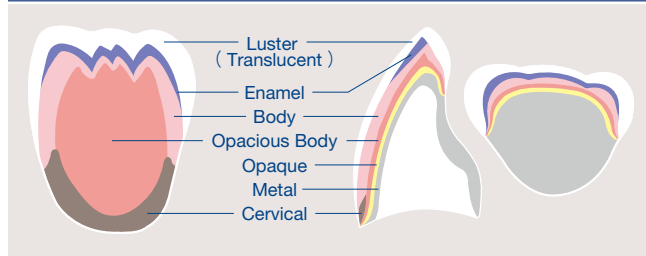


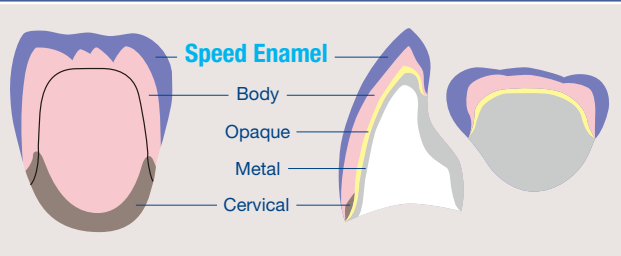
# EX-3 LINE-UPS

Paste Opaque	6g	POA <sub>1</sub> /PONa <sub>1</sub> POC <sub>1</sub> /PONc <sub>1</sub> PONP <sub>1.5</sub>	POA <sub>2</sub> /PONa <sub>2</sub> POC <sub>2</sub> /PONc <sub>2</sub> PONP <sub>2.5</sub>	POA <sub>3</sub> /PONa <sub>3</sub> POC <sub>3</sub> /PONc <sub>3</sub> PONW <sub>0</sub>	POA <sub>3.5</sub> /PONa <sub>3.5</sub> POC <sub>4</sub> /PONc <sub>4</sub> PONW <sub>0.5</sub>	POA <sub>4</sub> /PONa <sub>4</sub> POD <sub>2</sub> /PONd <sub>2</sub> POEW <sub>0</sub>	POB <sub>1</sub> /PONb <sub>1</sub> POD <sub>3</sub> /PONd <sub>3</sub> POEW	POB <sub>2</sub> /PONb <sub>2</sub> POD <sub>4</sub> /PONd <sub>4</sub> POBA	POB <sub>3</sub> /PONb <sub>3</sub> — —	POB <sub>4</sub> /PONb <sub>4</sub> — —
Paste Opaque Modifier	3g	PO White	PO Gray	PO Orange	PO Earth Brown	PO Reddish Brown	PO Pink	PO Blue	PO Yellow	—
Universal Paste Opaque	6g	UPnA <sub>1</sub> UPnC <sub>1</sub> UPNP <sub>1.5</sub>	UPnA <sub>2</sub> UPnC <sub>2</sub> UPNP <sub>2.5</sub>	UPnA <sub>3</sub> UPnC <sub>3</sub> UPNW <sub>0</sub>	UPnA <sub>3.5</sub> UPnC <sub>4</sub> UPNW <sub>0.5</sub>	UPnA <sub>4</sub> UPnD <sub>2</sub> UPEW <sub>0</sub>	UPnB <sub>1</sub> UPnD <sub>3</sub> UPEW	UPnB <sub>2</sub> UPnD <sub>4</sub> —	UPnB <sub>3</sub> — —	UPnB <sub>4</sub> — —
Universal Paste Opaque Modifier	3g	UP White	UP Gray	UP Orange	UP Earth Brown	UP Reddish Brown	UP Pink	UP Blue	UP Yellow	—
