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Method for Molding Dental Restorations and Related Apparatus
Related Applications

This application is a continuation in part application of application S.N. 08/250,926 Filed May 31, 1994]

Field of the Invention

The present invention relates to a process for the molding of metal free dental restorations such as crowns, bridges, inlays, onlays etc. from glass-ceramic materials. The invention is also concerned with apparatus which permits dental restorations to be easily molded from glass-ceramic materials and lastly, the invention relates to the resulting dental restorations.

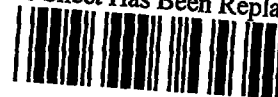
Background of the Invention

In the prior art various methods have been used to form metal free dental restorations from glass-ceramic materials. Glass-ceramic materials because of their strength, translucency, non-toxicity and other physical properties are ideal materials for use in forming dental restorations. Because of their suitability, glass-ceramic materials have been used to form dental restorations for at least eighty years. In the prior art the most widely used means for forming dental restorations from mixtures of glass and ceramic materials is a process which utilizes a slurry of glass and ceramic particles. In this process a die is formed which is an exact replica of the remaining portion of the tooth to which the restoration is to be secured. It is understood by one skilled in



the art that the remaining portion of the tooth has been prepared by the dentist in such a manner that the attachment of the restoration is facilitated. To start the process the dentist takes an impression of the prepared tooth to create a negative impression of the prepared tooth or teeth. This negative impression is then packed with a material to form a positive impression of the prepared tooth or teeth. This positive impression is called a die. Platinum foil is then pressed over the die to form a matrix which is essentially a foundation on which the dental restoration is built. In order to form up the dental restoration many layers of a slurry of a particulate glass-ceramic material are applied to the platinum foil matrix. As multiple layers of the slurry are built up and dried a semi-solid structure is formed which can be carved into the shape of the desired dental restoration. Once the desired shape is achieved the structure is then removed from the die. At this stage the structure is referred to as a green structure. The structure is then fired, during the firing process the particulate glass-ceramic material fuses into a solid mass. Because the green structure is formed from multiple layers of the dried glass-ceramic material uneven fusing may result. As a result of this uneven fusing the physical properties of the finished restoration may be detrimentally affected. As a result an inferior dental restoration results. Further, as can be seen from the above description, the overall process is very labor intensive.

Other methods for forming the green restoration have been considered in the prior art, for example, in U.S. Patent no



2,196,258, a mixture of particulate glass and ceramic materials which incorporates a binder is packed into a flexible mold to form a green structure which is then fired to form a finished structure. Again, because the process entails the fusing of particulate material, uneven fusing may result and hence a weakened and inferior dental restoration may result.

To overcome the problems as described above the trade has recognized that in order to produce strong, translucent metal free dental restorations it would be desirable to form these restorations directly from a homogenous molten glass-ceramic material. It was realized that it may be possible to produce a satisfactory restoration by forcing a molten or plastic glass-ceramic material into a mold having a cavity in the form of the desired dental restoration. The prior art further recognized that the glass-ceramic material could be introduced into the cavity when the glass-ceramic material was in the liquid or in the plastic state.

A constant goal of the prior art as described, was to effect the molding process in a quick and efficient manner and in a manner that produces a dental restoration that has excellent definition and fit. In dental restorations definition is extremely important, as in order to have a satisfactory restoration the finest details of the original tooth must be reproduced. For example, for a dental restoration to be successful the margins must be sharp and well defined. It is in this area that the prior art molding processes are deficient in that it was not possible to achieve the

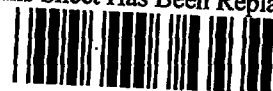


desired degree of definition.

Further, it is desirable to produce a dental restoration in a short period of time in order to efficiently utilize the overhead of the dental laboratory and in order to minimize the labor content of the dental restoration.

Dental laboratories are not typically well funded operations. Therefore, in order to keep cost to a minimum it is highly desirable that a suitable process for forming dental restorations utilize equipment which is relatively inexpensive. While the above described process fits this requirement the below described DICOR process does not.

As is discussed above, there are several prior art processes for the manufacture of dental restorations from glass-ceramic materials. A recent addition to the prior art is the DICOR process as sold by the Dentsply International, Inc. of York Pennsylvania. In this process a dental restoration is formed by centrifugal casting of a molten glass-ceramic material. This process is further described in U.S. Patent No. 4,431,420 issued February 14, 1984 and related patents. Centrifugal casting has been extensively used in the casting of metals principally by the lost wax process. Further, this process has been imminently successful for hundreds of years for use in conjunction with metals. This success results from the fact that molten metals have very low viscosity and high density in the molten state, hence, they function very well in centrifugal casting processes. That is, because molten metals have a high density and a very low viscosity in the molten state



centrifugal force is adequate for purposes of injecting the molten metal into a preformed mold cavity. In an attempt to produce dental restorations which have high definition the above mentioned DICOR process uses centrifugal force to form the desired dental restorations from a molten glass-ceramic material. Molten glass-ceramic materials have a much higher viscosity and a much lower density when compared to molten metals. For this reason, it is not possible to consistently drive a molten glass-ceramic material, by centrifugal force alone into a mold in order to produce a satisfactory dental restoration. That is, a molten glass-ceramic material cannot be driven by centrifugal force into a mold cavity with sufficient force in order to always get the required definition, necessary to form a satisfactory dental restoration. It is well recognized by one skilled in the art that in order to have a satisfactory dental restoration, excellent definition must be achieved in order to recreate the desired margins which are needed for the proper fit of a dental restoration into the human mouth.

Further, the DICOR process, is deficient as to the coloration of the glass-ceramic material utilized. The resulting Dicor dental restoration had an undesirable white color and must be glazed in order to produce satisfactory human coloration. As a result the coloration is only on the surface of the dental restoration, If adjustment by grinding is needed in the final installation of the restoration into the human mouth the glazing is removed thereby exposing the whitish base which contrasts with the glaze. This



contrast is very unsatisfactory from an esthetic point of view.

In contrast to this deficiency, the restoration of the subject process is adapted to utilize glass-ceramic materials wherein the coloration of the resulting dental restoration, throughout, approximates human tooth coloration. Hence, if grinding is necessary in final fitting contrast between the surface of the dental restoration and the underlying base is not observed.

Undesirable contrast can also result from normal wear, where as a result of the grinding action of one tooth against another the glaze is worn away. Again, this is not a problem in this invention as the preferred glass-ceramic material has a uniform natural coloration throughout. It should be noted that the restoration of the subject invention may be glazed to achieve the exact shade desired.

In contrast to the above discussed prior art processes, the process of the subject invention utilizes a positive mechanically applied force for purposes of injecting the molten dental glass-ceramic material into the preformed mold cavity.

For a dental glass-ceramic material to be satisfactory for use in the formation of dental restorations the material should incorporate many or all of the following properties:

1. It must be inert and non-toxic in an oral environment.
2. It must have sufficient structural integrity to resist the forces of mastication and generally must have a 3-point MOR of at least 30,000 PSI.



3. Should be capable of being formed into forms which are compatible with the human anatomy using simple equipment.
4. Should have esthetic qualities (coloration similar to human teeth with a slightly translucent appearance) which are compatible with human teeth and hence should be monolithic or glazable.
5. Further, the glass-ceramic material must not absorb moisture or stain and it must be stress corrosion resistant.
6. Likewise the glass-ceramic material should have wear characteristics which are similar to natural human teeth and should be compatible with other dental materials.
7. The glass-ceramic likewise must have dimensional stability and resist thermal shock during processing and in particular it must have dimensional stability during subsequent heat treating processes wherein recrystallization is effected.
8. Further, the glass-ceramic material should be compatible from a thermal expansion point of view with metals, stains, glazes etc. as are conventionally used to form dental restorations.



9. In order to create an esthetically pleasing dental restoration it may be necessary to alter the final dental restoration to the exact shape and shade desired. In order to effect these alterations the dental restoration must be heated to a temperature of about 950°C for each operation. Therefore, a satisfactory glass-ceramic material must be capable of withstanding multiple heat cycles to about 950°C.
10. A suitable glass-ceramic material must be capable of retaining its structural integrity during heat treating.
11. In summary a suitable glass-ceramic material should have;
- A. Coefficient thermal expansions (C.T.E.) of 5 to $145 \times 10^{-7} / ^\circ\text{C}$
 - B. Translucency of 2.5 to 4.0 on a visible scale of 0 (clear) to 5 (opaque) and overall beauty.
 - C. M.O.R. of at least 30 K.S.I. average.
 - D. Ability to be heat treated to 925-950° C
 - E. Structural integrity during heat treat
 - F. Meltability and formability
 - G. Chemical durability in an oral environment

The subject invention includes glass-ceramic materials which meet the above set forth criteria.



Summary of the invention

In accordance with the above description , it is obvious that in accordance with the prior art it is difficult, if not impossible, to form top quality dental restorations by molding glass-ceramic materials in an inexpensive and efficient manner.

The process, apparatus, compositions and dental restoration of the subject invention provide improvements over the prior art. By use of the process of the subject invention glass-ceramic materials can be readily molded into dental restorations. Further, the apparatus of the subject invention is relatively inexpensive and is easy to utilize. The compositions of the subject invention are highly advantageous in that they produce esthetically pleasing dental restorations which are chemically inert in the human mouth and have outstanding strength properties. Further, the compositions of this invention are advantageous in that when dental restorations formed from these compositions are heat treated they maintain their structural integrity. Further, these dental restorations are capable of withstanding multiple heat cycles to about 950°C, possess thermal expansions which are compatible with the existing porcelains and therefore, these dental restorations can be readily altered using conventional porcelain materials.



Likewise, dental restorations in accordance with the present invention have acceptable coloration after heat treating and can be used at that stage, without further cosmetic treatment, in the mouth. In order to enhance the esthetic properties of the resulting dental restoration, the dental restoration can be readily altered using porcelain materials to achieve any desired effect.

Accordingly, it is an object of the present invention to provide an efficient process whereby dental restorations may be molded from glass-ceramic materials.

It is a further object of the present invention to provide an apparatus for the molding of glass-ceramic dental restorations which is easy to use, is lab friendly, and which is reasonably priced.

It is a further object of the present invention to provide glass-ceramic dental restorations which have outstanding strength and are esthetically pleasing.

It is also an object of this invention to provide glass-ceramic compositions, which are suitable for the formation of dental restorations which have a high degree of micro-structural control during the development of the crystals thereby permitting great flexibility in the forming of these dental restorations.

It is still another object of the present invention to provide a glass-ceramic material which will maintain its structural integrity during heat treating and, in particular, will not slump or sag during heat treating outside of the investment.

Another object of the present inventions is a glass-ceramic



material which is suitable for the formation of dental restorations and which is capable of maintaining its translucency during multiple firing cycles to approximately 950°C.

Still another object of this invention is a process for forming a ceramic dental restoration.

Wherein the process comprises:

- A. placing a glass-ceramic material in a heat-pressure deformable crucible;
- B. heating the crucible and glass-ceramic material to a temperature at which said crucible becomes heat-pressure deformable and the glass-ceramic material is moldable;
- C. bringing the heated crucible into contact with a mold having a preformed cavity therein;
- D. continuing to move the crucible into contact with the mold thereby causing the crucible to deform against the mold, and causing the moldable glass-ceramic material to be injected into said cavity, thereby forming a dental restoration;
- E. cooling the mold and the ceramic dental restoration therein;
- F. removing the formed ceramic restoration from the mold;
- G. heat treating the dental restoration; and
- H. finishing the dental restoration.

Also an object of this invention is to form a heat deformable crucible having a base and a side portion wherein said crucible is formed by the heat sintering of a particulate mixture of glass and



a metal oxide. A preferred composition comprises from about 27 to 31 percent glass and from about 69 to about 73 percent of a metal oxide.

Another object of this invention is a dental restoration which is formed from a glass ceramic material having the following composition (by weight percent);

Li_2O	8 - 15
Al_2O_3	1.5 - 5.0
SiO_2	60 - 85
Na_2O	0 - 2
K_2O	0 - 2
P_2O_5	1.5 - 5
ZrO_2	0 - 3
CaO	0 - 1
$\text{BaO}+\text{SrO}+\text{LaO}$	0 - 12
Coloring oxide	0 - 5

Lastly, an object of the present invention is to create a glass-ceramic material which has excellent chemical durability and as such will not deteriorate when exposed to the fluids in the human mouth.

These and other objects, features and advantageous of the present invention will become apparent from the detailed description herein.

The advantages of the present invention can be more clearly understood from the following description taken together with the drawings.



Brief Description of the Drawings

Figure 1 is a flow chart showing the steps of the preferred embodiment of the process of this invention.

Figure 2 shows a sectioned lost wax mold for use in the invention.

Figure 3 shows a sectioned structure illustrating the heating step of this invention.

Figure 4 shows a sectioned structure illustrating the initial contact of the crucible with the mold.

Figure 5 shows a sectioned structure illustrating the partial sealing of the crucible against the mold.

Figure 6 shows a sectioned structure illustrating the complete sealing of the crucible against the mold and the injection of the molten glass-ceramic into the mold cavity.

Figure 7 is a sectioned side view showing the composite apparatus of this invention.

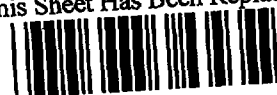
Figure 7a and 7b are sectional side views showing the preferred composite apparatus of this invention.

Figure 8 shows a sectioned alternate mold.

Figure 9 shows a sectioned alternate mold.

Figure 10 shows the mold of Figure 9 being filled with a molten glass-ceramic.

It should be noted that Figures 2 to 10 are schematic representations of apparatus which may be useful in this invention.



