccal-lingual) or 16mm square. Pontic spans are not to exceed 11 mm anterior to canine and 9 mm posterior to canine. Measurements should be taken from the proximal surfaces of the unprepared abutment teeth adjacent to the pontic site. Empress IPS connectors are prefabricated anatomically-shaped plastic connectors that ensure optimum connector size between the pontic and bridge abutment. Please contact us for more information regarding sizes and shapes available.

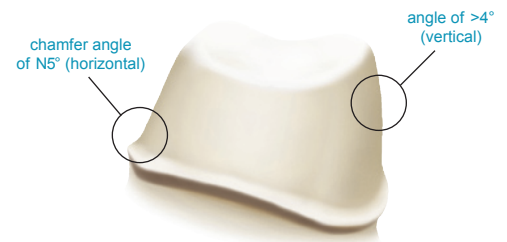
**Stump Die** – Stump dies can be helpful in both staining accuracy and the handling of your Empress units. Please be sure to include the patient's preparation shade when requesting a stump die. Make sure to place a check in the Stump Die box and include the stump shade if you are requesting a stump die.

### Build-ups

Severely prepped teeth should be built up.

### Angulation

Vertical walls and sharp line angles are difficult for the In-Ceram process. Note proper angulation of prep area.



### Model Prep

**Stone Color** – Light color stones such as white or buff work best and yield the most accurate result

**Stone Type** – Type IV die stone or similar

**Stone Expansion** – Low

**Block Out** – Yes

**Margin** – The die must have a ditched margin. Use a margin pencil just below the margin line to outline the requested margin design on the die(s)

**Conditioner/Sealer** – May apply sealer

**Die Spacer** – Apply die spacer to within 1 mm of the margin. For very retentive preparations an additional thin coat of removable die spacer is also applied to within 1mm of the margin

**Wax Ups** – A full contour wax-up should be developed and then cut back to ensure the correct ratio of core thickness to layered material. Fabricate a full anatomical wax-up using your choice of low ash dental wax. Determine the thickness of each crown and consult the tooth reduction chart to reduce the wax-up by the appropriate amount. Important: A minimum thickness of .8 mm must be maintained. To assure an accurate pressing, we may add to areas that do not meet the minimum thickness requirements. After waxing your crown to full contour, measure along the incisal, body and gingival around the entire crown.

(continued on back)

All Dale Dental copings and bridge frameworks are manufactured in the USA. Information subject to change. Contact Dale Dental or Ivoclar Vivadent for more information.  
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## EMPRESS ERIS FOR E2 CUTBACK REDUCTION CHART

If your wax pattern measures (mm)	1.5	1.8	2.0	2.2	2.5	2.8	3.0	3.2	3.5	3.8	4.0	4.2	4.5	4.8	5.0
Cut it back by (mm)	.7	.8	.9	1.0	1.2	1.3	1.4	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
For a final thickness of (mm)	.8	1.0	1.1	1.2	1.3	1.5	1.6	1.7	2.0	2.3	2.5	2.7	3.0	3.3	3.5

### COMPLETING THE RX

- Write in your patients name and choose a turnaround time
- Indicate tooth numbers
- Select Empress from the list by checking the corresponding box
- Write "Eris Layering" in the Shade area and check your preference for a stump die
- Select Elite service level (optional)

**ELITE LEVEL SERVICE** – Elite Level Service for Empress crowns and bridges gives your case priority status throughout the manufacturing process. Included in this are:

**Enhanced Customer Service and Technical Support** – Hallmarked by an even greater degree of customer interaction.

**Priority Sorting Upon Receipt** – Using Elite urgent stickers, this initial presort moves Elite cases into production first on that day.

**Guaranteed Availability** – Guaranteed capacity allocations on all machinery and resources.

**Redundant Technical Checkpoints** – Case attributes are observed frequently at various stages of production.

**Additional outbound insurance** – At no extra cost, this added benefit covers your articulators or other valuable items which may be included in your case.

Please see the Dale Dental Pricing Sheet for pricing details.

**RECEIVING YOUR CASE** – When you receive your coping or framework steam clean to make sure it is free of oil and being layering.

**PORCELAIN TRIAL SIZES** – We carry several trial-sized porcelains for you to complete your case with. Contact customer service at 888.GET.DALE (888.438.3253) for more information

**FINISHING NOTES** – You will need the following to complete your case:

- Empress Universal Stain and Glaze Kit
- Layering porcelains for the shade of your finished restoration
- Option: Low fusing add-on material for contacts, etc.

**Foundation Firing** – Carefully air abrade the ceramic framework with 100µm aluminum oxide at 1 bar (15 psi). Steam clean and dry with oil-free air. Avoid any contamination from this time onward. Conduct a foundation firing using either Eris for E2 dentin powder or IPS Universal Shade Paste. IPS Eris for E2 build-up liquid or IPS Empress Universal glazing and staining liquid must be used for mixing dentin powders. Shade pastes should be thinned only with IPS Empress Universal glazing and staining liquid.

**Firing Precautions** – Only honey-combed firing trays and metal firing pins should be used. Do not use silicon-nitride support pins. Flat ended metal pins or sharp points on pins should be rounded, or platinum foil should be used to create a smooth tapered point at the pin's tip. Discard or air abrade pins that may have developed an oxidized layer.

If you have any questions or for more information please contact our technical service support at 888.GET.DALE (888.438.3253).

### LABORATORY PREPARATION

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After measuring the thickness in each area, consult the chart for the reduction amount. Example: The body 1/3 of your wax up measures 2.8 mm. According to the chart above, the cutback would be of 1.3 mm leaving a coping thickness in that area of 1.5 mm. Note: The coping thickness never falls below 1.5 mm.

**Packaging** – Ship only dies and wax-ups only

**Please Note** – Including other items such as study models, articulators, matrixes, and/or photographs could help us to create an improved framework design (Additional charges will apply)

**Do Not Send** – Impressions

### CLINICAL PREPARATION

If you need information for your dentist, please contact the system manufacturer or a Dale Dental customer service representative at 888.GET.DALE (888.438.3253).

### THANK YOU FOR CHOOSING DALE DENTAL

Since 2000, Dale Dental has worked hard to earn your business and – more importantly – your trust. From the latest products to the best customer service, here are just a few of the ways we continue to be your resource for copings and bridge frameworks.

**Secure & Non-competitive** – We do not compete for your dentist clientele because we don't work with dentists. We are America's first dental lab exclusively for dental labs.

**Experienced** – Our specially trained technicians maintain an in-depth system knowledge and are committed to finishing cases that meet or exceed exacting manufacturer standards.

**Consistent & Reliable** – With an on-time delivery of over 99% and inbound and outbound email notifications sent daily with delivery tracking hyperlinks for each case, your assured of keeping your customers satisfied.

**Informative & Progressive** – Login to our website to see the status of your cases or provide feedback through on-line quality control cards that instantly display your feedback to the technicians responsible for your cases.

**Certified** – Dale Dental is the first outsourcing dental laboratory in the United States and among the first worldwide to obtain the ISO 9001:2008 certification. We are also a CDL laboratory and employ CDT technicians in many supervisory positions.

**Friendly** – You can always count on our welcoming, professional and well-informed staff to answer questions about the products and services we offer.

At Dale Dental, we know you have choices. And we're proud you've chosen us.