Powder Opaque	10,50,200g	A <sub>1</sub> O/nA <sub>1</sub> O C <sub>1</sub> O/nC <sub>1</sub> O NP <sub>1.5</sub> O	A <sub>2</sub> O/nA <sub>2</sub> O C <sub>2</sub> O/nC <sub>2</sub> O NP <sub>2.5</sub> O	A <sub>3</sub> O/nA <sub>3</sub> O C <sub>3</sub> O/nC <sub>3</sub> O NW <sub>0</sub>	A <sub>3.5</sub> O/nA <sub>3.5</sub> O C <sub>4</sub> O/nC <sub>4</sub> O NW <sub>0.5</sub> O	A <sub>4</sub> O/nA <sub>4</sub> O D <sub>2</sub> O/nD <sub>2</sub> O EW <sub>0</sub> O	B <sub>1</sub> O/nB <sub>1</sub> O D <sub>3</sub> O/nD <sub>3</sub> O EW <sub>0</sub>	B <sub>2</sub> O/nB <sub>2</sub> O D <sub>4</sub> O/nD <sub>4</sub> O —	B <sub>3</sub> O/nB <sub>3</sub> O — —	B <sub>4</sub> O/nB <sub>4</sub> O — —
Powder Opaque Modifier	10,50g	OM Gray	OM Orange	OM Pink	—	—	—	—	—	—
Body	10,50,200g	A <sub>1</sub> B/nA <sub>1</sub> B C <sub>1</sub> B/nC <sub>1</sub> B NP <sub>1.5</sub> B	A <sub>2</sub> B/nA <sub>2</sub> B C <sub>2</sub> B/nC <sub>2</sub> B NP <sub>2.5</sub> B	A <sub>3</sub> B/nA <sub>3</sub> B C <sub>3</sub> B/nC <sub>3</sub> B NW <sub>0</sub> B	A <sub>3.5</sub> B/nA <sub>3.5</sub> B C <sub>4</sub> B/nC <sub>4</sub> B NW <sub>0.5</sub> B	A <sub>4</sub> B/nA <sub>4</sub> B D <sub>2</sub> B/nD <sub>2</sub> B EW <sub>0</sub> B	B <sub>1</sub> B/nB <sub>1</sub> B D <sub>3</sub> B/nD <sub>3</sub> B EW <sub>0</sub> B	B <sub>2</sub> B/nB <sub>2</sub> B D <sub>4</sub> B/nD <sub>4</sub> B EWB	B <sub>3</sub> B/nB <sub>3</sub> B — EWYB	B <sub>4</sub> B/nB <sub>4</sub> B — —
Enamel	10,50,200g	E <sub>1</sub>	E <sub>2</sub>	E <sub>3</sub>	Silky E <sub>1</sub>	Silky E <sub>2</sub>	—	—	—	—
Speed Enamel	10,50,200g	S <sub>1</sub>	S <sub>2</sub>	S <sub>3</sub>	S <sub>4</sub>	—	—	—	—	—
Margin	10,50g	MA <sub>1</sub> MC <sub>2</sub>	MA <sub>2</sub> MC <sub>4</sub>	MA <sub>3</sub> MD <sub>3</sub>	MA <sub>3.5</sub> MD <sub>4</sub>	MA <sub>4</sub> MNP <sub>1.5</sub>	MB <sub>1</sub> MNP <sub>2.5</sub>	MB <sub>2</sub> MNW <sub>0</sub>	MB <sub>3</sub> MNW <sub>0.5</sub>	MB <sub>4</sub> —
