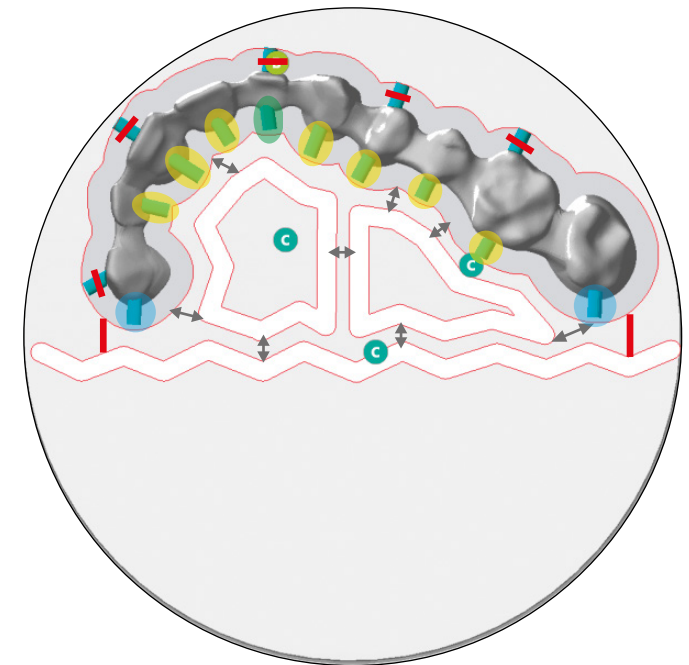
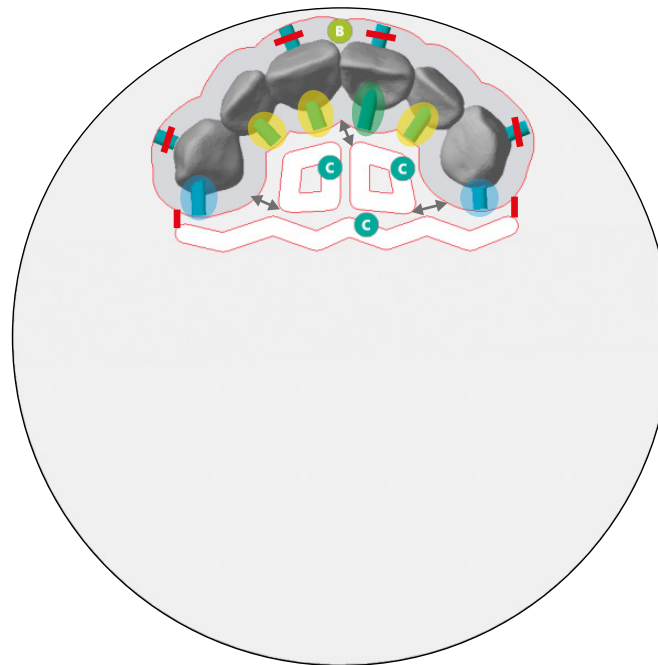
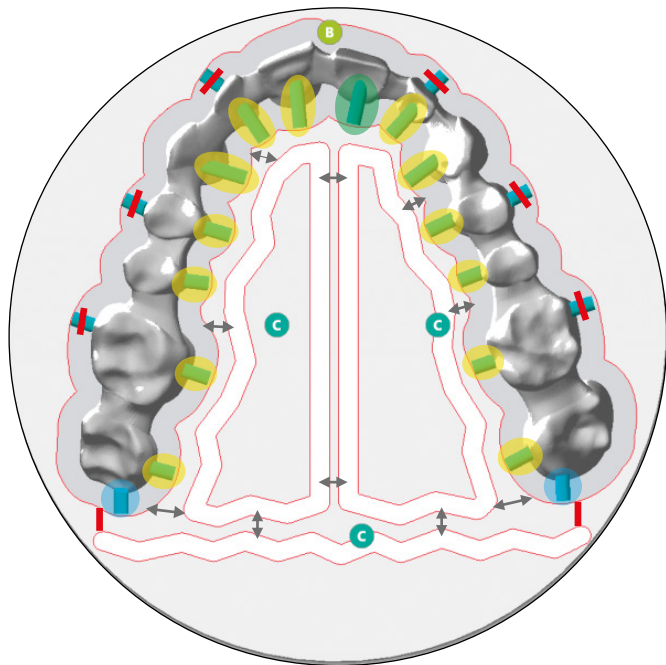