DESCRIPTION OF THE PREFERRED EMBODIMENT

Figure 1 generally describes the overall process of the subject invention wherein dental restorations are formed by the molding of a glass-ceramic material. As can be seen in Figure 1, the first step is the formation of a mold having a suitable mold cavity therein. To start the process whereby the mold cavity is formed the tooth or teeth in the human mouth are prepared by the dentist by procedures which are commonly known in the prior art. By using impressions which are provided by the dentist a positive wax form is produced of the desired dental restoration. This positive wax form is then positioned in a mold usually called a ring. A semi-liquid investment material is then poured around the positive wax form. Once the investment material sets up and cures the resulting mold is placed in a furnace and heated thereby causing the wax to melt and run out of a sprue hole which is integral with the mold. The finished mold is then complete. This constitutes the formation of a mold by the lost wax process.

In the second step of Figure 1 a button of a glass-ceramic material is placed in deformable crucible 8, as is illustrated in Figure 3. The button of glass-ceramic material constitutes a small cylinder of the glass-ceramic material which usually weighs about six grams and has a diameter of about two cm. and a thickness of



about one cm. These buttons of glass-ceramic materials are a convenient shape whereby these materials may be manufactured, sold and used. It is understood by one skilled in the art that a sufficient amount of the glass-ceramic material must be used in order to form the desired dental restoration.

In the third step of Figure 1 crucible 8 and the button of glass-ceramic material 7 is uniformly heated. The glass-ceramic material is heated to a temperature above its liquidus temperature as will be described in greater detail herein below. Further the heat-pressure deformable crucible 8 will be described in greater detail herein below.

In the process of this invention the preformed mold can incorporate multiple cavities in order that more than one dental restoration can be produced during one cycle of the subject process.

In steps four, five and six of Figure 1 the heated crucible and glass-ceramic material are moved into contact with the mold by mechanical means in a manner which will be described in greater detail relative to the discussion of Figures 3 to 6 herein below.

In accordance with steps 7 and 8 of Figure 1 the mold is cooled and the solidified glass-ceramic casting is removed from the investment by mechanical means. The dental restoration is then cut off the sprue and finished by heat treating polishing and/or glazing in order to achieve the desired esthetic effect.

The process of this invention may utilize both glass and glass-ceramic materials for purposes of forming the desired dental



restoration.

For strength and esthetic reasons, it is preferred that a glass-ceramic material be utilized. When a glass-ceramic material is utilized, the button of glass-ceramic material 7 is initially placed in crucible 8 in a glass phase. As heat is applied to crucible 8, glass-ceramic material 7 is heated. As the heating of the glass-ceramic material 7 continues, crystal formation is effected whereby glass-ceramic material 7 becomes a ceramic via the formation of a crystalline phase. As the heating is continued, the glass matrix slowly dissolves the crystalline phase thereby causing the glass-ceramic material 7 to reenter the glass phase. The temperature at which the crystal phase completely dissolves in the glass matrix is defined as the liquidus temperature of the glass-ceramic material. In accordance with this invention, it is found desirable to heat the glass-ceramic material to a temperature above the liquidus temperature in order to eliminate any possibility of the existence of a crystalline phase in the molten material. Further at this temperature the glass-ceramic material has a viscosity of about $\log 3$ to about $\log 4$ P which is suitable to allow the molten glass-ceramic material to be readily injected into the mold cavity 5. The viscosity at this temperature is defined as the working range.

Throughout this application, the viscosity of the molten glass-ceramic materials and of the softened crucible will be defined as the log of the respective viscosity in poises. Further, the unit poise will be abbreviated as P. For example, if the viscosity



of a molten glass-ceramic glass material is 10^4 poises the viscosity will be indicated by $\log 4 P$.

While Figure 1 illustrates the broad process of the subject invention. The individual steps as illustrated in Figure 1 are defined in greater detail in the description of Figures 2 through Figure 10.

In Figure 2, it can be seen that mold 4 has been formed by the placement of an investment material 10 in ring 12. Prior to the placement of investment material 10 in ring 12, ring 12 is positioned around wax form 14, the upper extremity of which is shaped in the form of a desired dental restoration 16. Wax form 14 is only shown in an outline form, as Figure 2 illustrates a finished mold 4 after wax form 14 has been burnt out.

The procedure whereby mold 4 is formed is generally known in the prior art, and has been used for centuries to form lost wax molds for use in metal casting procedures. As is stated above in the preparation of mold 4, wax form 14 is positioned in ring 12 an investment slurry 10 is then slowly poured into ring 12 usually with the aid of vibratory techniques to insure that investment 10 completely fills ring 12, and in particular, completely encases wax form 14. Again, these procedures are commonly known in the prior art.

Figures 3, 4, 5, and 6 show the general process of the subject invention in a schematic form.

Referring to Figure 3, it can be seen that mold 4 having cavity 14 is positioned in the vicinity of crucible 8. Positioned



in crucible 8 is glass-ceramic material 7, the details of which will be described herein. Crucible 8 is further positioned on a ceramic base 21 which is positioned on ram 22 whereby crucible 8 can be moved in relation to mold 4. An electric heating element 24 is further provided whereby heat can be applied to crucible 8. Details of the heating of glass-ceramic material 7 will be discussed herein below.

During the heating of crucible 8 glass-ceramic material 7 is converted from the solid state to the liquid state, and crucible 8 converted from a solid brittle state to a plastic state wherein it is heat-pressure deformable. Once the glass-ceramic material 7 reaches the desired working range, ram 22 is actuated as is illustrated in Figure 4, thereby causing crucible 8 to move upwardly and to come into contact with the lower extremities of mold 4. The actuation of ram 22 is effected by a power source not shown.

As can be seen in Figure 5 as the upward movement of ram 22 continues, crucible 8 continues to deform against mold 4 causing the upper extremities of crucible 8 to seal against mold 4 at interface 28. Further, it can be seen that molten glass-ceramic material 7 has started to flow into mold cavity 14.

Referring to Figure 6, as the travel of ram 22 continues the deformation of crucible 8 against mold 4 is completed, and further cavity 14 is completely filled with glass-ceramic material 7 as a result of the applied pressure of ram 22.

Subsequent to the procedures as are illustrated in Figures 3



through 6, mold 4 is then cooled and the desired dental restoration is removed from investment 10. Once the dental restoration is removed from investment 10, the dental restoration is cut apart from the sprue and is heat treated and finished by polishing and glazing in order to achieve the desired esthetic effect.

Further, after formation dental restoration 26 is heat treated in such a manner that its strength and other properties are enhanced by the formation of crystals in a glass matrix. The details of heat treating are described below.

Figure 7 illustrates apparatus 32 which may be utilized to effect the composite process which is illustrated in the flow chart of Figure 1. This apparatus generally comprises support frame 30, heat source 33, mold retaining means 34 and a plunger 36. Support frame 30 generally comprises the outside frame of apparatus 32.

Mold retaining means 34 comprises a bar 50 into which is threaded mold clamp 35. As can be seen, bar 50 permits mold 4 to be locked to support bar 44. Support bar 44 further incorporates an aperture 56 which is slightly smaller than the diameter of mold 4 and slightly larger than the diameter of crucible 8. By the actuation of ram 36, crucible 8 is moved up into contact with mold 4 in a manner which is similar to that as is described above in conjunction with Figures 4, 5 and 6. The apparatus of figure 7 further incorporates a heat source 33, which in the illustrated embodiment comprises an electric resistance heating element 37. In the preferred embodiment the heating element is molybdenum disilicide. Heat source 33 is controlled by a power control source



58.

As is illustrated in Figures 3 and 7, an electric resistance heater may be utilized to effect the heating of crucible 8 and, hence, glass-ceramic material 7. In addition to the electric resistance heating, as illustrated heating may be effected via induction heating, gas torch heating, or any other appropriate means.

The apparatus further may incorporate rotating means, not shown, whereby ram 36 may be rotated during the heating process in order to effect a more uniform heating of crucible 8 and glass-ceramic material contained therein. The rotating means may be an electric, pneumatic or hydraulic motor. Ram 36 is further provided with means for effecting its upward movement, which in the preferred embodiment is a pneumatic cylinder 39.

Further, referring to Figure 7, it can be seen that apparatus 32 incorporates a plurality of structural insulating members 41, 43, 45, 47 and 49 which support and contain heating element 37, and contain the heat created during the operation of the element 37. These structural insulating members are formed from ceramic fiber board.

Likewise, it can be seen that support bar 44 incorporates an aperture 56 which has a waist section 55. Waist section 55 is advantageous in that when crucible 8 deforms against mold 4 the deforming upper extremities of crucible 8 are prevented from downward movement at the constriction of waist 55 thereby causing the molten glass-ceramic material to be efficiently injected into



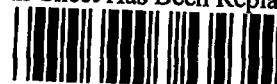
the preformed cavity 14 in mold 4. That is, because upper extremities of crucible 8 are caused to solidify in the vicinity of waist 55, the downward movement of the molten glass-ceramic material is prevented, thereby causing the glass-ceramic material to be injected into mold cavity 14.

Figure 7a and 7b represent the preferred apparatus 31 for use in accordance with this invention. Most of the components of the preferred apparatus 31 are identical or similar to the components of apparatus 32 as discussed herein above. Apparatus 31 differs from apparatus 32 primarily in that a movable arm 38 is provided for wherein a preheated mold 4 may be brought into position for the molding process and positioned against furnace base 41. Moveable arm 38 may be connected to a central pivot point whereby it may be swung into position or it can be laterally moved into position.

Prior to moving arm 38 into position, as is shown in figure 7 a ram 22 is extended in order to place crucible 8 in heat source 33, whereby glass-ceramic material 7 may be melted. Once this melting is effected ram 22 is withdrawn and moveable arm 38 is swung into place to the position as is illustrated in figure 7b. In this position the forming sequence as is shown in Figures 2 to 6 can be completed.

Relative to apparatus 31 and 32 it is understood by one skilled in the art that crucible 8 may be placed in position on ceramic base 21 either manually or by automatic means.

The above described Figures 1 to 7b illustrate the formation of a dental restoration. In addition to being useful in the



formation of essentially complete dental restorations, the composition and process of the subject invention may be used to form copings over which porcelain materials may be applied to alter and shade the dental restoration.

In the prior art, metal copings are extensively utilized. These copings are covered with layers of porcelain materials which are applied to the metal copings for purposes of forming a composite dental restoration which comprises a metal base and a porcelain exterior portion. Composite structures are advantageous in that a metal coping significantly enhances the strength of the resulting dental restoration. Metal copings are disadvantageous in that they are opaque and they have a color which contrasts with the color of a natural tooth and, further, they have toxicity problems in some instances. The use of the subject invention to form an all glass-ceramic dental restoration is advantageous in that the coping is essentially the same color as a natural tooth and, in particular, it is essentially the same color as the porcelain from which the exterior portion of the dental restoration is formed. Further, the all ceramic structure is advantageous in that problems resulting for certain patients who are allergic to certain metals are eliminated. In this procedure, metal free crowns and bridges of outstanding strength and esthetic properties are achieved. The outstanding esthetic properties results from the fact that these glass-ceramic copings can be utilized as a base over which a variety of different porcelains can be fired in order to achieve the most delicate coloration and esthetic properties.



As is stated above, the process of the invention may utilize both glass and glass-ceramic materials. Preferred glass-ceramic compositions for use in accordance with the invention are listed in Tables I to IV. All components listed in Tables I to IV are in weight percent.

The subject invention can utilize any suitable glass-ceramic materials. As is shown in Table I to IV preferred glass-ceramic materials for use in this invention are lithium disilicate glass-ceramic materials. In these materials $\text{Li}_2\text{O} \cdot 2(\text{SiO}_2)$ constitutes the crystalline phase, of the heat treated glass ceramic material. Lithium disilicate glass-ceramic materials are particularly suited for use in the invention in that they are non-toxic, they resist thermal shock, have excellent strength, are corrosion resistant and they produce dental restorations which approximate humane coloration and are translucent and esthetically pleasing. Further, lithium disilicate glass-ceramic materials are advantageous in that they maintain their structural integrity during heat treating, in that they do not slump or sag during proper heat treating.

Other lithium disilicate glass-ceramic materials which may be used in this invention are disclosed in U.S. patent 5,219,799 issued June 15, 1993.

Lithium disilicate glass-ceramic materials may utilize P_2O_5 as a nucleating agent. Other nucleating agents are TiO_2 and ZrO_2 .

Glass-ceramic compositions which may be useful in this invention are as per Table I. The percentages of Table I and the other tables herein are in weight per cent.



TABLE I

Li_2O	8 - 15
Al_2O_3	1.5 - 5.0
SiO_2	60 - 85
Na_2O	0 - 2
K_2O	0 - 2
P_2O_5	1.5 - 5
ZrO_2	0 - 3
CaO	0 - 1
$\text{BaO} + \text{SrO} + \text{LaO}$	0 - 12
Coloring Oxides	0 - 5

More specific glass-ceramic compositions which may be useful in the invention are as per Table II. In particular the compositions of Table II are useful in conjunction with either high or low fusing porcelains which may be used to alter, shade or glaze the dental restorations of this invention.

Table II

Li_2O	10 - 13.5
Al_2O_3	2 - 3
SiO_2	70 - 84
K_2O	0 - 1
P_2O_5	1.5 - 4
ZrO_2	0 - 1



BaO+SrO+LaO	.5 - 4
CaO	0 - 1
Coloring Oxides	0 - 5

In some instances it is desirable to form a dental restoration which can be altered, or glazed with a low fusing porcelain. For purposes of this application a low fusing porcelain is defined as a porcelain which fuses at a temperature of about 700° c

Specific glass-ceramic compositions which are useful in conjunction with low fusing porcelains are as per Table III.