Margin Modifier	10,50g	M Clear	M Peach	M Orange	—	—	—	—	—	—
Margin Retouching	10,50g	MRP	—	—	—	—	—	—	—	—
Margin Dilution	10,50g	MDL	—	—	—	—	—	—	—	—
Opacious Body	10,50,200g	OBA <sub>1</sub> OBC <sub>1</sub> OB Enamel	OBA <sub>2</sub> OBC <sub>2</sub> OB White	OBA <sub>3</sub> OBC <sub>3</sub> OB Orange	OBA <sub>3.5</sub> OBC <sub>4</sub> OB Pale Pink	OBA <sub>4</sub> OBD <sub>2</sub> —	OBB <sub>1</sub> OBD <sub>3</sub> —	OBB <sub>2</sub> OBD <sub>4</sub> —	OBB <sub>3</sub> OBNP <sub>1.5</sub> —	OBB <sub>4</sub> OBNP <sub>2.5</sub> —
Cervical	10,50,200g	CV-1	CV-2	CV-3	CV-4	—	—	—	—	—
Mamelon	10,50g	Mamelon 1	Mamelon 2	—	—	—	—	—	—	—
Translucent	10,50,200g	Tx	T <sub>0</sub>	T <sub>1</sub>	T <sub>2</sub>	—	—	—	—	—
Luster	10,50,200g	LTo LT Natural	LT <sub>1</sub> LT Super Gray	T Blue LT Yellow	Aqua Blue 1 ELT <sub>1</sub>	Aqua Blue 2 ELT <sub>2</sub>	Creamy Enamel ELT <sub>3</sub>	Sun Bright	Incisal Aureola	Creamy White
Clear Cervical	10,50,200g	CCV-1	CCV-2	CCV-3	CCV-4	—	—	—	—	—
Modifier	10,50g	White Dark Pink	Gray Coral Pink	Blue	Green	Yellow	Light Orange	Orange	Brown	Pink
Tissue	10,50g	Tissue 1	Tissue 2	Tissue 3	Tissue 4	Tissue 5	Tissue 6	Tissue 7	—	—
Add-on	10,50g	AD-T	AD-B	—	—	—	—	—	—	—
External Stain	3g 10,30g	Gray Cervical 2 B+	Black Cervical 3 C+	Blue Earth Brown D+	Green 1 Reddish Brown	Green 2 Pure White	Yellow Pink	Orange 1 Salmon Pink	Orange 2 Red	Cervical 1 A+
Internal Stain	3g	Incisal Blue 1 White Gray	Incisal Blue 2 Red	Mamelon Orange 1 Salmon Pink	Mamelon Orange 2 A+	Reddish Brown B+	Earth Brown C+	Cervical 1 D+	Cervical 2 Bright	Cervical 3 Fluoro
Addmate	10g	Light Opaque	Dark Opaque	Light Body	Dark Body	Enamel	Translucent	Luster Translucent	—	—

