

Setting Parameters

cara CAD for cara production service

As of 09.2018

Important Information:

- Observe the Processing Guides of the materials.

Software Setting Options (all figures in mm):

cara C&B Zr high translucent esthetic – A1, A2, A3, A3.5, B1, B2, B3, C2, D3

Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.01	0.02 – 0.04	1.0	0.3 – 0.4	0.3	75 – 100°	–	1.2
3-unit-Bridge	0.01	0.04 – 0.05	1.0	0.4 – 0.5	0.3	70 – 90°	7 – 9	1.2
Inlays/Onlays	0.03	0.04 – 0.05	0.5 – 1.0	0.3 – 0.4	≥ 0.3	75 – 100°	–	1.2

Zr HTE

cara C&B Zr high translucent – A1, A2, A3, A3.5, B1, B2, B3, C2, D3

Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.01	0.02 – 0.04	1.0	0.3 – 0.4	0.3	75 – 100°	–	1.2
3 – 4-unit-Bridge	0.01	0.04 – 0.05	1.0	0.4 – 0.5	0.3	70 – 90°	7 – 9	1.2
5-unit-Bridge	0.02	0.06 – 0.07	1.0	0.5	0.3	70 – 90°	8 – 9	1.2
6 – 16-unit-Bridge	0.02	0.07 – 0.08	1.0	0.6	0.3	65 – 90°	≥ 9	1.2
Inlays/Onlays	0.03	0.04 – 0.05	0.5 – 1.0	0.3 – 0.4	≥ 0.3	75 – 100°	–	1.2

Zr HT

cara C&B Zr – white, B-light and A-intensive

Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.010	0.020 – 0.040	1.0	0.3 – 0.4	0.2	75 – 100°	–	1.0
3 – 4-unit-Bridge	0.010	0.040 – 0.050	1.0	0.4 – 0.5	0.2	70 – 90°	7 – 9	1.0
5-unit-Bridge	0.015	0.040 – 0.060	1.0	0.5	0.2	70 – 90°	8 – 9	1.0
6 – 16-unit-Bridge	0.015	0.060 – 0.085	1.0	0.6	0.2	65 – 90°	≥ 9	1.0
Inlays/Onlays	0.030	0.040 – 0.050	0.5 – 1.0	0.3 – 0.4	≥ 0.2	75 – 100°	–	1.0

Zr ST

Giving a hand to oral health.


KULZER
 MITSUI CHEMICALS GROUP

cara C&B Zr translucent – white WS and B-medium WS

Zr_{tr}

Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.010	0.020 – 0.040	1.0	0.3 – 0.4	0.3	75 – 100°	–	1.2
3 – 4-unit-Bridge	0.010	0.040 – 0.050	1.0	0.4 – 0.5	0.3	70 – 90°	7 – 9	1.2
5-unit-Bridge	0.015	0.040 – 0.060	1.0	0.5	0.3	70 – 90°	8 – 9	1.2
6 – 7-unit-Bridge	0.015	0.060 – 0.085	1.0	0.6	0.3	65 – 90°	≥ 9	1.2
Inlays/Onlays	0.030	0.040 – 0.050	0.5 – 1.0	0.3 – 0.4	≥ 0.3	75 – 100°	–	1.2

cara C&B Zr translucent – light, medium and intensive

Zr_{tr}

Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.01	0.02 – 0.04	1.0	0.3 – 0.4	0.3	75 – 100°	–	1.2
3 – 4-unit-Bridge	0.01	0.04 – 0.05	1.0	0.4 – 0.5	0.3	70 – 90°	7 – 9	1.2
5-unit-Bridge	0.02	0.06 – 0.07	1.0	0.5	0.3	70 – 90°	8 – 9	1.2
6 – 7-unit-Bridge	0.02	0.07 – 0.08	1.0	0.6	0.3	65 – 90°	≥ 9	1.2
Inlays/Onlays	0.03	0.04 – 0.05	0.5 – 1.0	0.3 – 0.4	≥ 0.3	75 – 100°	–	1.2

cara C&B Zr multilayer – Shade A, Shade B and Shade C

Zr_{ML}

Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.010	0.020 – 0.040	1.0	0.4	0.3	75 – 100°	–	1.2
3 – 4-unit-Bridge	0.010	0.040 – 0.050	1.0	0.5	0.3	70 – 90°	7 – 9	1.2
5-unit-Bridge	0.015	0.040 – 0.060	1.0	0.5	0.3	70 – 90°	8 – 9	1.2
6 – 7-unit-Bridge	0.015	0.060 – 0.085	1.0	0.6	0.3	65 – 90°	≥ 9	1.2
Inlays/Onlays	0.030	0.040 – 0.050	0.5 – 1.0	0.3 – 0.4	≥ 0.3	75 – 100°	–	1.2

cara C&B Lithium Disilicate (Made of well-proven IPS e.max® CAD blanks by Ivoclar Vivadent)