Table III

Li ₂ O	9 - 13
Al ₂ O ₃	1.5 - 4
Si O ₂	65 - 84
Na ₂ O	0 - 1
K ₂ O	0 - 1
P ₂ O ₅	1.5 - 4
Zr O ₂	0 - 1
BaO+SrO+LaO	0 - 12
Ca O	0 - 1
Coloring Oxides	0 - 5

Specific glass-ceramic compositions which may be useful in this invention are as per Table IV.



Table IV

	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
SiO ₂	81.0	84.0	84.0	83.0	82.0	84.0	81.0	83.0	83.0	81.5	80.0	86.0	84.0	81.0	82.0	82.0	81.0	78.5	80.5	72.5
Al ₂ O ₃	3.5	3.0	3.0	3.0	4.0	3.3	3.3	3.5	3.5	3.0	6.0	1.5		3.0	3.3	3.5	3.0	2.5	2.3	2.5
Li ₂ O	11.0	10.5	10.5	10.5	10.5	10.0	11.0	9.0	8.0	12.0	10.5	10.5	11.0	11.0	10.0	10.0	11.0	10.5	12.5	10.5
P ₂ O ₅	3.0	2.0	2.0	2.0	2.0	1.5	1.5	3.0	3.0	2.0	2.0	2.0	3.0	1.0	1.5	2.2	3.0	2.0	2.0	2.0
ZnO	1.0	0.5		0.5	0.5		2.0			0.5	0.5		1.0	2.0		2.0	1.0	0.5	1.0	0.5
TiO ₂	0.4					0.1	1.0	0.5					0.4	0.4		0.5	0.4	0.1	0.1	0.1
CaO	0.5	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25		0.50	0.50		0.25	0.50	0.35	0.35	0.42
MgO		0.5	0.5	0.5	0.5				0.5	0.5	0.5	0.5								0.75
Na ₂ O							0.06													
K ₂ O			0.5	0.5	0.5	1.0			1.0	0.5	0.5							0.5	0.5	
NH ₃	0.5					0.2	0.2	0.5	0.5						0.2	3.0				
Fe ₂ O ₃						0.09	0.09	0.09								0.09				
BaO															3.0			3.0	0.5	9.0
MgO								1.0												
CaO									1.0									0.4	0.4	0.4

This Sheet Has Been Replaced



As to a general range of compositions which are preferred for use in conjunction with this invention the glass-ceramic compositions as defined in Table II are preferred.

The most preferred glass-ceramic composition for use in accordance with this invention is the glass-ceramic composition as is defined by composition 18 of Table IV.

The glass-ceramic composition as defined by Table I to IV above are particularly advantageous over the prior art in that;

1. They are stronger than the prior art glass-ceramic compositions.
2. Those compositions which incorporate barium and cerium oxides are florescent in ultra violet light.
3. The expansion rates of many of these glass ceramic compositions are compatable with the expansion rate of existing altering porcelain materials.
4. They retain their structural integrity at higher temperatures than those of the prior art, thereby permitting altering at higher temperatures.

As is listed in Tables I to IV, coloring oxides may be added to the glass-ceramic material in order to achieve the desired coloration of the glass-ceramic dental restoration.

Suitable coloring oxides for use in glass-ceramic compositions which can be used in this invention, some of which are illustrated in Table I to IV are SnO_2 , MnO , CeO , Fe_2O_3 , Ni_2O , V_2O_3 , Cr_2O_3 , TiO_2



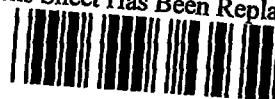
etc. These coloring oxides may be used singularly or in combination.

After formation of a glass-ceramic restoration in accordance with the process of this invention, the resulting dental restoration is heat treated in order to effect the formation of crystals in the dental restoration. This crystal formation is generally referred to as heat treating and enhances the physical and esthetic properties of the dental restoration. A suitable heat treating sequence for use with the glass-ceramic compositions of Tables I to IV is as per Table V below.

For the glass compositions which may be used in this invention the best nucleating temperatures are about 25° to 50°C above the upper anneal point of the glass-ceramic. It has also been determined that a slow increase in temperature from just above the upper anneal point to some 50°C. higher produces the best results in achieving maximum nucleation. It is also well known that the temperature then must be raised to a higher temperature to affect crystallization, this temperature depends upon the composition of the particular glass-ceramic material being used.

If the heating sequence in the heat treating stage is improper or is incorrectly controlled the dental restoration may slump or deform. It is understood by one skilled in the art that an optimum heat treating procedure should be developed for each particular glass-ceramic material in order to allow the dental restoration to maintain its structural integrity during the heat treating process.

In the preferred embodiment the heat treat cycle is such that



in the crystalline phase the glass-ceramic material incorporates a large number of fine crystals which are evenly dispersed throughout the glass matrix. It has been found that when the crystalline phase is very fine and evenly dispersed a dental restoration of maximum strength results. Further a fine crystalline structure tends to produce translucent dental restorations.

From the above discussion it is obvious that dental restorations produced in accordance with this invention can be heat treated after the dental restoration is removed from the investment material and the sprue is cut away.

In accordance with an alternate preferred embodiment of this invention the heat treating of the dental restoration may be effected while the dental restoration is still in the invested state. That is heat treating can be effected while the dental restoration is still encased in the investment material.

In accordance with still another embodiment, the dental restoration can be removed from the investment material in which it was formed and finished or partially finished prior to heat treating. For heat treating the material is then reinvested in an investment material which enhances the heat treatment process. After reinvestment the heat treating is carried out in accordance with the procedure described above.

Whenever the dental restoration is heat treated in the invested state the shrinkage of the dental restoration is minimized if not eliminated.

In heat treating and in particular in the formation of a



crystalline phase shrinkage of the dental restoration occurs. This shrinkage can amount to 3 percent. Naturally, this shrinkage is undesirable as it adversely affects the fit of the dental restoration back into the patients mouth.

As a way of overcoming the shrinkage problem, it is within the scope of this invention to invest the wax form in an investment material which expands when it hardens and is heated. That is the investment material expands when it hardens to produce an oversize mold cavity. This oversize mold cavity naturally produces an oversize dental restoration. This oversize dental restoration is then shrunk back to the correct size during the heat treating process.

For example since the glass-ceramic material shrinks about 3 percent during the heat treating process the original wax form may be invested using an investment material which expands about 3 percent when it hardens and is heated. Using this procedure a dental restoration which is 3 percent oversize results. This oversize dental restoration is then heat treated whereupon it shrinks about 3 percent to produce a finished dental restoration of the correct size.

In order to achieve proper fit, if the restoration is to be heat treated after removal from the investment, an investment material which expands on hardening and heating by about 3 percent must be used. Investment materials which are useful with metals are not particularly suited for use in the invention as they only expand about 1.75 percent. Investments which expand about 3



percent upon hardening and heating and hence permit this type of process are manufactured by Whipmix Corporation of Louisville, Ky. and sold under the designation GIJM 3-23-94; 1

The preferred heat treating process for use with the glass-ceramic compositions of Table I to IV is as per Table V

TABLE V

Heat Restoration To	500
Ramp or Soak at	500 - 600°C for 2 - 6 hours
Ramp at	600 - 925°C for 2 - 3 hours
Soak at	925°C for 1 - 2 hours
Cool to	Room temperature

After heat treating the resulting dental restoration may be further finished. This finishing may include a step wherein the dental restoration is altered with one or more porcelains in order to achieve the precise shape, shade and shading desired. For those glass-ceramic materials of Tables I to IV which have a C.T.E. (Coefficient of Thermal Expansion) of from about 135 to about 145 at the set point temperature, it is desired that the C.T.E. of the altering porcelain material be from about 125 to about 135 and always less the C.T.E. of the glass ceramic material. The process wherein the C.T.E. is measured is defined in the description of the Examples herein below.

Deformable crucible 8 is a critical part of the subject



invention. Crucible 8 in its preferred embodiment has a circular base and hence is generally cylindrical. However it is understood by one skilled in the art that the crucible of this invention can have configurations other than circular. The crucible is formed by heat sintering a particulate mixture of components, such as, fused silica, aluminum oxide, zirconium oxide, magnesium oxide with a glass such as borosilicate glass, soda lime glass, bottle glass, window glass, etc., clay or other materials that those skilled in the art of crucible making might use, to form a crucible suitable for use with a glass-ceramic material. In the broad concept of this invention one forms the crucible of a mixture of materials, such that, at the temperature where the glass-ceramic material is in the working range of about log 3 to log 4 P the crucible has a viscosity of about log 5 to log 7 P.

Crucibles for use in this invention are formed by slip casting. The formation of crucibles by slip casting is well known to those skilled in the art and is described in greater detail in the Examples below.

In the description, as set forth above, the compositions which are used to form crucibles which are useful in this invention may utilize a wide range of materials. While many glasses can be used to form crucibles which are useful in the subject invention, because of their toxicity, glasses which contain heavy metals such as lead, cadmium etc. should not be used.

An alternate method for the formation of crucibles for use in this invention is by powder pressing and then sintered.



In this invention the composition from which the crucible is formed contains materials such that it will be heat-pressure deformable at the desired temperature i.e. about log 3 to log 4 P working temperature of the glass-ceramic. The heat-pressure deformation properties of the crucibles used in this invention is to be contrasted with the crucibles of the prior art which are designed to be rigid at the working temperature of the glass-ceramic material which is contained therein.

In the alternate structure, as is shown in Figures 8, 9, and 10, the sealing of the deformed crucible against the mold is enhanced. In the structure as shown, mold 64 incorporates a circular depression 66 having vertical walls 68 and 70 to which crucible 8 may seal. Vertical walls 72 and 74 of mold 65 may further incorporate a plurality of annular grooves 76. As is further shown in Figure 10, the sealing of crucible 8 against mold 65 is enhanced by the flowing of the upper extremities of crucible 8 into annular grooves 76 during the deformation process.

EXAMPLES

The present invention is illustrated by the following Examples however, these examples are not to be construed as limiting the invention.

Dental restorations were prepared in accordance with the below listed examples. In these examples wax models of a tooth were prepared. A sprue was then attached to the wax model. The wax model with the sprue attached was then placed in an investment



ring. An investment material was then prepared by mixing 90 gram of Kerr Thermovest with 17 ml of a mixture of 2 parts of Thermovest liquid with 1 part water. The resulting mixture was then mixed to a uniform consistency. The mixed investment was then vibrated into the investment ring and around the wax model. The mold was allowed to dry and harden overnight. The investment ring was then placed in a burn out furnace at room temperature and the temperature raised to 600°C where upon the wax model was burnt out of the investment material.

The crucibles as used in these examples were prepared by slip casting. In this process a female plaster of paris mold was prepared by mixing 1247.4 grams of plaster of paris with 946 ml of water to a uniform consistency. The resulting mold was allowed to harden for 36 hours. A slurry of a particulate crucible formulation mixture, as is identified in the examples below was then placed in the preformed plaster of paris mold. The green crucible was removed from the mold and fired in a furnace for 15 minutes at 1100°C to sinter the crucible to a hardened more durable form.

The slurry used to form the crucible was formed by mixing 1 pound of particulate material with 160 ml water.

Because of the hyorasiopic nature of the plaster of paris mold the particulate crucible formulation slurry coagulates in the plaster of paris mold. When the desired crucible wall thickness was achieved the remainder of the slurry was poured out of the mold resulting in a green crucible structure which was allowed to dry.



In the listed examples and in this application, the coefficient of thermal expansion (C.T.E.) was measured from room temperature to 250°C and is reported in units of $\times 10^{-7} / ^\circ\text{C}$.

The translucency of the resulting dental restoration was measured by visual inspection given a value of 0 to 5 wherein value of 0 was deemed to be perfectly clear and 5 was deemed to be opaque.

In the below listed Examples for purposes of injecting the molten glass and glass ceramic material into the mold a pressure of 30 P.S.I. was utilized, with the exception of Examples 26, and 27 wherein a pressure of about 50 P.S.I. was utilized.

The referenced heat treating sequence for all Examples except Examples 26, and 27 is in accordance with Table IV above.

In the below Examples the glass-ceramic test rods for measuring modules of rupture (MOR) and thermal expansion (C.T.E) were formed along with color tab test samples. These test rods and color tab samples were subjected to the heat treatment process of Table VI whereby the glasses were crystallized in situ to glass-ceramics. The test rod samples were .120" X 1.25". The Examples also record the visual appearance of each glass-ceramic and values of various properties exhibited by the glass-ceramic, such as, linear coefficient of thermal expansion (C.T.E.), reported in terms of $\times 10^{-7} / ^\circ\text{C}$, modules of rupture (MOR), cited in terms of K.S.I. (thousands of pounds per square inch) as determined in accordance with measurement techniques conventional in the art. K.S.I. may be converted to its metric equivalent MPa by dividing K.S.I. by .145.



The components used in these Examples are as follows:

Thermovest and Therovest Liquid as sold by Kerr Manufacturing Co.
Romulus, Mi. 48174.

3I Fused Silica as sold by Harbison Walker Refractories division of
Indresco Inc., Pittsburg, Pa. 15223.

SP921 TF (borosilicate glass) as sold by Specialty Glass Inc. of
Oldsmar, Florida and has the following compositions in weight
percent.

TABLE VI

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5



Example 1

An attempt was made to form a Glass-ceramic dental restoration in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 90.8 grams of SP921TF glass in 363.2 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6. The crucible cracked and hence no dental restoration was formed.



Example 2

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 136.2 grams of SP921TF glass and 317.8 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The composition of the glass-ceramic material used is in accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting dental restoration had excellent definition and a M.O.R. of 41 K.S.I., a C.T.E. of 148, a translucency of 3.5 and a softening temperature of 975° c.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold.



Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Additional tests were conducted wherein it was determined that the crucible of this Example deformed and sealed well at 1375 and 1425°C

Example 3

A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 181.6 grams of SP921TF glass and 272.4 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The preheated crucible without glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes.

During the heating process, the crucible lost its structural integrity and was not capable of effecting a seal with a mold. Therefore, no molding process was carried out.

Example 4

A mold was prepared in accordance with the procedure described



above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 227 grams of SP921TF glass and 227 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes.

During the heating process, the crucible melted and hence was not capable of forming an effective seal with the mold. Therefore, no molding process was carried out.

Example 5

Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 118 grams of SP921TF glass and 336 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The composition of the glass-ceramic material used is in



accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400° C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting dental restoration had excellent definition and physical properties as are reported with Example 2.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform. Further tests were conducted on crucibles having the composition as set forth above wherein it was determined that the crucible cracked and hence was not functional at 1375°C. An additional test demonstrated that the crucible of this example deformed and sealed at 1425°C.

Example 6

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance



with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 127.1 grams of SP921TF glass and 336.9 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The composition of the glass-ceramic material used is in accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400° C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting dental restoration had excellent definition and physical properties as are in accordance with Example 2.

During the forming process, the crucible retained its structural integrity and formed an effective seal for the mold. Further, during the heat treating process, the dental restoration retained its structural integrity and did not slump or deform. Additional tests were conducted on the crucible of this example wherein it was determined that the crucible would deform and seal at both 1375 and 1425°C.



Example 7

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 145.3 grams of SP921TF glass and 308.7 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The composition of the glass-ceramic material used is in accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400° C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting dental restoration had excellent definition and physical properties as are reported in accordance with example 2.



During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the dental restoration retained its structural integrity and did not slump or deform. Additional tests were conducted on the crucible of this Example wherein it was determined that the crucible functioned at 1375°C. However at 1425°C the crucible slumped and hence could not be used in the process of this invention.

Example 8

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and description described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #2 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is

illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heated treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 46.7 K.S.I., a C.T.E. of 138 a translucency of 2.75 and a softening temperature of 975° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Example 9

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and description described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #3 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7



and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heated treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 43 K.S.I., a C.T.E. of 141 a translucency of 3.0 and a softening temperature of 975°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Example 10

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and description described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.



The composition of the glass-ceramic material used is in accordance with composition #4 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heated treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 48 K.S.I., a C.T.E. of 133 a translucency of 2.5 and a softening temperature of 975°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Example 11

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.



By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #5 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 42 K.S.I., a C.T.E. of 140 a translucency of 2.5 and a softening temperature of 975°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Example 12

A Glass-ceramic dental restoration was prepared in accordance



with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #6 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 41.5 K.S.I., a C.T.E. of 162 a translucency of 4 and a softening temperature of 950°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.



Example 13

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material is in accordance with a composition #7 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heated treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 53.5 K.S.I., a C.T.E. of 136 a translucency of 4.0 and a softening temperature of 950° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental



restoration retained its structural integrity and did not slump or deform during heat treating.

Example 14

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The glass-ceramic material used was Di-Cor as sold by the Densply Corporation and as is described above. Di-Cor is thought to be flouro-mica glass-ceramic.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated in the investment.

While the glass-ceramic properly filled the mold the resulting dental restortion cracked as a result of shrinkage during the heat



treating process. This cracking is thought to result from the fact that the forming investment was not suitable for use in the heat treating sequence.

Example 15

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass used in weight percent was;

TABLE VII

SiO ₂	50.2
B ₂ O ₃	8.6
AlF ₃	.7
Al ₂ O ₃	16.0
BaO	4.75
ZnO	19.75

The preheated crucible and glass-ceramic material was then



placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

A satisfactory dental restoration resulted which was then removed from the investment material cut apart from the sprue.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 4 K.S.I., a C.T.E. of 56 a translucency of 0.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Because the material used was a glass the resulting dental restoration was not heat treated.

Example 16

Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 8 of Table IV. After melting, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 30 K.S.I., a C.T.E. of 157, a translucency of 40 and a softening temperature of 925°C.

The test samples cracked during heat treating therefore the composition was deemed to be unsuitable as a material for use in



preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 17

A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 9 of Table IV. After melting, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 24 K.S.I., a C.T.E. of 145, and a softening temperature of 975°C.

Because the test samples had a M.O.R. of only 24 and the glass-ceramic was hard to melt and form the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 18

A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 10 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test



samples had a M.O.R. of 41.4 K.S.I., a C.T.E. of 129, a translucency of 2.5 and a softening temperature of 975°C.

Because the test samples had a C.T.E. of less than 130 the composition may not be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 19

A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 11 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 35 K.S.I., a C.T.E. of 80, a translucency of 3.5 and a softening temperature of 975°C.

Because the test samples had a C.T.E. of 80 the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 20



A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 12 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 31 K.S.I., a C.T.E. of 127, and a translucency of 2.5.

Because the test samples had a C.T.E. of 127 therefore the composition may not be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 21

A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 13 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 32 K.S.I., a C.T.E. of 256, and a translucency of 5.

Because the test samples had a C.T.E. of 256 the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.



Example 22

Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 14 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 13 K.S.I., a C.T.E. of 126, and a translucency of 4.5.

Because the test samples had a low C.T.E. and a low M.O.R. the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 23

A Glass-ceramic dental composition was prepared and elevated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 15 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a translucency of 5.0.

Because the test samples turned opaque during heat treating therefore the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.



Example 24

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #16 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1425°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 35 K.S.I., a C.T.E. of 148 translucency of 3.5 and a softening temperature of 950° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental



restoration retained its structural integrity and did not slump or deform during heat treating.

The investment material utilized was Whipmix GTJM 3-23-94; As described herein above. The investment material had an expansion rate of about 3%. As a result of this expansion rate the resulting dental restoration had excellent fit.

Example 25

Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #17 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1425°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated in the investment material.



The resulting test samples and dental restoration had excellent definition and a M.O.R. of 40 K.S.I., a C.T.E. of 138 a translucency of 3.5 and a softening temperature of 950° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

The investment material utilized was Thermovest and after heat treating was removed and the resulting dental restoration had excellent fit.



Example 26

A glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible.

The composition of the glass-ceramic material used is in accordance with composition 18 of Table IV.

The crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figures 7a and 7b and heated to a temperature of 1425° C for a period of 5 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 47 K.S.I., a translucency of 4.0 and a softening temperature of 950° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental



restoration retained its structural integrity and did not slump or deform during heat treating.

The investment material utilized was Whipmix GTJM 3-23-94; As described herein above. The investment material had an expansion rate of about 3%. As a result of this expansion rate the resulting dental restoration had excellent fit.

Example 27

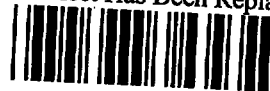
A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and not preheated .

The composition of the glass-ceramic material used is in accordance with composition 19 of Table IV.

The crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figures 7a and 7b and heated to a temperature of 1425° C for a period of 5 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.



The resulting test samples and dental restoration had excellent definition and a M.O.R. of 52 K.S.I., a translucency of 3.5 and a softening temperature of 950 ° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

The investment material utilized was Whipmix GTJM 3-23-94; As described herein above. The investment material had a total expansion rate of about 3%. As a result of this expansion rate the resulting dental restoration had excellent fit.

Examples 26 and 27 represent the preferred process and glass ceramic compositions in accordance with this invention. As is mentioned the resulting dental restorations of these Examples were heat treated the heat treating procedure used for Examples 26 and 27 is per Table VIII.

Table VIII

Heat Dental Restoration to	450° C at furnace rate
Ramp or soak at	450-550° C for 6 hours
Ramp at	550-850° C for 2 hours
Hold at	850° C for 45 minutes
Ramp at	850-900° C at furnace rate
Soak at	900° C for 15 minutes
Cool to	Room Temperature



After heat treating the dental restorations of Examples 26 and 27 were further finished by altering the shape and shade with a high fusing porcelain sold under the trademark Ceramco II and a low fusing porcelain sold under the trademark Final Touch. Both of the high and low fusing porcelains fired and adhered well. Likewise, both porcelains had thermal expansions which were compatible with the glass-ceramics from which the dental restorations were formed.

The Ceramco II and Final Touch porcelains as used herein are manufactured and sold by Ceramco, Inc. of six Terri Lane, Burlington, N.J. 08016.

Relative to the dental restorations as were produced in accordance with Examples 26 and 27 above it should be noted that these restorations were exceptionally strong in that they had M.O.R. ratings of about 50 K.S.I.

It should be noted that the M.O.R. ratings of Examples 26 and 27 do not correlate with the M.O.R. ratings as are specified relative to the other examples in that a different test protocol was used for measuring the M.O.R. of Examples 26 and 27. The M.O.R. for Examples 26 and 27 were tested on a Lloyd Instrument type No.TG 18 as manufactured by John Chatillon & Sons Inc. of Greensboro, N.C.. These measurements were made in accordance with I.S.O test No. 6872 using cylindrical bars of 0.125" diameter with a 1" span, 3 point bending with a crosshead speed of 1 m.m. per minute.

In contrast the M.O.R. measurements of the other Examples were made on a piece of equipment which was manufactured by the



applicant. This piece of equipment has characteristics which are similar to those of the above described Lloyd instrument type No. TG 18 and used the same test bars. Generally it could be said that the M.O.R. rating of those Examples other than Examples 26 and 27 appear to be low.

For a corelation between the M.O.R. test protocol of Examples 26 and 27 and the test protocol of the other Examples Table IX should be referred to

Table IX

Example No.	Reported M.O.R. As per test used for Examples 1-25	M.O.R. as per. I.S.O. Test No. 6872
26	42	47
27	45	52

Example 28

A glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was



then placed in the crucible and preheated to a temperature of 650°C.

The composition of the glass-ceramic material used is in accordance with composition 10 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1425°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated.

The resulting test samples and dental restoration had excellent definition and a C.T.E. of 111 a translucency of 3.5 and a softening temperature of 850°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

It should be understood that the invention is not limited to the embodiment shown and described in Figures 1-10 and examples 1 to 28 since the process and composition parameters can be varied and the configuration of the apparatus can be altered without departing from the scope of the invention.

The above description and drawings are illustrative only since



modifications could be made without departing from the present invention, the scope of which is to be limited only by the following claims.





WHAT IS CLAIMED:

1. A process for forming a ceramic dental restoration comprising the steps of;

a. Placing a glass-ceramic material in a heat-pressure deformable crucible,

b. Heating the crucible and glass-ceramic material to a temperature at which said crucible becomes heat-pressure deformable and the glass-ceramic material is moldable,

c. Bringing the heated crucible into contact with the sprue end of a mold having a preformed cavity therein,

d. Continue to move the crucible into contact with the mold thereby causing the crucible to deform against the mold, and causing a seal to form there between and causing the moldable glass-ceramic material to be injected into said cavity, thereby forming a dental restoration,

e. Cooling the mold and the glass- ceramic dental restoration therein.

f. Removing the formed ceramic restoration from the mold,





g. Heat treating the dental restoration

h. Finishing the dental restoration .

2. The process of claim 1 wherein the crucible containing the glass ceramic material therein and the mold are axially disposed in relation to each other.
3. The process of claim 1 wherein the crucible containing the glass-ceramic material therein and the mold are vertically disposed in relation to each other.
4. The process of claim 1 wherein the dental restoration is heat treated in the mold.
5. The process of claim 1 wherein the dental restoration is removed from the mold and reinvested prior to heat treating.
6. The process of claim 1 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P and the crucible and has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.
7. The process of claim 2 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P





and the crucible and has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.

8. The process of claim 3 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P and the crucible and has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.
9. The process of claim 4 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P and the crucible and has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.
10. The process of claim 5 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P and the crucible and has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.
11. The process of claim 1 wherein the glass-ceramic material has the following composition (by weight percent)

Li_2O	8 - 15
Al_2O_3	1.5 - 5.0





SiO ₂	60 - 85
Na ₂ O	0 - 2
K ₂ O	0 - 2
P ₂ O ₅	1.5 - 5
ZrO ₂	0 - 3
CaO	0 - 1
BaO+SrO+LiO	0 - 12
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to 74 percent of fused silica and from about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent)

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

12. The process of claim 2 wherein the glass-ceramic material has the following composition (by weight percent)

Li ₂ O	8 - 15
Al ₂ O ₃	1.5 - 5.0
SiO ₂	60 - 85





Na ₂ O	0 - 2
K ₂ O	0 - 2
P ₂ O ₅	1.5 - 5
ZrO ₂	0 - 3
CaO	0 - 1
BaO+SrO+LiO	0 - 12
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to about 74 percent of fused silica and from about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

13. The process of claim 3 wherein the glass-ceramic material has the following composition (by weight percent)

Li ₂ O	8 - 15
Al ₂ O ₃	1.5 - 5.0
SiO ₂	60 - 85





Na ₂ O	0 - 2
K ₂ O	0 - 2
P ₂ O ₅	1.5 - 5
ZrO ₂	0 - 3
CaO	0 - 1
BaO+SrO+LiO	0 - 12
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to about 74 percent of fused silica and about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

14. The process of claim 6 wherein the glass-ceramic material has the following composition (by weight percent)

Li ₂ O	8 - 15
Al ₂ O ₃	1.5 - 5.0





SiO ₂	60 - 85
Na ₂ O	0 - 2
K ₂ O	0 - 2
P ₂ O ₅	1.5 - 2.5
ZrO ₂	0 - 3
CaO	0 - 1
BaO+SrO+LiO	0 - 12
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to about 74 percent of fused silica and from about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent)

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

15. The process of claim 6 wherein the glass-ceramic material has the following composition (by weight percent)

Li ₂ O	10 - 13.5
Al ₂ O ₃	2 - 3.0

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SiO ₂	75 - 84
K ₂ O	0 - 1
P ₂ O ₅	1.5 - 4
ZrO ₂	0 - 1
CaO	0 - 1
BaO+SrO+LiO	.5 - 4
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to about 74 percent of fused silica and from about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

16. The dental restoration which is formed from the process of claim 1.
17. The dental restoration which is formed from the process of claim 2.