## 3 BASIC LAYER BUILD-UP



## 2 LAYER BUILD-UP with SPEED ENAMEL



*Noritake*



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# Baking Schedule

	Dry-out time	Low Temperature		Start Vacuum		Heat Rate		Vacuum Level	Release Vacuum		Hold Time	High Temperature		Cool Time
	min.	°C	°F	°C	°F	°C/min.	°F/min.	kPa *1	°C	°F	min.	°C	°F	min.
POBA	8	500	932	500	932	65	117	96	1000	1832	1 (with vacuum)	1000	1832	0
Paste Opaque 1 <sup>st</sup> and 2 <sup>nd</sup>	8	500	932	500	932	65	117	96	980	1796	1 (without vacuum)	980	1796	0
Universal Paste Opaque 1 <sup>st</sup> and 2 <sup>nd</sup> (High Noble, Noble, Ni-Cr w/Be alloys)	8	400	752	400	752	65	117	96	980	1796	1 (without vacuum)	980	1796	0
Universal Paste Opaque 1 <sup>st</sup> and 2 <sup>nd</sup> (Ni-Cr w/out Be, Co-Cr alloys)	8	400	752	400	752	65	117	96	1000	1832	1 (without vacuum)	1000	1832	0
Powder Opaque 1 <sup>st</sup>	3	650	1202	650	1202	55	99	96	950	1742	0 *4	960	1760	0
Powder Opaque 2 <sup>nd</sup>	5	650	1202	650	1202	55	99	96	950	1742	0 *4	960	1760	0
Margin Porcelain 1 <sup>st</sup> and 2 <sup>nd</sup>	5	650	1202	650	1202	55	99	96	935	1715	0	945	1733	0
Body / Enamel / S.Enamel / Translucent (1-3 units)	7	600	1112	600	1112	45	81	96	920	1688	0	930	1706	0
Body / Enamel / S.Enamel / Translucent (4-6 units)	10	600	1112	600	1112	45	81	96	925	1696	0	935	1715	0
Body / Enamel / S.Enamel / Translucent (over 7 units)	15	600	1112	600	1112	45	81	96	930	1706	0	940	1724	0
Body (Minor Adjustments)	7	600	1112	600	1112	45	81	96	910	1670	0	920	1688	0
Internal Stain 1 <sup>st</sup> and 2 <sup>nd</sup>	3	650	1202	—	—	55	99	0	—	—	0	830 *2	1526 *2	0
Self Glaze only	5	650	1202	—	—	50	90	0	—	—	0	930 *3	1706 *3	0
Self Glaze with after-polishing	5	650	1202	—	—	50	90	0	—	—	0	890	1634	0
External Stain / Glaze powder	5	650	1202	—	—	50	90	0	—	—	0	910	1670	0
MRP	5	650	1202	—	—	55	99	0	—	—	0	850	1562	0
Add-on	5	650	1202	—	—	55	99	0	—	—	0	880	1616	0
Addmate (Minor adjustments)	5	450	842	450	842	45	81	96	690	1274	0	700	1292	0
Degassing for NORI-VEST (Using a burnout furnace only)	0	300	572	—	—	30	54	0	—	—	20	1080	1976	0
Wash bake for Refractory	10	600	1112	600	1112	45	81	96	940	1724	0	950	1742	4
Body for Refractory	10	600	1112	600	1112	45	81	96	940	1724	0	950	1742	4
Glaze for Refractory	10	600	1112	—	—	45	81	0	—	—	0	950	1742	4

**Note** The above program is only a guideline. Baking temperature may be varied with the peculiarities of different furnace.  
 \*1 96kPa = 72cmHg (29 inchesHg) \*2 This case is for 1-3 units. Set the high temperature the same as Body baking. \*3 This case is for 1-3 units. Reduce 40°C (72°F) from the high temperature of Body baking.  
 \*4 1min. holding-time might be necessary depending on the peculiarities of different furnace.

