



Solera™

HIGH FUSING PORCELAIN

## Color Combination Chart

Shades	A1	A2	A3	A3.5	A4	B1	B2	B3	B4	C1	C2	C3	C4	D2	D3	D4
Opagues	O A1	O A2	O A3	O A3.5	O A4	O B1	O B2	O B3	O B4	O C1	O C2	O C3	O C4	O D2	O D3	O D4
Opacious Dentines	OD A1	OD A2	OD A3	OD A3.5	OD A4	OD B1	OD B2	OD B3	OD B4	OD C1	OD C2	OD C3	OD C4	OD D2	OD D3	OD D4
Chroma Dentines Shoulder	BA				BB				BC				BD			
Dentines	D A1	D A2	D A3	D A3.5	D A4	D B1	D B2	D B3	D B4	D C1	D C2	D C3	D C4	D D2	D D3	D D4
Incisals	S68	S68	S69	S69	S70	S67	S69	S69	S69	S70	S69	S69	S70	S70	S69	S69
Transparents	TR Superclear - Clear - Neutral - Opal - Red - Yellow - White - Light Blue - Gray - Neon															

## Firing Chart

Cycle	Dry Time (Entry Time)	Entry Temperature	High Temperature	Heat Rate Per Minute	Vacuum Start	Vacuum Release	Hold Time W/out Vacuum	Cool Time <b>**See Note</b>	Appearance
1st Paste Opaque	7 Minutes	500c / 930f	970c / 1780f	80c / 175f	500c / 930f	970c / 1780f	1 Minute	0	Egg Shell
2nd Paste Opaque	7 Minutes	500c / 930f	950c / 1745f	60c / 140f	600c / 1115f	950c / 1745f	1 Minute	0	Egg Shell
1st Powder Opaque	2 Minutes	600c / 1100f	970c / 1780f	50c / 120f	600c / 1100f	970c / 1780f	1 Minute	0	Slight Shine
2nd Powder Opaque	2 Minutes	600c / 1100f	940c / 1725f	50c / 120f	600c / 1100f	940c / 1725f	1 Minute	0	Egg Shell
1st Body / Dentine	5 Minutes	440c / 825f	940c / 1725f	50c / 120f	440c / 825f	940c / 1725f	1 Minute	0 (NP-4 min.)	Slight Shine
2nd Body / Dentine	4 Minutes	440c / 825f	935c / 1715f	50c / 120f	440c / 825f	935c / 1715f	1 Minute	0 (NP-4 min.)	Slight Shine
Glaze	3 Minutes	600c / 1100f	930c / 1705f	50c / 120f	None	None	1 Minute	0 (NP-4 min.)	
1st & 2nd Shoulder	3 Minutes	450c / 850f	940c / 1725f	50c / 120f	450c / 850f	940c / 1725f	1 Minute	0	Slight Shine

**\*\*NOTE:** Non precious alloys require a 4 minute cool time. It is also possible that alloys with a cte higher than 14.3 may also require a 3-4 minute cool time. Opaque cycles never require a cool time.

## Shoulder Mixing Chart

	Proportional Mixing Ratios				
Shoulder Powder	••	•	•••	••••	•••••
Neutral Powder	•••	•	••	•••	•
Shade Group					
A	A1	A2	A3	A3.5	A4
B	B1	B2	B3		B4
C	C1	C2	C3		C4
D		D2	D3		D4

### Additions and Corrections

Solera does not require the use of a special correction powder.

For small additions to contacts or cusps mix the corresponding powder (body, incisal or clear) with Solera glaze liquid, apply to the dry restoration and fire during the glaze cycle.

For corrections requiring larger amounts of porcelain mix the corresponding powder with Solera model liquid. Then fire Solera using your last dentine cycle minus 18°F or 10°C.



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