18. The dental restoration which is formed from the process of claim 3.
19. The dental restoration which is formed from the process of claim 4.
20. The dental restoration which is formed from the process of claim 5.
21. An apparatus which is suitable for the formation of a dental restoration which comprises a mold having a cavity therein, a means for retaining said mold in a fixed position, a heat deformable crucible containing a molten glass-ceramic material therein, a means for supporting said crucible, a means for uniformly heating said crucible and said glass-ceramic material, and a means for bringing said crucible into contact with said mold thereby causing said crucible to deform and seal against mold and causing the molten glass-ceramic material to be injected into the cavity which is integral with the mold.
22. The apparatus for claim 21 wherein means are provided for rotating the crucible while it is being heated in order to facilitate its uniform heating.
23. The apparatus of claim 21 wherein means are provided for





automatically controlling the uniform heating of the crucible in accordance with a predetermined cycle and a means are provided for automatically moving said crucible into contact with said mold in accordance with a predetermined cycle.

24. The apparatus of claim 22 wherein means are provided for automatically controlling the uniform heating of the crucible in accordance with a predetermined cycle and a means are provided for automatically moving said crucible into contact with said mold in accordance with a predetermined cycle.
25. The apparatus of claim 21 which further incorporates a waisted aperture wherein the crucible is guided into contact with the mold.
26. A heat deformable crucible having a base and a side portion wherein said crucible is formed by the heat sintering of a particulate mixture of a glass and a metal oxide.
27. The heat deformable crucible of claim 26 wherein the percentage of the particulate mixture comprises from about 26 to about 32 percent glass and from about 68 to about 74 percent of a metal oxide.
28. The heat deformable crucible of claim 26 wherein the glass is a borosilicate glass.





29. The heat deformable crucible of claim 27 wherein the glass is a borosilicate glass.
30. The heat deformable crucible of claim 26 wherein the metal oxide is silica.
31. The heat deformable crucible of claim 27 wherein the metal oxide is silica.
32. The heat deformable crucible of claim 28 wherein the metal oxide is silica.
33. The heat deformable crucible of claim 29 wherein the metal oxide is silica.
34. The heat deformable crucible of claim 26 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO_2	78
B_2O_3	15
Al_2O_3	2.5
Na_2O	4.5

35. The heat deformable crucible of claim 27 wherein the glass is a borosilicate glass having the following composition (by





weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

36. The heat deformable crucible of claim 30 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

37. The heat deformable crucible of claim 31 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

38. The heat deformable crucible of claim 32 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
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B_2O_3	15
Al_2O_3	2.5
Na_2O	4.5

39. The heat deformable crucible of claim 33 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO_2	78
B_2O_3	15
Al_2O_3	2.5
Na_2O	4.5

40. The heat deformable crucible of claim 36 wherein the particulate mixture comprises 28 percent borosilicate glass and 72 percent silica.

41. The process of claim 1 wherein the sprue end of the mold incorporates a circular cavity which interacts with the crucible when the deformable crucible is brought into contact with the mold.

42. The process of claim 1 wherein the sprue end of the mold incorporates a circular cavity the axis of which is parallel with the axis of the mold, the outer edges of said cavity having a plurality of annular grooves, which interact with the crucible when the deformable crucible is brought into contact





with the mold.

43. The process of claim 1 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
44. The process of claim 6 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
45. The process of claim 7 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
46. The process of claim 8 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
47. The process of claim 9 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point. .





48. The process of claim 10 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
49. The process of claim 14 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
50. The process of claim 15 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains having C.T.E.'s of from about 125 to 135 at their set point.
51. The process of claim 1 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
52. The process of claim 6 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.





53. The process of claim 7 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
54. The process of claim 8 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
55. The process of claim 9 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
56. The process of claim 10 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
57. The process of claim 14 wherein the preformed cavity is formed by investing a wax model in an investment which





expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax out of the cavity.

58. The process of claim 15 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.

59. The process of claim 6 wherein the glass-ceramic material has the following composition (by weight percent)

SiO ₂	78.5
Al ₂ O ₃	2.5
LiO ₂	10.5
K ₂ O	0.5
P ₂ O ₅	2.0
ZiO ₂	0.5
CeO	.35
NiO ₂	.02
TiO ₂	0.1
BaO	3.0
CaO	0.4

60. A dental restoration which is formed from a glass- ceramic material having the following composition (by weight





percent);

Li_2O	8 - 15
Al_2O_3	1.5 - 5.0
Si O_2	60 - 85
Na_2O	0 - 2
K_2O	0 - 2
P_2O_5	1.5 - 5
ZrO_2	0 - 3
CaO	0 - 1
$\text{BaO}+\text{SrO}+\text{LaO}$	0 - 12
Coloring Oxide	0 - 5

61. A dental restoration which is formed from a glass- ceramic material having the following composition (by weight percent);

Li_2O	10 - 13.5
Al_2O_3	2 - 3
SiO_2	70 - 84
K_2O	0 - 1
P_2O_5	1.5 - 4
ZrO_2	0 - 1
$\text{Ba}+\text{SrO}+\text{LaO}$	.5 - 4
CaO	0 - 1
Coloring Oxides	0 - 5

62. A dental restoration which is formed from a glass ceramic





material having the following composition (by weight percent);

Li_2O	9 - 13
Al_2O_3	1.5 - 4
SiO_2	65 - 84
Na_2O	0 - 1
K_2O	0 - 1
P_2O_5	1.5 - 4
ZrO_2	0 - 1
$\text{BaO}+\text{SrO}+\text{LaO}$	0 - 12
CaO	0 - 1
Coloring Oxides	0 - 5

63. A dental restoration which if formed from a glass ceramic material having the following composition (by weight percent);

Li_2O	10.5
Al_2O_3	2.5
SiO_2	78.5
K_2O	0.5
P_2O_5	2.0
ZrO_2	0.5
TiO_2	0.1
CeO	0.35
NiO_2	0.02
BaO	3.0

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CaO

0.4

64. The dental restoration of claim 60 which is altered with a porcelain material which has a C.T.E. which is slightly less than the C.T.E. of the glass ceramic material.
65. The dental restoration of claim 61 which is altered with a porcelain material which has a C.T.E. which is slightly less than the C.T.E. of the glass ceramic material.
66. The dental restoration of claim 62 which is altered with a porcelain material which has a C.T.E. which is slightly less than the C.T.E. of the glass ceramic material.
67. The dental restoration of claim 63 which is altered with a porcelain material which has a C.T.E. which is slightly less than the C.T.E. of the glass ceramic material.
68. The dental restoration of claim 60 wherein the resulting dental restoration has a M.O.R. of at least 30 K.S.I.
69. The dental restoration of claim 61 wherein the resulting dental restoration has a M.O.R. of at least 30 K.S.I.
70. The dental restoration of claim 62 wherein the resulting dental restoration has a M.O.R. of at least 30 K.S.I.

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71. The dental restoration of claim 63 wherein the resulting dental restoration has a M.O.R. of at least 40 K.S.I.

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Abstract

The present invention is concerned with a process for the formation of dental restorations from glass-ceramic materials and the resulting dental restorations. In this invention, a dental restoration is prepared by placing a glass-ceramic material in a heat-pressure deformable crucible. Heat is then applied to the crucible in order to bring the glass-ceramic material to a working range at temperatures above its liquidus temperature. The crucible in which the glass-ceramic material is placed has heat-pressure deformation properties which are matched to the working temperature of the glass-ceramic material being heated. The heat deformation properties of the crucible must be such that when the glass-ceramic material in the crucible is in the working range the crucible is heat-pressure deformable without rupturing. Once the glass-ceramic material is heated to its working temperature, the crucible is brought into contact with a mold having a preformed cavity therein, the cavity being in the shape of the desired dental restoration. As the distance between the heated glass-ceramic material and the mold is decreased, the crucible is deformed to form a seal with the mold thereby facilitating the injection of the molten glass-ceramic material into the mold cavity. An interactive seal between the crucible and the mold may be provided for. The composite process may be carried out in a vacuum. The resulting dental restoration has superior optical esthetic and strength properties. The invention further includes the heat-pressure deformable crucible



which is useful in the process of this invention and the related apparatus.



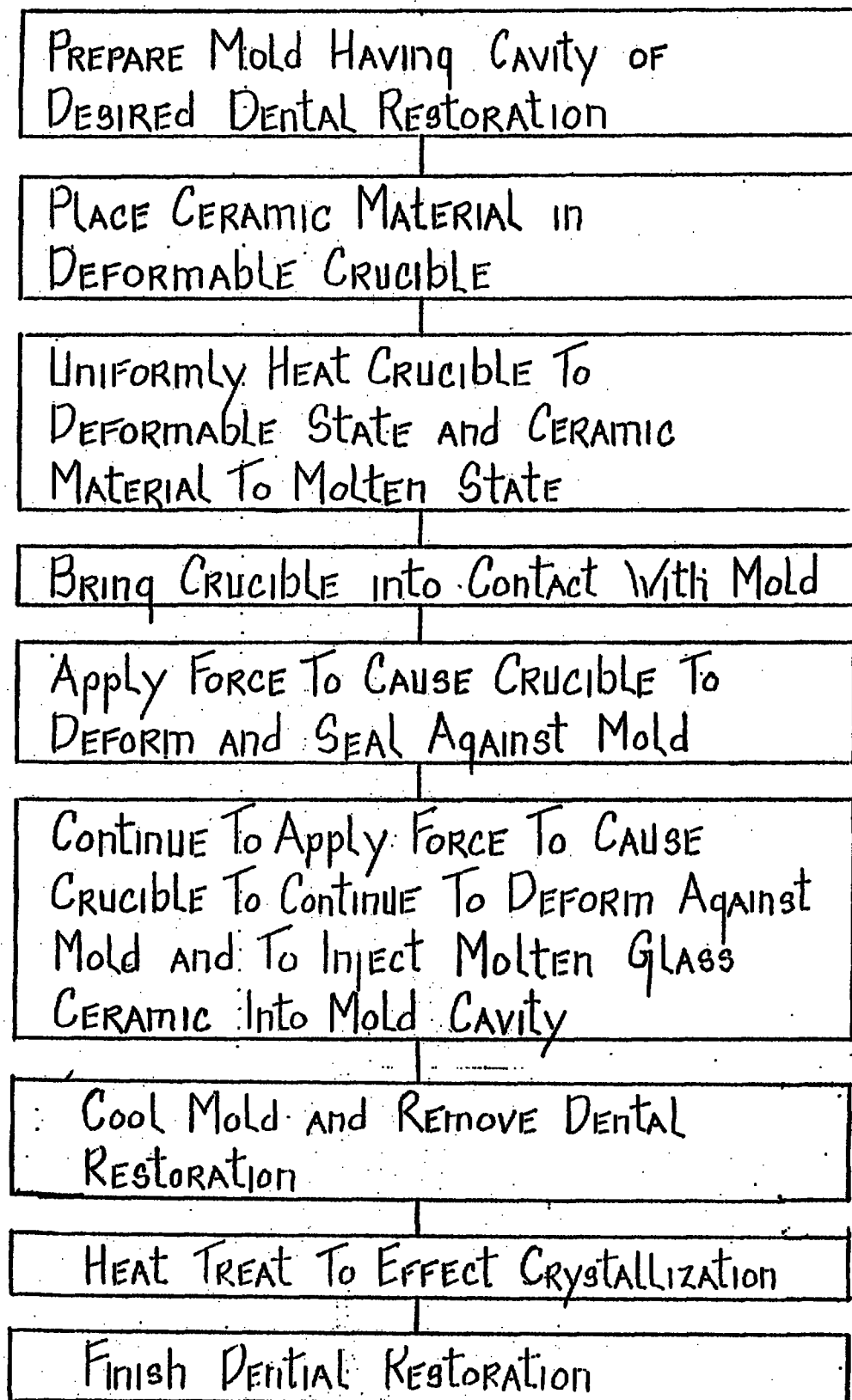


FIG 1

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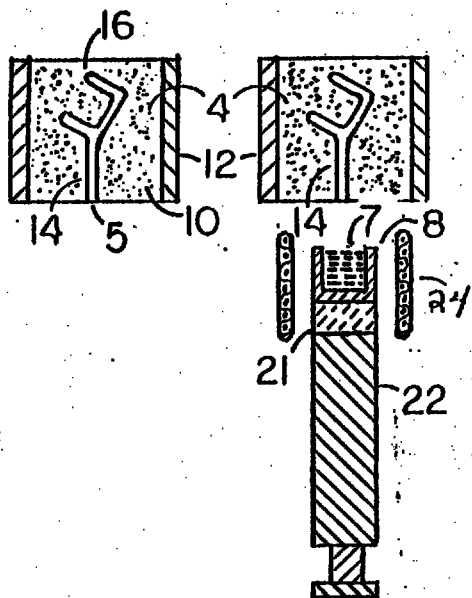