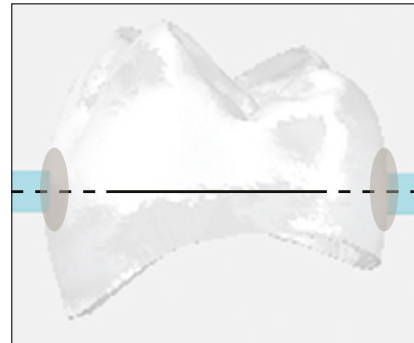
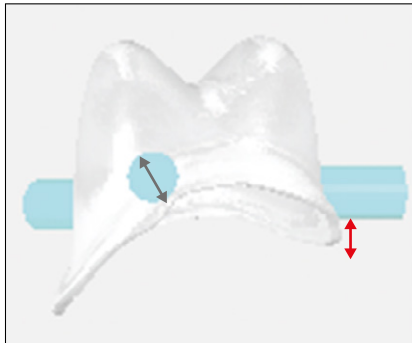
Rules for restorations **with** sintering support structure (> 5-unit bridges with pronounced curvature)

- Position a holding bar in the extension of the centre strut of the sinter frame and attach to the restoration. Do not place the holding bar in the interdental area.
- Connect all the other units with the sinter frame using a holding bar.
- Provide terminal units with a holding bar vertical to the sinter base.
- ↔ Evenly designed sinter frame (2–5 mm).
- Separate cut-off points before sintering. Smooth out the holding bars marked in this way before sintering.



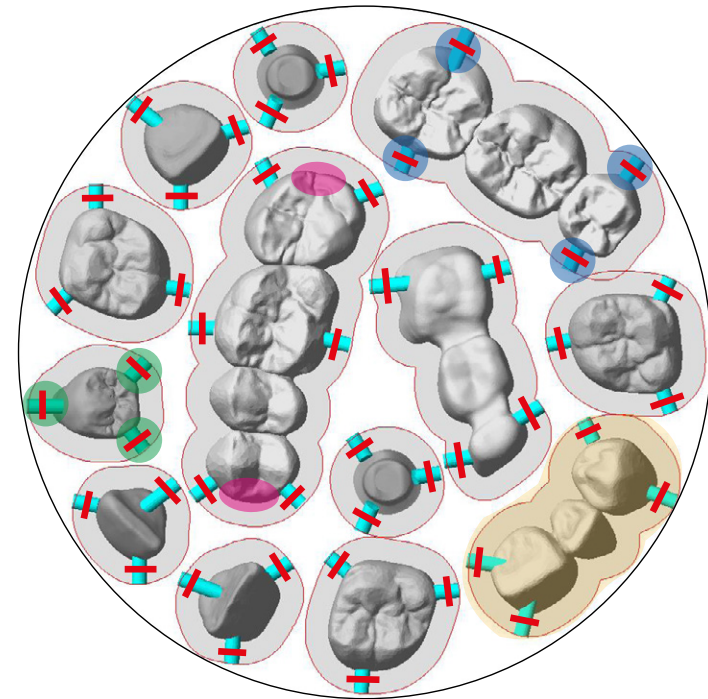
General rules for the attachment of holding bars

- Always align holding bars horizontally.
- ↔ The diameter of the holding bars must be at least 2.0 mm.
- ↔ Attach the holding bars at least 1.0 mm above the preparation margin.
- For multi-unit restorations, the holding bars have to be attached to the restoration in the oral and vestibular area.
For full-contour restoration or frameworks with a reduced anatomical shape, the holding bars should be placed in the area of the anatomical equator so that no undercuts are created and the restoration can be optimally processed from above and below.



Rules for restorations **without** sintering support structures (≤5-unit bridges)

- Attach 3 holding bars per single-tooth restoration.
- For multi-unit restorations, provide terminal units with 2 holding bars (oral and vestibular area). If required, provide additional units with holding bars.
- Large milling pieces are to be positioned preferably with the tooth arch parallel to the disc margin.
- The holding bars should not be placed in the interdental area.
- Separate cut-off points before sintering. Smooth out the holding bars marked in this way before sintering.



Please refer to the IPS e.max ZirCAD Instructions for Use for detailed information about separating, positioning and sintering.