# Color Combination Table

	A <sub>1</sub>		A <sub>2</sub>		A <sub>3</sub>		A <sub>3.5</sub>		A <sub>4</sub>		B <sub>1</sub>		B <sub>2</sub>		B <sub>3</sub>		B <sub>4</sub>		C <sub>1</sub>		C <sub>2</sub>		C <sub>3</sub>		C <sub>4</sub>	
Paste Opaque	POA <sub>1</sub>	P0nA <sub>1</sub>	POA <sub>2</sub>	P0nA <sub>2</sub>	POA <sub>3</sub>	P0nA <sub>3</sub>	POA <sub>3.5</sub>	P0nA <sub>3.5</sub>	POA <sub>4</sub>	P0nA <sub>4</sub>	POB <sub>1</sub>	P0nB <sub>1</sub>	POB <sub>2</sub>	P0nB <sub>2</sub>	POB <sub>3</sub>	P0nB <sub>3</sub>	POB <sub>4</sub>	P0nB <sub>4</sub>	POC <sub>1</sub>	P0nC <sub>1</sub>	POC <sub>2</sub>	P0nC <sub>2</sub>	POC <sub>3</sub>	P0nC <sub>3</sub>	POC <sub>4</sub>	P0nC <sub>4</sub>
Universal Paste Opaque	UPnA <sub>1</sub>		UPnA <sub>2</sub>		UPnA <sub>3</sub>		UPnA <sub>3.5</sub>		UPnA <sub>4</sub>		UPnB <sub>1</sub>		UPnB <sub>2</sub>		UPnB <sub>3</sub>		UPnB <sub>4</sub>		UPnC <sub>1</sub>		UPnC <sub>2</sub>		UPnC <sub>3</sub>		UPnC <sub>4</sub>	
Powder Opaque	A <sub>1</sub> 0	nA <sub>1</sub> 0	A <sub>2</sub> 0	nA <sub>2</sub> 0	A <sub>3</sub> 0	nA <sub>3</sub> 0	A <sub>3.5</sub> 0	nA <sub>3.5</sub> 0	A <sub>4</sub> 0	nA <sub>4</sub> 0	B <sub>1</sub> 0	nB <sub>1</sub> 0	B <sub>2</sub> 0	nB <sub>2</sub> 0	B <sub>3</sub> 0	nB <sub>3</sub> 0	B <sub>4</sub> 0	nB <sub>4</sub> 0	C <sub>1</sub> 0	nC <sub>1</sub> 0	C <sub>2</sub> 0	nC <sub>2</sub> 0	C <sub>3</sub> 0	nC <sub>3</sub> 0	C <sub>4</sub> 0	nC <sub>4</sub> 0
Margin	MA <sub>1</sub>		MA <sub>2</sub>		MA <sub>3</sub>		MA <sub>3.5</sub>		MA <sub>4</sub>		MB <sub>1</sub>		MB <sub>2</sub>		MB <sub>3</sub>		MB <sub>4</sub>		MC <sub>2</sub> +MDL (1+1)		MC <sub>2</sub>		MC <sub>4</sub> +MDL (1+1)		MC <sub>4</sub>	
Opacious Body	OBA <sub>1</sub>		OBA <sub>2</sub>		OBA <sub>3</sub>		OBA <sub>3.5</sub>		OBA <sub>4</sub>		OB <sub>B</sub> <sub>1</sub>		OB <sub>B</sub> <sub>2</sub>		OB <sub>B</sub> <sub>3</sub>		OB <sub>B</sub> <sub>4</sub>		OBC <sub>1</sub>		OBC <sub>2</sub>		OBC <sub>3</sub>		OBC <sub>4</sub>	
Body	A <sub>1</sub> B	nA <sub>1</sub> B	A <sub>2</sub> B	nA <sub>2</sub> B	A <sub>3</sub> B	nA <sub>3</sub> B	A <sub>3.5</sub> B	nA <sub>3.5</sub> B	A <sub>4</sub> B	nA <sub>4</sub> B	B <sub>1</sub> B	nB <sub>1</sub> B	B <sub>2</sub> B	nB <sub>2</sub> B	B <sub>3</sub> B	nB <sub>3</sub> B	B <sub>4</sub> B	nB <sub>4</sub> B	C <sub>1</sub> B	nC <sub>1</sub> B	C <sub>2</sub> B	nC <sub>2</sub> B	C <sub>3</sub> B	nC <sub>3</sub> B	C <sub>4</sub> B	nC <sub>4</sub> B
Cervical	—		A <sub>2</sub> B+CV-1 (2+1)		A <sub>3</sub> B+CV-1 (1+1)		A <sub>3.5</sub> B+CV-1 (1+1)		CV-1		—		B <sub>2</sub> B+CV-2 (2+1)		B <sub>3</sub> B+CV-2 (1+1)		CV-2		—		C <sub>2</sub> B+CV-3 (2+1)		C <sub>3</sub> B+CV-3 (1+1)		CV-3	
Enamel	E <sub>2</sub>		E <sub>2</sub>		E <sub>3</sub>		E <sub>3</sub>		E <sub>3</sub>		E <sub>1</sub>		E <sub>2</sub>		E <sub>3</sub>		E <sub>3</sub>		E <sub>2</sub>		E <sub>3</sub>		E <sub>3</sub>		E <sub>3</sub>	
Speed Enamel	S <sub>2</sub>		S <sub>3</sub>		S <sub>3</sub>		S <sub>3</sub>		S <sub>4</sub>		S <sub>1</sub>		S <sub>3</sub>		S <sub>3</sub>		S <sub>4</sub>		S <sub>3</sub>		S <sub>3</sub>		S <sub>3</sub>		S <sub>4</sub>	
Luster (Translucent)	LT <sub>1</sub> (T <sub>1</sub> )										LT <sub>1</sub> (T <sub>1</sub> )															