FIG 2

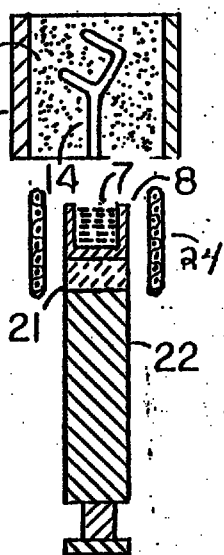


FIG 3

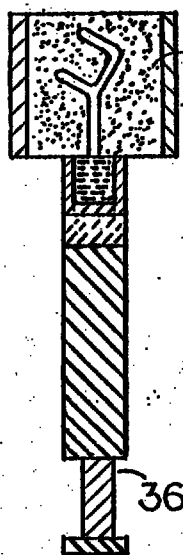


FIG 4

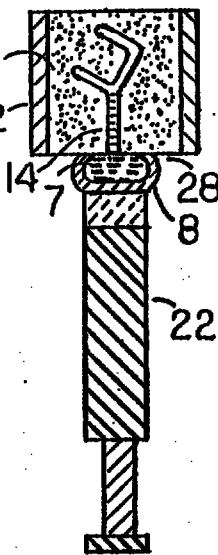


FIG 5

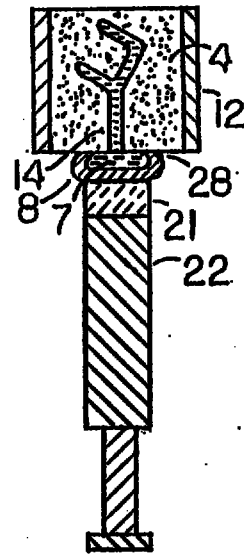


FIG 6

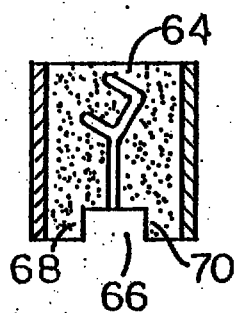


FIG 8

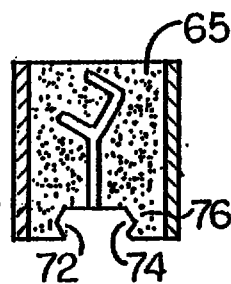


FIG 9

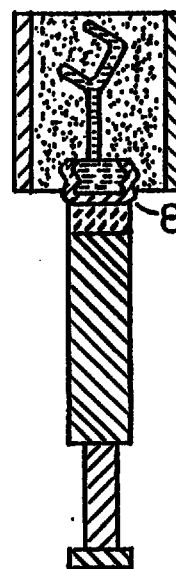


FIG 10

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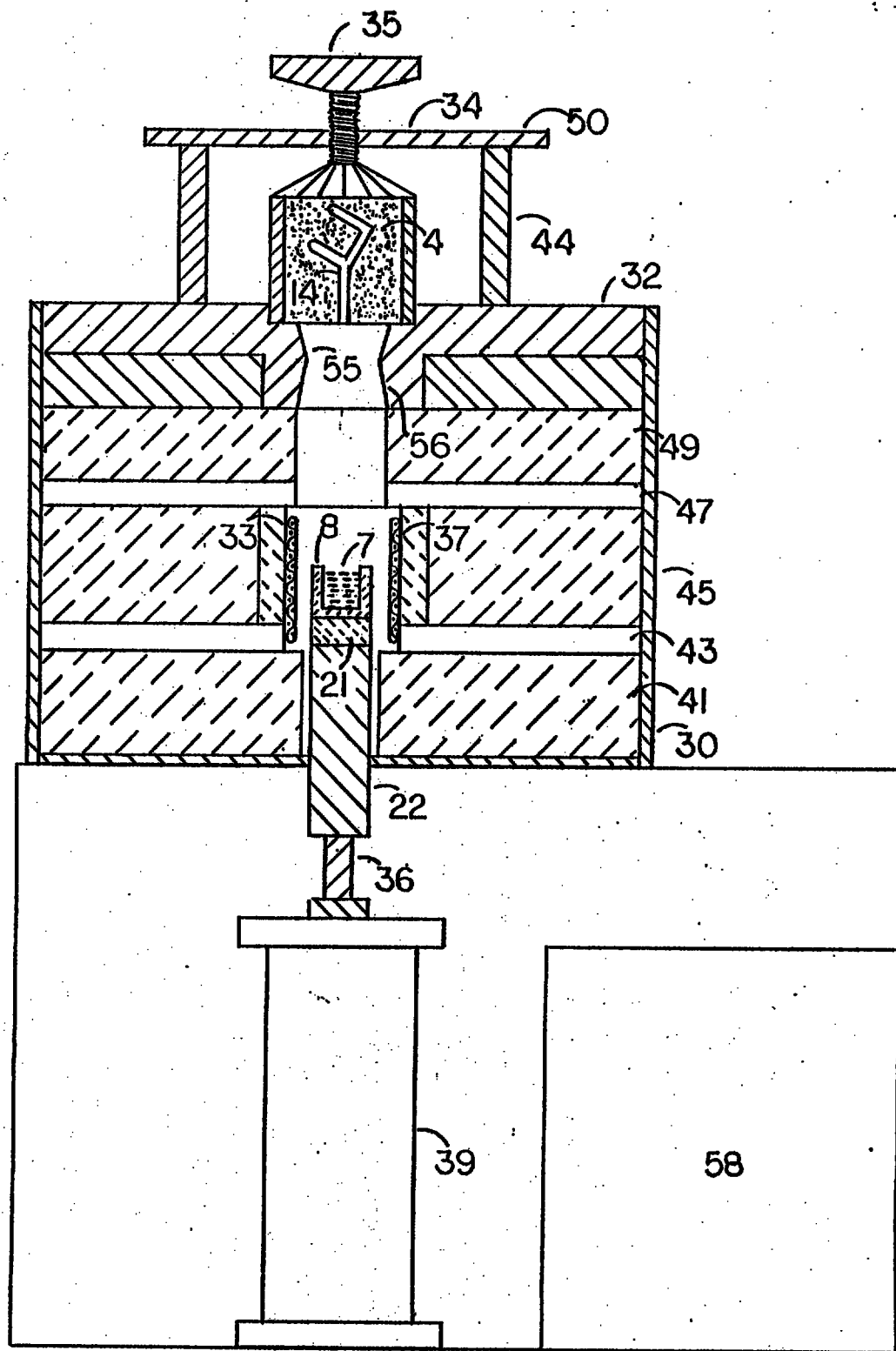
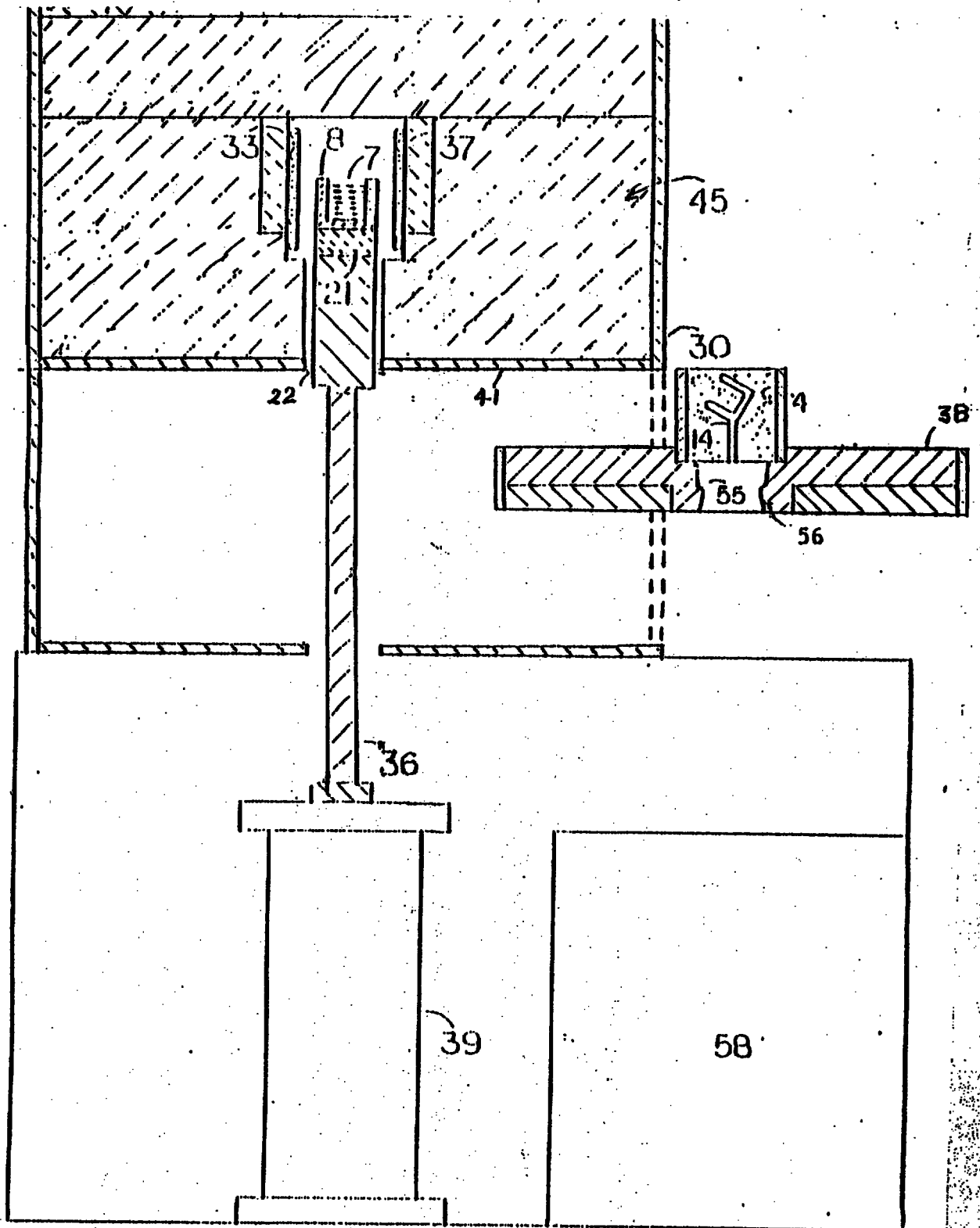


FIG 7

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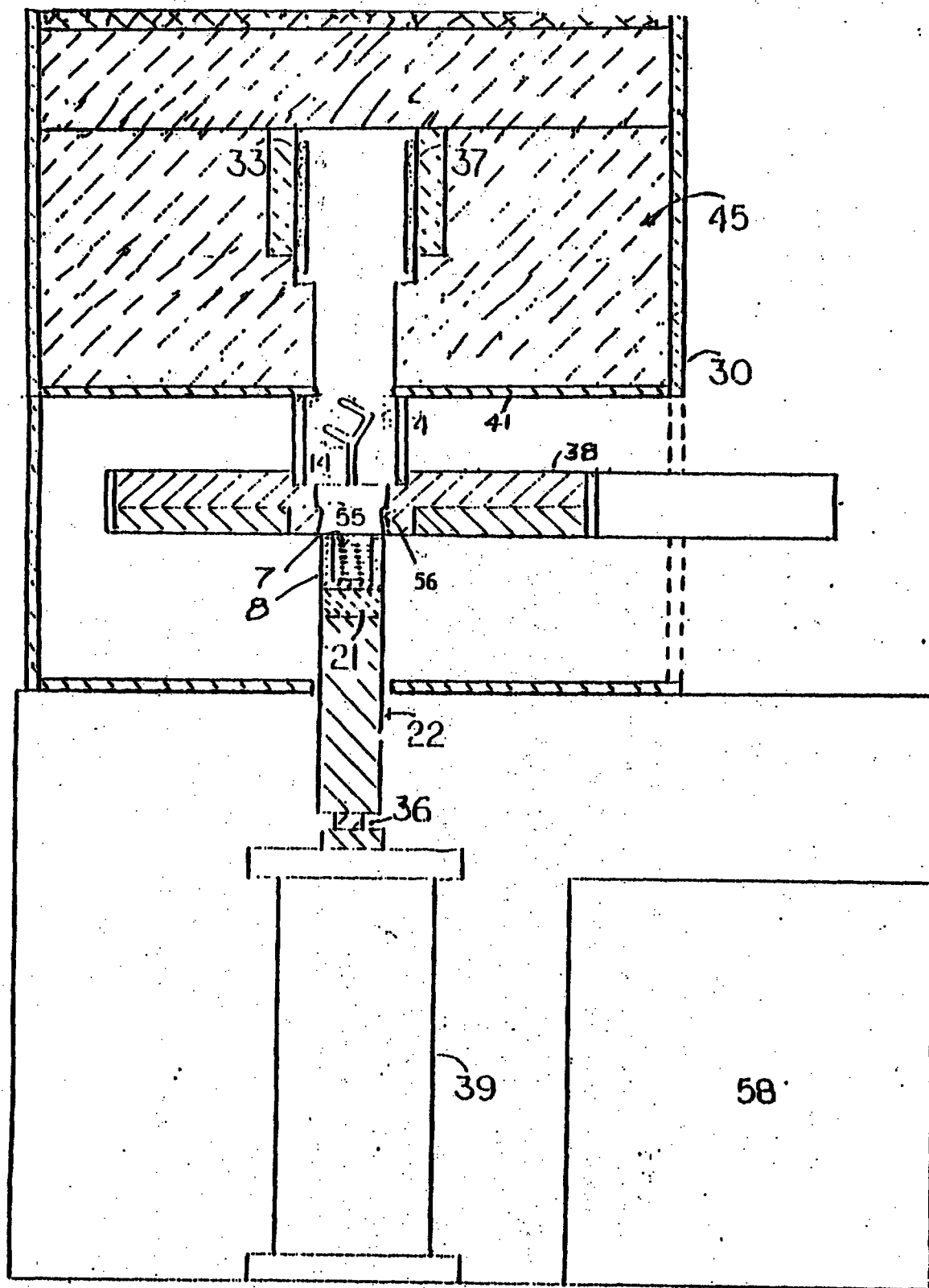


FIG 7B

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Method for Molding Dental Restorations and Related Apparatus
Related Applications

This application is a continuation in part application of application S.N. 08/250,926 Filed May 31, 1994

Field of the Invention

The present invention relates to a process for the molding of metal free dental restorations such as crowns, bridges, inlays, onlays etc. from glass-ceramic materials. The invention is also concerned with apparatus which permits dental restorations to be easily molded from glass-ceramic materials and lastly, the invention relates to the resulting dental restorations.

