

Super Porcelain
EX-3

Noritake Super Porcelain EX-3



Paste Opaque - NP Bonder -

NP Bonder has been added to Noritake Super Porcelain EX-3 Paste Opaque. This is a reliable metal bonder optimized to make a secure bond between porcelain and metal frameworks made of non-precious alloys*.



Optimized to make a secure bond between porcelain and metal frameworks made of non-precious*

* Non-precious alloys such as Co-Cr alloy and Ni-Cr alloy, and semi-precious alloys containing 75 - 85 percent palladium that also contain copper.

- High bond strength to non-precious alloys*
- Capable of reducing the black lines that can occur at the margins of metal frameworks
- Effective at reducing the likelihood of yellow or green discoloration of the porcelain after baking.

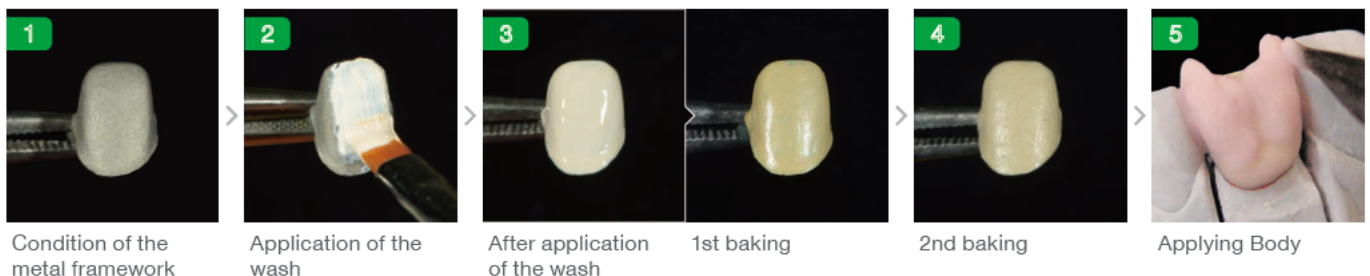
Procedure Overview¹⁾

When used over a metal framework

- 1 Condition the metal framework according to the Instructions for Use supplied with the alloy products.
- 2 Apply a thin coat of NP Bonder across the entire dry surface of the metal framework and rub it in.
- 3 Apply NP Bonder until about 70 percent of the metal is masked and then bake the paste.
- 4 After baking, apply²⁾ another coat of the target shade of Paste Opaque, Paste Opaque Modifier, or a mixture of the two. Mask the metal completely and bake the paste for a second time.
- 5 Apply²⁾ Body and other types of porcelain.

1) For detailed information, see the Instructions for Use supplied with "Noritake Super Porcelain EX-3".

2) Before applying any porcelain, make sure to clean the metal framework in water using an ultrasonic cleaner or steam clean both the outer and inner surfaces of the metal framework before drying with compressed air.



Baking schedule

The baking schedule is the same as that used for other Paste Opaque porcelains.

Dry-out time (min)	Predrying Temperature (°C/F°)	Start Vacuum (°C/F°)	Heate rate (°C/F°)/min	Vacuum Level (kPa/cmHg/ inchesHg)	Release Vacuum (°C/F°)	High Temperature (°C/F°)	Hold Time (in the air) (min)	Cool Time (min)
8	500/932	500/932	65/117	96/72/29	980/1796	980/1796	1	0



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- Before using this product, be sure to read the Instructions for Use supplied with the product.
- The specifications and appearance of the product are subject to change without notice.
- Printed color can be slightly different from actual color.