

Setting Parameters

exocad  for cara production service

As of 09.2018

Important Information:

- Before sending, be sure to select the setting “always optimize for selective laser melting”.
- Observe the Processing Guides of the materials.
- The given dimensions serve as guidelines and may be customized according to individual wishes.

Software Setting Options (all figures in mm):

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



Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Cross section of connector	Diameter
Crown	0.02	0.01	1	0.3 – 0.4	0.3	75 – 100°	0.15	–	1.2
3-unit-Bridge	0.03	0.02	1	0.4 – 0.5	0.3	70 – 90°	0.15	≥ 7 – 9	1.2
Primary Telescope	0.02	0.01	1	0.4	0.3	45 – 80°	0.20	–	1.2
Setting parameters Inlays/Onlays/Veneers									
Inlays/Onlays/Veneers	Gap thickness of cement	Additional spacing	Margin width	Beginning of cement gap	Diameter				
	0.04	0.03	≥ 0.3	1	1.2				

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



Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Cross section of connector	Diameter
Crown	0.02	0.01	1	0.3 – 0.4	0.3	75 – 100°	0.15	–	1.2
3 – 4-unit-Bridge	0.03	0.02	1	0.4 – 0.5	0.3	70 – 90°	0.15	≥ 7 – 9	1.2
5-unit-Bridge	0.05	0.03	1	0.5	0.3	70 – 90°	0.15	≥ 8 – 9	1.2
6 – 16-unit-Bridge	0.07	0.04	1	0.6	0.3	70 – 90°	0.15	≥ 9	1.2
Primary Telescope	0.02	0.01	1	0.4	0.3	45 – 80°	0.20	–	1.2
Setting parameters Inlays/Onlays/Veneers									
Inlays/Onlays/Veneers	Gap thickness of cement	Additional spacing	Margin width	Beginning of cement gap	Diameter				
	0.04	0.03	≥ 0.3	1	1.2				

Giving a hand to oral health.



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

ZrST

Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Cross section of connector	Diameter
Crown	0.01	0.010	1	0.3 – 0.4	0.2	75 – 100°	0.15	–	1.2
3 – 4-unit-Bridge	0.02	0.010	1	0.4 – 0.5	0.2	70 – 90°	0.15	≥ 7 – 9	1.2
5-unit-Bridge	0.02	0.015	1	0.5	0.2	70 – 90°	0.15	≥ 8 – 9	1.2
6 – 16-unit-Bridge	0.03	0.015	1	0.6	0.2	70 – 90°	0.15	≥ 9	1.2
Primary Telescope	0.01	0.010	1	0.4	0.2	45 – 80°	0.20	–	1.2
Setting parameters Inlays/Onlays/Veneers									
Inlays/Onlays/Veneers	Gap thickness of cement	Additional spacing	Margin width	Beginning of cement gap	Diameter				
	0.04	0.03	≥ 0.2	1	1.2				

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

Zr^{tr}

Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Cross section of connector	Diameter
Crown	0.01	0.010	1	0.3 – 0.4	0.3	75 – 100°	0.15	–	1.2
3 – 4-unit-Bridge	0.02	0.010	1	0.4 – 0.5	0.3	70 – 90°	0.15	≥ 7 – 9	1.2
5-unit-Bridge	0.02	0.015	1	0.5	0.3	70 – 90°	0.15	≥ 8 – 9	1.2
6 – 7-unit-Bridge	0.03	0.015	1	0.6	0.3	70 – 90°	0.15	≥ 9	1.2
Primary Telescope	0.01	0.010	1	0.4	0.3	45 – 80°	0.20	–	1.2
Setting parameters Inlays/Onlays/Veneers									
Inlays/Onlays/Veneers	Gap thickness of cement	Additional spacing	Margin width	Beginning of cement gap	Diameter				
	0.04	0.03	≥ 0.3	1	1.2				