Background of the Invention

In the prior art various methods have been used to form metal free dental restorations from glass-ceramic materials. Glass-ceramic materials because of their strength, translucency, non-toxicity and other physical properties are ideal materials for use in forming dental restorations. Because of their suitability, glass-ceramic materials have been used to form dental restorations for at least eighty years. In the prior art the most widely used means for forming dental restorations from mixtures of glass and ceramic materials is a process which utilizes a slurry of glass and ceramic particles. In this process a die is formed which is an exact replica of the remaining portion of the tooth to which the restoration is to be secured. It is understood by one skilled in

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the art that the remaining portion of the tooth has been prepared by the dentist in such a manner that the attachment of the restoration is facilitated. To start the process the dentist takes an impression of the prepared tooth to create a negative impression of the prepared tooth or teeth. This negative impression is then packed with a material to form a positive impression of the prepared tooth or teeth. This positive impression is called a die. Platinum foil is then pressed over the die to form a matrix which is essentially a foundation on which the dental restoration is built. In order to form up the dental restoration many layers of a slurry of a particulate glass-ceramic material are applied to the platinum foil matrix. As multiple layers of the slurry are built up and dried a semi-solid structure is formed which can be carved into the shape of the desired dental restoration. Once the desired shape is achieved the structure is then removed from the die. At this stage the structure is referred to as a green structure. The structure is then fired, during the firing process the particulate glass-ceramic material fuses into a solid mass. Because the green structure is formed from multiple layers of the dried glass-ceramic material uneven fusing may result. As a result of this uneven fusing the physical properties of the finished restoration may be detrimentally affected. As a result an inferior dental restoration results. Further, as can be seen from the above description, the overall process is very labor intensive.

Other methods for forming the green restoration have been considered in the prior art, for example, in U.S. Patent no

2,196,258, a mixture of particulate glass and ceramic materials which incorporates a binder is packed into a flexible mold to form a green structure which is then fired to form a finished structure. Again, because the process entails the fusing of particulate material, uneven fusing may result and hence a weakened and inferior dental restoration may result.

To overcome the problems as described above the trade has recognized that in order to produce strong, translucent metal free dental restorations it would be desirable to form these restorations directly from a homogenous molten glass-ceramic material. It was realized that it may be possible to produce a satisfactory restoration by forcing a molten or plastic glass-ceramic material into a mold having a cavity in the form of the desired dental restoration. The prior art further recognized that the glass-ceramic material could be introduced into the cavity when the glass-ceramic material was in the liquid or in the plastic state.

A constant goal of the prior art as described, was to effect the molding process in a quick and efficient manner and in a manner that produces a dental restoration that has excellent definition and fit. In dental restorations definition is extremely important, as in order to have a satisfactory restoration the finest details of the original tooth must be reproduced. For example, for a dental restoration to be successful the margins must be sharp and well defined. It is in this area that the prior art molding processes are deficient in that it was not possible to achieve the

desired degree of definition.

Further, it is desirable to produce a dental restoration in a short period of time in order to efficiently utilize the overhead of the dental laboratory and in order to minimize the labor content of the dental restoration.

Dental laboratories are not typically well funded operations. Therefore, in order to keep cost to a minimum it is highly desirable that a suitable process for forming dental restorations utilize equipment which is relatively inexpensive. While the above described process fits this requirement the below described DICOR process does not.

As is discussed above, there are several prior art processes for the manufacture of dental restorations from glass-ceramic materials. A recent addition to the prior art is the DICOR process as sold by the Dentsply International, Inc. of York Pennsylvania. In this process a dental restoration is formed by centrifugal casting of a molten glass-ceramic material. This process is further described in U.S. Patent No. 4,431,420 issued February 14, 1984 and related patents. Centrifugal casting has been extensively used in the casting of metals principally by the lost wax process. Further, this process has been imminently successful for hundreds of years for use in conjunction with metals. This success results from the fact that molten metals have very low viscosity and high density in the molten state, hence, they function very well in centrifugal casting processes. That is, because molten metals have a high density and a very low viscosity in the molten state

centrifugal force is adequate for purposes of injecting the molten metal into a preformed mold cavity. In an attempt to produce dental restorations which have high definition the above mentioned DICOR process uses centrifugal force to form the desired dental restorations from a molten glass-ceramic material. Molten glass-ceramic materials have a much higher viscosity and a much lower density when compared to molten metals. For this reason, it is not possible to consistently drive a molten glass-ceramic material, by centrifugal force alone into a mold in order to produce a satisfactory dental restoration. That is, a molten glass-ceramic material cannot be driven by centrifugal force into a mold cavity with sufficient force in order to always get the required definition, necessary to form a satisfactory dental restoration. It is well recognized by one skilled in the art that in order to have a satisfactory dental restoration, excellent definition must be achieved in order to recreate the desired margins which are needed for the proper fit of a dental restoration into the human mouth.

Further, the DICOR process, is deficient as to the coloration of the glass-ceramic material utilized. The resulting Dicor dental restoration had an undesirable white color and must be glazed in order to produce satisfactory human coloration. As a result the coloration is only on the surface of the dental restoration, If adjustment by grinding is needed in the final installation of the restoration into the human mouth the glazing is removed thereby exposing the whitish base which contrasts with the glaze. This

contrast is very unsatisfactory from an esthetic point of view.

In contrast to this deficiency, the restoration of the subject process is adapted to utilize glass-ceramic materials wherein the coloration of the resulting dental restoration, throughout, approximates human tooth coloration. Hence, if grinding is necessary in final fitting contrast between the surface of the dental restoration and the underlying base is not observed.

Undesirable contrast can also result from normal wear, where as a result of the grinding action of one tooth against another the glaze is worn away. Again, this is not a problem in this invention as the preferred glass-ceramic material has a uniform natural coloration throughout. It should be noted that the restoration of the subject invention may be glazed to achieve the exact shade desired.

In contrast to the above discussed prior art processes, the process of the subject invention utilizes a positive mechanically applied force for purposes of injecting the molten dental glass-ceramic material into the preformed mold cavity.

For a dental glass-ceramic material to be satisfactory for use in the formation of dental restorations the material should incorporate many or all of the following properties:

1. It must be inert and non-toxic in an oral environment.
2. It must have sufficient structural integrity to resist the forces of mastication and generally must have a 3-point MOR of at least 30,000 PSI.

3. Should be capable of being formed into forms which are compatible with the human anatomy using simple equipment.
4. Should have esthetic qualities (coloration similar to human teeth with a slightly translucent appearance) which are compatible with human teeth and hence should be monolithic or glazable.
5. Further, the glass-ceramic material must not absorb moisture or stain and it must be stress corrosion resistant.
6. Likewise the glass-ceramic material should have wear characteristics which are similar to natural human teeth and should be compatible with other dental materials.
7. The glass-ceramic likewise must have dimensional stability and resist thermal shock during processing and in particular it must have dimensional stability during subsequent heat treating processes wherein recrystallization is effected.
8. Further, the glass-ceramic material should be compatible from a thermal expansion point of view with metals, stains, glazes etc. as are conventionally used to form dental restorations.

9. In order to create an esthetically pleasing dental restoration it may be necessary to alter the final dental restoration to the exact shape and shade desired. In order to effect these alterations the dental restoration must be heated to a temperature of about 950°C for each operation. Therefore, a satisfactory glass-ceramic material must be capable of withstanding multiple heat cycles to about 950°C.
10. A suitable glass-ceramic material must be capable of retaining its structural integrity during heat treating.
11. In summary a suitable glass-ceramic material should have;
- A. Coefficient thermal expansions (C.T.E.) of 5 to $145 \times 10^{-7} / ^\circ\text{C}$
 - B. Translucency of 2.5 to 4.0 on a visible scale of 0 (clear) to 5 (opaque) and overall beauty.
 - C. M.O.R. of at least 30 K.S.I. average.
 - D. Ability to be heat treated to 925-950° C
 - E. Structural integrity during heat treat
 - F. Meltability and formability
 - G. Chemical durability in an oral environment

The subject invention includes glass-ceramic materials which meet the above set forth criteria.

Summary of the invention

In accordance with the above description , it is obvious that in accordance with the prior art it is difficult, if not impossible, to form top quality dental restorations by molding glass-ceramic materials in an inexpensive and efficient manner.

The process, apparatus, compositions and dental restoration of the subject invention provide improvements over the prior art. By use of the process of the subject invention glass-ceramic materials can be readily molded into dental restorations. Further, the apparatus of the subject invention is relatively inexpensive and is easy to utilize. The compositions of the subject invention are highly advantageous in that they produce esthetically pleasing dental restorations which are chemically inert in the human mouth and have outstanding strength properties. Further, the compositions of this invention are advantageous in that when dental restorations formed from these compositions are heat treated they maintain their structural integrity. Further, these dental restorations are capable of withstanding multiple heat cycles to about 950°C, possess thermal expansions which are compatible with the existing porcelains and therefore, these dental restorations can be readily altered using conventional porcelain materials.

Likewise, dental restorations in accordance with the present invention have acceptable coloration after heat treating and can be used at that stage, without further cosmetic treatment, in the mouth. In order to enhance the esthetic properties of the resulting dental restoration, the dental restoration can be readily altered using porcelain materials to achieve any desired effect.

Accordingly, it is an object of the present invention to provide an efficient process whereby dental restorations may be molded from glass-ceramic materials.

It is a further object of the present invention to provide an apparatus for the molding of glass-ceramic dental restorations which is easy to use, is lab friendly, and which is reasonably priced.

It is a further object of the present invention to provide glass-ceramic dental restorations which have outstanding strength and are esthetically pleasing.

It is also an object of this invention to provide glass-ceramic compositions, which are suitable for the formation of dental restorations which have a high degree of micro-structural control during the development of the crystals thereby permitting great flexibility in the forming of these dental restorations.

It is still another object of the present invention to provide a glass-ceramic material which will maintain its structural integrity during heat treating and, in particular, will not slump or sag during heat treating outside of the investment.

Another object of the present inventions is a glass-ceramic

material which is suitable for the formation of dental restorations and which is capable of maintaining its translucency during multiple firing cycles to approximately 950°C.

Still another object of this invention is a process for forming a ceramic dental restoration.

Wherein the process comprises:

- A. placing a glass-ceramic material in a heat-pressure deformable crucible;
- B. heating the crucible and glass-ceramic material to a temperature at which said crucible becomes heat-pressure deformable and the glass-ceramic material is moldable;
- C. bringing the heated crucible into contact with a mold having a preformed cavity therein;
- D. continuing to move the crucible into contact with the mold thereby causing the crucible to deform against the mold, and causing the moldable glass-ceramic material to be injected into said cavity, thereby forming a dental restoration;
- E. cooling the mold and the ceramic dental restoration therein;
- F. removing the formed ceramic restoration from the mold;
- G. heat treating the dental restoration; and
- H. finishing the dental restoration.

Also an object of this invention is to form a heat deformable crucible having a base and a side portion wherein said crucible is formed by the heat sintering of a particulate mixture of glass and

a metal oxide. A preferred composition comprises from about 27 to 31 percent glass and from about 69 to about 73 percent of a metal oxide.

Another object of this invention is a dental restoration which is formed from a glass ceramic material having the following composition (by weight percent);

Li ₂ O	8 - 15
Al ₂ O ₃	1.5 - 5.0
SiO ₂	60 - 85
Na ₂ O	0 - 2
K ₂ O	0 - 2
P ₂ O ₅	1.5 - 5
ZrO ₂	0 - 3
CaO	0 - 1
BaO+SrO+LaO	0 - 12
Coloring oxide	0 - 5

Lastly, an object of the present invention is to create a glass-ceramic material which has excellent chemical durability and as such will not deteriorate when exposed to the fluids in the human mouth.

These and other objects, features and advantageous of the present invention will become apparent from the detailed description herein.

The advantages of the present invention can be more clearly understood from the following description taken together with the drawings.

Brief Description of the Drawings

Figure 1 is a flow chart showing the steps of the preferred embodiment of the process of this invention.

Figure 2 shows a sectioned lost wax mold for use in the invention.

Figure 3 shows a sectioned structure illustrating the heating step of this invention.

Figure 4 shows a sectioned structure illustrating the initial contact of the crucible with the mold.

Figure 5 shows a sectioned structure illustrating the partial sealing of the crucible against the mold.

Figure 6 shows a sectioned structure illustrating the complete sealing of the crucible against the mold and the injection of the molten glass-ceramic into the mold cavity.

Figure 7 is a sectioned side view showing the composite apparatus of this invention.

Figure 7a and 7b are sectional side views showing the preferred composite apparatus of this invention.

Figure 8 shows a sectioned alternate mold.

Figure 9 shows a sectioned alternate mold.

Figure 10 shows the mold of Figure 9 being filled with a molten glass-ceramic.

It should be noted that Figures 2 to 10 are schematic representations of apparatus which may be useful in this invention.