	D <sub>2</sub>		D <sub>3</sub>		D <sub>4</sub>		NP <sub>1.5</sub>		NP <sub>2.5</sub>		NW <sub>0</sub>		NW <sub>0.5</sub>		EW <sub>00</sub>		EW <sub>0</sub>		EW		EWY	
Paste Opaque	POD <sub>2</sub>	P0nD <sub>2</sub>	POD <sub>3</sub>	P0nD <sub>3</sub>	POD <sub>4</sub>	P0nD <sub>4</sub>	PONP <sub>1.5</sub>		PONP <sub>2.5</sub>		PONW <sub>0</sub>		PONW <sub>0.5</sub>		POEW <sub>0</sub>		POEW <sub>0</sub>		POEW		POEW	
Universal Paste Opaque	UPnD <sub>2</sub>		UPnD <sub>3</sub>		UPnD <sub>4</sub>		UPNP <sub>1.5</sub>		UPNP <sub>2.5</sub>		UPNW <sub>0</sub>		UPNW <sub>0.5</sub>		UPEW <sub>0</sub>		UPEW <sub>0</sub>		UPEW		UPEW	
Powder Opaque	D <sub>2</sub> 0	nD <sub>2</sub> 0	D <sub>3</sub> 0	nD <sub>3</sub> 0	D <sub>4</sub> 0	nD <sub>4</sub> 0	NP <sub>1.5</sub> 0		NP <sub>2.5</sub> 0		NW <sub>0</sub> 0		NW <sub>0.5</sub> 0		EW <sub>0</sub> 0		EW <sub>0</sub> 0		EWO		EWO	
Margin	MD <sub>3</sub> +MDL (1+1)		MD <sub>3</sub>		MD <sub>4</sub>		MNP <sub>1.5</sub>		MNP <sub>2.5</sub>		MNW <sub>0</sub>		MNW <sub>0.5</sub>		MDL		MDL		MNW <sub>0</sub> +MDL (1+1)		MNW <sub>0</sub> +MDL (2+1)	
Opacious Body	OBD <sub>2</sub>		OBD <sub>3</sub>		OBD <sub>4</sub>		OBNP <sub>1.5</sub>		OBNP <sub>2.5</sub>		—		—		—		—		—		—	
Body	D <sub>2</sub> B	nD <sub>2</sub> B	D <sub>3</sub> B	nD <sub>3</sub> B	D <sub>4</sub> B	nD <sub>4</sub> B	NP <sub>1.5</sub> B		NP <sub>2.5</sub> B		NW <sub>0</sub> B		NW <sub>0.5</sub> B		EW <sub>00</sub> B		EW <sub>0</sub> B		EW B		EWY B	
Cervical	D <sub>2</sub> B+CV-4 (2+1)		D <sub>3</sub> B+CV-4 (1+1)		CV-4		—		NP <sub>2.5</sub> B+CV-1 (2+1)		—		—		—		—		—		—	
Enamel	E <sub>2</sub>		E <sub>3</sub>		E <sub>3</sub>		E <sub>2</sub>		E <sub>2</sub>		Silky E <sub>2</sub>		Silky E <sub>2</sub>		Silky E <sub>1</sub>		Silky E <sub>1</sub>		Silky E <sub>2</sub>		Silky E <sub>2</sub>	
Speed Enamel	S <sub>3</sub>		S <sub>3</sub>		S <sub>4</sub>		S <sub>2</sub>		S <sub>3</sub>		S <sub>1</sub>		S <sub>1</sub>		Silky E <sub>1</sub>		Silky E <sub>1</sub>		Silky E <sub>2</sub>		Silky E <sub>2</sub>	
Luster (Translucent)	LT <sub>1</sub> (T <sub>1</sub> )						LT <sub>1</sub> (T <sub>1</sub> )						ELT <sub>2</sub>				ELT <sub>1</sub>					