LiSi₂*

Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown Anterior tooth	0.005	0.03	1.5 – 3.0	See table with minimum wall thickness	0.4	75 – 100°	–	1.2
Premolar	0.005	0.03	1.5 – 3.0		0.4	75 – 100°	–	1.2
Molar	0.005	0.03	1.5 – 3.0		0.4	75 – 100°	–	1.2
Minimum wall thickness cara LiSi₂*			Anterior tooth	Premolar		Molar		
Staining technique	Circular		1.2	1.5		1.5		
	Incisal/Occlusal		1.5	1.5		1.5		
Cutback technique (after reduction)	Circular		1.2	1.5		1.5		
	Incisal/Occlusal		0.4	1.0		1.3		

* cara LiSi₂ frames are made of well-proven IPS e.max® CAD blanks by Ivoclar Vivadent.

Important: Avoid sharp edges and highly tapered margins. To avoid margin chipping, edge thicknesses and minimum wall thicknesses must be observed during construction. Always observe the general guidelines for all-ceramic preparations! Bear in mind the dimensions of cara LiSi₂* blanks! Width: 12 mm and Height: 14 mm

Contra-indications:

- Very deep subgingival preparations
- Patients with severely reduced residual dentition/bruxism
- All other applications not listed as indications

cara C&B CoCr SLM/SLM anatomic*



Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.025	0.115	1.5	0.4	0.18	75°	–	1.0
3 – 4-unit-Bridge	0.035	0.12	1.5	0.4	0.18 – 0.20	75°	5 – 7	1.0
5-unit-Bridge	0.035	0.12	1.5	0.4	0.20	75°	≥ 7	1.0
6 – 16-unit-Bridge	0.035	0.12	1.5	0.5	0.20	75°	≥ 8	1.0

cara C&B CoCr milled



Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.017 – 0.025	0.065 – 0.095	1.0	0.35	0.1	65 – 100°	–	1.0
3 – 4-unit-Bridge	0.017 – 0.025	0.065 – 0.095	1.0	0.35	0.1	70 – 90°	5 – 6	1.0
5-unit-Bridge	0.017 – 0.025	0.065 – 0.095	1.0	0.40	0.1	70 – 90°	6 – 7	1.0
6 – 16-unit-Bridge	0.017 – 0.025	0.075 – 0.100	1.0	0.40	0.1	70 – 90°	> 7	1.0

cara Temp PMMA



Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.010	0.02	1.0	0.6 – 1.2	0.2	70 – 90°	–	1.0
3 – 4-unit-Bridge	0.010	0.040	1.0	0.6 – 1.2	0.2	70 – 90°	10 – 16	1.0
5-unit-Bridge	0.015	0.050 – 0.060	1.0	0.6 – 1.2	0.2	70 – 90°	10 – 16	1.0
6 – 16-unit-Bridge	0.015	0.060 – 0.070	1.0	0.6 – 1.2	0.2	65 – 90°	≥ 16	1.0

cara Cast PMMA



Elements	Friktion Area Gap	Cement gap	Transition Area Width	Minimum thickness	Margin thickness	Margin Angle	Connector thickness in mm ²	Milling Tool Diameter
Crown	0.010	0.02	1.0	0.6 – 1.2	0.2	70°	–	1.0
3 – 4-unit-Bridge	0.010	0.04 – 0.05	1.0	0.6 – 1.2	0.2	70 – 90°	10 – 16	1.0
5-unit-Bridge	0.015	0.06	1.0	0.6 – 1.2	0.2	70 – 90°	10 – 16	1.0
6 – 16-unit-Bridge	0.015	0.07	1.0	0.6 – 1.2	0.2	65 – 90°	≥ 16	1.0

The general safety regulations for handling dental products are applicable.

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