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

Zr^{tr}

Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Cross section of connector	Diameter
Crown	0.02	0.01	1	0.3 – 0.4	0.3	75 – 100°	0.15	–	1.2
3 – 4-unit-Bridge	0.03	0.02	1	0.4 – 0.5	0.3	70 – 90°	0.15	≥ 7 – 9	1.2
5-unit-Bridge	0.05	0.03	1	0.5	0.3	70 – 90°	0.15	≥ 8 – 9	1.2
6 – 7-unit-Bridge	0.07	0.04	1	0.6	0.3	70 – 90°	0.15	≥ 9	1.2
Primary Telescope	0.02	0.01	1	0.4	0.3	45 – 80°	0.20	–	1.2
Setting parameters Inlays/Onlays/Veneers									
Inlays/Onlays/Veneers	Gap thickness of cement	Additional spacing	Margin width	Beginning of cement gap	Diameter				
	0.04	0.03	≥ 0.3	1	1.2				

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

Zr^{ML}

Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Cross section of connector	Diameter
Crown	0.02	0.010	1	0.4	0.3	75 – 100°	0.20	–	1.2
3 – 4-unit-Bridge	0.03	0.020	1	0.5	0.3	70 – 90°	0.20	≥ 7 – 9	1.2
5-unit-Bridge	0.02	0.015	1	0.5	0.3	70 – 90°	0.15	≥ 8 – 9	1.2
6 – 7-unit-Bridge	0.03	0.015	1	0.6	0.3	70 – 90°	0.15	≥ 9	1.2
Setting parameters Inlays/Onlays/Veneers									
Inlays/Onlays/Veneers	Gap thickness of cement	Additional spacing	Margin width	Beginning of cement gap	Diameter				
	0.04	0.03	≥ 0.3	1	1.2				



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

Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Diameter
Crown Anterior tooth	0.03	0.005	1.5 – 3.0	See table with minimum wall thickness	0.4	75 – 100°	0.2	1.4
Premolar	0.03	0.005	1.5 – 3.0		0.4	75 – 100°	0.2	1.4
Molar	0.03	0.005	1.5 – 3.0		0.4	75 – 100°	0.2	1.4
Minimum wall thickness cara LiSi ₂ *			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	
	Labial/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+



Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Cross section of connector	Diameter
Crown	0.085	0.03	1	0.40	0.18	75°	0.1	–	–
3 – 4-unit-Bridge	0.090	0.04	1	0.40	0.20	75°	0.1	≥ 6	–
5-unit-Bridge	0.150	0.05	1	0.40	0.20	75°	0.1	≥ 7	–
6 – 16-unit-Bridge	0.150	0.05	1	0.40	0.20	75°	0.1	≥ 8	–
Primary Telescope**	0.085	0.03	1	0.45	0.18	75°	0.1	–	–

** Primary telescopes are not available in SLM anatomic+.

cara C&B CoCr milled



Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Cross section of connector	Diameter
Crown	0.03	0.01	1	0.35	0.1	65 – 100°	0.1	–	1.2
3 – 4-unit-Bridge	0.04	0.01	1	0.35	0.1	70 – 90°	0.1	≥ 5 – 6	1.2
5-unit-Bridge	0.04	0.01	1	0.40	0.1	70 – 90°	0.1	≥ 6 – 7	1.2
6 – 16-unit-Bridge	0.04	0.01	1	0.40	0.1	70 – 90°	0.1	≥ 7	1.2
Primary Telescope	0.03	0.01	1	0.40	0.1	40 – 85°	0.1	–	1.2

cara Temp PMMA, cara Cast PMMA



Indications	Gap thickness of cement	Add. Distance X/Y	Beginning of cement gap	Minimal thickness	Horizontal crown margin	Angle	Angled crown margin	Cross section of connector	Diameter
Crown	0.01	0	1	0.6 – 1.2	0.2	75 – 100°	0.15	–	1.2
3 – 4-unit-Bridge	0.01	0	1	0.6 – 1.2	0.2	70 – 90°	0.15	≥ 10 – 16	1.2
5-unit-Bridge	0.01	0.01	1	0.6 – 1.2	0.2	70 – 90°	0.15	≥ 10 – 16	1.2
6 – 16-unit-Bridge	0.02	0.01	1	0.6 – 1.2	0.2	70 – 90°	0.15	≥ 16	1.2
Primary Telescope	0.01	0	1	0.6 – 1.2	0.2	45 – 80°	0.20	–	1.2

The general safety regulations for handling dental products are applicable.

Contact in Germany
 Kulzer GmbH
 Leipziger Straße 2
 63450 Hanau, Germany
 cara-service@kulzer-dental.com