



General Sintering Guidance

Cycle	Recommended use	Time
Standard	units ≤ 7 units	6.5h
Long	For units > 7 units and thick-walled units	8.5h
Speed	Single crown, or bridge < 7 units	1.5h

MHT, GM, MM-4D

Crowns and bridges (≤ 7 units)

Standard Cycle
403 minutes

STEP	Start temperature(°C)	Final temperature(°C)	Time(min)	Ramp Rate(°C/min)
Step1	20	1050	103	10
Step2	1050	1050	20	Holding
Step3	1050	1500	90	5
Step4	1500	1500	120	Holding
Step5	1500	800	70	-10

MHT, GM, MM-4D

Bridges (> 7 units)

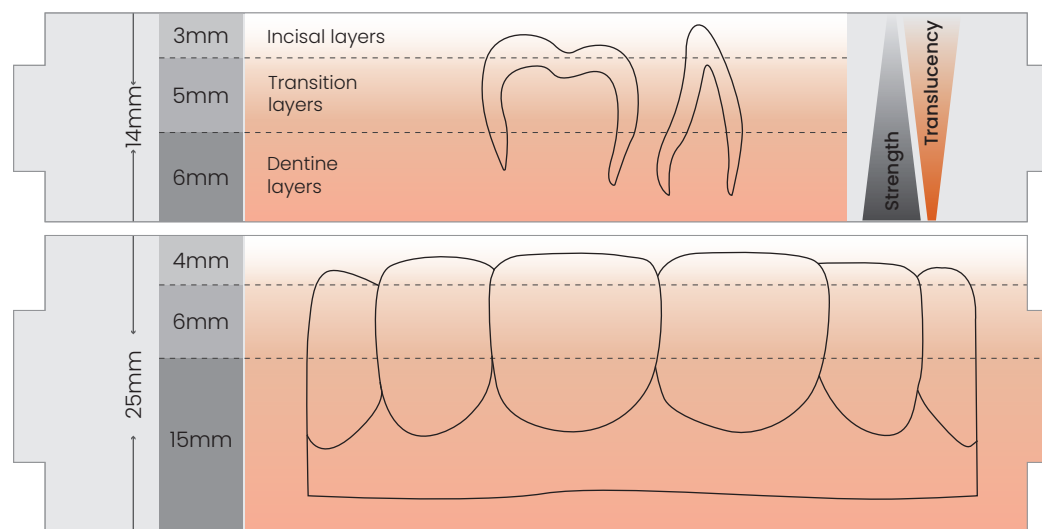
Long Cycle
526 minutes

STEP	Start temperature(°C)	Final temperature(°C)	Time(min)	Ramp Rate(°C/min)
Step1	20	1050	206	5
Step2	1050	1050	20	Holding
Step3	1050	1500	90	5
Step4	1500	1500	120	Holding
Step5	1500	800	90	-8

Disc Thickness Selection

HUGE has 8 sizes of multilayer zirconia for maximum flexibility.
12 mm, 14 mm, 16 mm, 18 mm, 20 mm, 22 mm, 25 mm, 30 mm.

Blank Height	12mm	14mm	16mm	18mm	20mm	22mm	25mm	30mm
Incisal layers	3mm	3mm	3mm	3mm	4mm	4mm	4mm	4mm
Transition layers	4mm	5mm	5mm	5mm	6mm	6mm	6mm	6mm
Dentine layers	5mm	6mm	8mm	10mm	11mm	12mm	15mm	20mm



NOTE:

1. Select an appropriately sized disc. The vertical positioning may significantly influence the final shade intensity and transparency.
2. A unit does not need to fill the entire height of a disc but should be at least ¾ the height. HUGE recommends nesting in the middle height to maximize shade distribution. It is better to leave approximately 0.5-1.0 mm space within the incisal layer.
3. Align crowns vertically on blanks during nesting; avoid steep tilting which causes uneven shading.



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