DESCRIPTION OF THE PREFERRED EMBODIMENT

Figure 1 generally describes the overall process of the subject invention wherein dental restorations are formed by the molding of a glass-ceramic material. As can be seen in Figure 1, the first step is the formation of a mold having a suitable mold cavity therein. To start the process whereby the mold cavity is formed the tooth or teeth in the human mouth are prepared by the dentist by procedures which are commonly known in the prior art. By using impressions which are provided by the dentist a positive wax form is produced of the desired dental restoration. This positive wax form is then positioned in a mold usually called a ring. A semi-liquid investment material is then poured around the positive wax form. Once the investment material sets up and cures the resulting mold is placed in a furnace and heated thereby causing the wax to melt and run out of a sprue hole which is integral with the mold. The finished mold is then complete. This constitutes the formation of a mold by the lost wax process.

In the second step of Figure 1 a button of a glass-ceramic material is placed in deformable crucible 8, as is illustrated in Figure 3. The button of glass-ceramic material constitutes a small cylinder of the glass-ceramic material which usually weighs about six grams and has a diameter of about two cm. and a thickness of

about one cm. These buttons of glass-ceramic materials are a convenient shape whereby these materials may be manufactured, sold and used. It is understood by one skilled in the art that a sufficient amount of the glass-ceramic material must be used in order to form the desired dental restoration.

In the third step of Figure 1 crucible 8 and the button of glass-ceramic material 7 is uniformly heated. The glass-ceramic material is heated to a temperature above its liquidus temperature as will be described in greater detail herein below. Further the heat-pressure deformable crucible 8 will be described in greater detail herein below.

In the process of this invention the preformed mold can incorporate multiple cavities in order that more than one dental restoration can be produced during one cycle of the subject process.

In steps four, five and six of Figure 1 the heated crucible and glass-ceramic material are moved into contact with the mold by mechanical means in a manner which will be described in greater detail relative to the discussion of Figures 3 to 6 herein below.

In accordance with steps 7 and 8 of Figure 1 the mold is cooled and the solidified glass-ceramic casting is removed from the investment by mechanical means. The dental restoration is then cut off the sprue and finished by heat treating polishing and/or glazing in order to achieve the desired esthetic effect.

The process of this invention may utilize both glass and glass-ceramic materials for purposes of forming the desired dental

restoration.

For strength and esthetic reasons, it is preferred that a glass-ceramic material be utilized. When a glass-ceramic material is utilized, the button of glass-ceramic material 7 is initially placed in crucible 8 in a glass phase. As heat is applied to crucible 8, glass-ceramic material 7 is heated. As the heating of the glass-ceramic material 7 continues, crystal formation is effected whereby glass-ceramic material 7 becomes a ceramic via the formation of a crystalline phase. As the heating is continued, the glass matrix slowly dissolves the crystalline phase thereby causing the glass-ceramic material 7 to reenter the glass phase. The temperature at which the crystal phase completely dissolves in the glass matrix is defined as the liquidus temperature of the glass-ceramic material. In accordance with this invention, it is found desirable to heat the glass-ceramic material to a temperature above the liquidus temperature in order to eliminate any possibility of the existence of a crystalline phase in the molten material. Further at this temperature the glass-ceramic material has a viscosity of about $\log 3$ to about $\log 4$ P which is suitable to allow the molten glass-ceramic material to be readily injected into the mold cavity 5. The viscosity at this temperature is defined as the working range.

Throughout this application, the viscosity of the molten glass-ceramic materials and of the softened crucible will be defined as the log of the respective viscosity in poises. Further, the unit poise will be abbreviated as P. For example, if the viscosity

of a molten glass-ceramic glass material is 10^4 poises the viscosity will be indicated by $\log 4 P$.

While Figure 1 illustrates the broad process of the subject invention. The individual steps as illustrated in Figure 1 are defined in greater detail in the description of Figures 2 through Figure 10.

In Figure 2, it can be seen that mold 4 has been formed by the placement of an investment material 10 in ring 12. Prior to the placement of investment material 10 in ring 12, ring 12 is positioned around wax form 14, the upper extremity of which is shaped in the form of a desired dental restoration 16. Wax form 14 is only shown in an outline form, as Figure 2 illustrates a finished mold 4 after wax form 14 has been burnt out.

The procedure whereby mold 4 is formed is generally known in the prior art, and has been used for centuries to form lost wax molds for use in metal casting procedures. As is stated above in the preparation of mold 4, wax form 14 is positioned in ring 12 and investment slurry 10 is then slowly poured into ring 12 usually with the aid of vibratory techniques to insure that investment 10 completely fills ring 12, and in particular, completely encases wax form 14. Again, these procedures are commonly known in the prior art.

Figures 3, 4, 5, and 6 show the general process of the subject invention in a schematic form.

Referring to Figure 3, it can be seen that mold 4 having cavity 14 is positioned in the vicinity of crucible 8. Positioned

in crucible 8 is glass-ceramic material 7, the details of which will be described herein. Crucible 8 is further positioned on a ceramic base 21 which is positioned on ram 22 whereby crucible 8 can be moved in relation to mold 4. An electric heating element 24 is further provided whereby heat can be applied to crucible 8. Details of the heating of glass-ceramic material 7 will be discussed herein below.

During the heating of crucible 8 glass-ceramic material 7 is converted from the solid state to the liquid state, and crucible 8 converted from a solid brittle state to a plastic state wherein it is heat-pressure deformable. Once the glass-ceramic material 7 reaches the desired working range, ram 22 is actuated as is illustrated in Figure 4, thereby causing crucible 8 to move upwardly and to come into contact with the lower extremities of mold 4. The actuation of ram 22 is effected by a power source not shown.

As can be seen in Figure 5 as the upward movement of ram 22 continues, crucible 8 continues to deform against mold 4 causing the upper extremities of crucible 8 to seal against mold 4 at interface 28. Further, it can be seen that molten glass-ceramic material 7 has started to flow into mold cavity 14.

Referring to Figure 6, as the travel of ram 22 continues the deformation of crucible 8 against mold 4 is completed, and further cavity 14 is completely filled with glass-ceramic material 7 as a result of the applied pressure of ram 22.

Subsequent to the procedures as are illustrated in Figures 3

through 6, mold 4 is then cooled and the desired dental restoration is removed from investment 10. Once the dental restoration is removed from investment 10, the dental restoration is cut apart from the sprue and is heat treated and finished by polishing and glazing in order to achieve the desired esthetic effect.

Further, after formation dental restoration 26 is heat treated in such a manner that its strength and other properties are enhanced by the formation of crystals in a glass matrix. The details of heat treating are described below.

Figure 7 illustrates apparatus 32 which may be utilized to effect the composite process which is illustrated in the flow chart of Figure 1. This apparatus generally comprises support frame 30, heat source 33, mold retaining means 34 and a plunger 36. Support frame 30 generally comprises the outside frame of apparatus 32.

Mold retaining means 34 comprises a bar 50 into which is threaded mold clamp 35. As can be seen, bar 50 permits mold 4 to be locked to support bar 44. Support bar 44 further incorporates an aperture 56 which is slightly smaller than the diameter of mold 4 and slightly larger than the diameter of crucible 8. By the actuation of ram 36, crucible 8 is moved up into contact with mold 4 in a manner which is similar to that as is described above in conjunction with Figures 4, 5 and 6. The apparatus of figure 7 further incorporates a heat source 33, which in the illustrated embodiment comprises an electric resistance heating element 37. In the preferred embodiment the heating element is molybdenum disilicide. Heat source 33 is controlled by a power control source

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As is illustrated in Figures 3 and 7, an electric resistance heater may be utilized to effect the heating of crucible 8 and, hence, glass-ceramic material 7. In addition to the electric resistance heating, as illustrated heating may be effected via induction heating, gas torch heating, or any other appropriate means.

The apparatus further may incorporate rotating means, not shown, whereby ram 36 may be rotated during the heating process in order to effect a more uniform heating of crucible 8 and glass-ceramic material contained therein. The rotating means may be an electric, pneumatic or hydraulic motor. Ram 36 is further provided with means for effecting its upward movement, which in the preferred embodiment is a pneumatic cylinder 39.

Further, referring to Figure 7, it can be seen that apparatus 32 incorporates a plurality of structural insulating members 41, 43, 45, 47 and 49 which support and contain heating element 37, and contain the heat created during the operation of the element 37. These structural insulating members are formed from ceramic fiber board.

Likewise, it can be seen that support bar 44 incorporates an aperture 56 which has a waist section 55. Waist section 55 is advantageous in that when crucible 8 deforms against mold 4 the deforming upper extremities of crucible 8 are prevented from downward movement at the constriction of waist 55 thereby causing the molten glass-ceramic material to be efficiently injected into

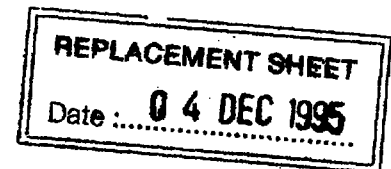
the preformed cavity 14 in mold 4. That is, because upper extremities of crucible 8 are caused to solidify in the vicinity of waist 55, the downward movement of the molten glass-ceramic material is prevented, thereby causing the glass-ceramic material to be injected into mold cavity 14.

Figure 7a and 7b represent the preferred apparatus 31 for use in accordance with this invention. Most of the components of the preferred apparatus 31 are identical or similar to the components of apparatus 32 as discussed herein above. Apparatus 31 differs from apparatus 32 primarily in that a movable arm 38 is provided for wherein a preheated mold 4 may be brought into position for the molding process and positioned against furnace base 41. Moveable arm 38 may be connected to a central pivot point whereby it may be swung into position or it can be laterally moved into position.

Prior to moving arm 38 into position, as is shown in figure 7 a ram 22 is extended in order to place crucible 8 in heat source 33, whereby glass-ceramic material 7 may be melted. Once this melting is effected ram 22 is withdrawn and moveable arm 38 is swung into place to the position as is illustrated in figure 7b. In this position the forming sequence as is shown in Figures 2 to 6 can be completed.

Relative to apparatus 31 and 32 it is understood by one skilled in the art that crucible 8 may be placed in position on ceramic base 21 either manually or by automatic means.

The above described Figures 1 to 7b illustrate the formation of a dental restoration. In addition to being useful in the



formation of essentially complete dental restorations, the composition and process of the subject invention may be used to form copings over which porcelain materials may be applied to alter and shade the dental restoration.

In the prior art, metal copings are extensively utilized. These copings are covered with layers of porcelain materials which are applied to the metal copings for purposes of forming a composite dental restoration which comprises a metal base and a porcelain exterior portion. Composite structures are advantageous in that a metal coping significantly enhances the strength of the resulting dental restoration. Metal copings are disadvantageous in that they are opaque and they have a color which contrasts with the color of a natural tooth and, further, they have toxicity problems in some instances. The use of the subject invention to form an all glass-ceramic dental restoration is advantageous in that the coping is essentially the same color as a natural tooth and, in particular, it is essentially the same color as the porcelain from which the exterior portion of the dental restoration is formed. Further, the all ceramic structure is advantageous in that problems resulting for certain patients who are allergic to certain metals are eliminated. In this procedure, metal free crowns and bridges of outstanding strength and esthetic properties are achieved. The outstanding esthetic properties results from the fact that these glass-ceramic copings can be utilized as a base over which a variety of different porcelains can be fired in order to achieve the most delicate coloration and esthetic properties.

As is stated above, the process of the invention may utilize both glass and glass-ceramic materials. Preferred glass-ceramic compositions for use in accordance with the invention are listed in Tables I to IV. All components listed in Tables I to IV are in weight percent.

The subject invention can utilize any suitable glass-ceramic materials. As is shown in Table I to IV preferred glass-ceramic materials for use in this invention are lithium disilicate glass-ceramic materials. In these materials $\text{Li}_2\text{O} \cdot 2(\text{SiO}_2)$ constitutes the crystalline phase, of the heat treated glass ceramic material. Lithium disilicate glass-ceramic materials are particularly suited for use in the invention in that they are non-toxic, they resist thermal shock, have excellent strength, are corrosion resistant and they produce dental restorations which approximate humane coloration and are translucent and esthetically pleasing. Further, lithium disilicate glass-ceramic materials are advantageous in that they maintain their structural integrity during heat treating, in that they do not slump or sag during proper heat treating.

Other lithium disilicate glass-ceramic materials which may be used in this invention are disclosed in U.S. patent 5,219,799 issued June 15, 1993.

Lithium disilicate glass-ceramic materials may utilize P_2O_5 as a nucleating agent. Other nucleating agents are TiO_2 and ZrO_2 .

Glass-ceramic compositions which may be useful in this invention are as per Table I. The percentages of Table I and the other tables herein are in weight per cent.

TABLE I

Li_2O	8 - 15
Al_2O_3	1.5 - 5.0
SiO_2	60 - 85
Na_2O	0 - 2
K_2O	0 - 2
P_2O_5	1.5 - 5
ZrO_2	0 - 3
CaO	0 - 1
$\text{BaO} + \text{SrO} + \text{LaO}$	0 - 12
Coloring Oxides	0 - 5

More specific glass-ceramic compositions which may be useful in the invention are as per Table II. In particular the compositions of Table II are useful in conjunction with either high or low fusing porcelains which may be used to alter, shade or glaze the dental restorations of this invention.

Table II

Li_2O	10 - 13.5
Al_2O_3	2 - 3
SiO_2	70 - 84
K_2O	0 - 1
P_2O_5	1.5 - 4
ZrO_2	0 - 1

BaO+SrO+LaO	.5 - 4
CaO	0 - 1
Coloring Oxides	0 - 5

In some instances it is desirable to form a dental restoration which can be altered, or glazed with a low fusing porcelain. For purposes of this application a low fusing porcelain is defined as a porcelain which fuses at a temperature of about 700° c

Specific glass-ceramic compositions which are useful in conjunction with low fusing porcelains are as per Table III.

Table III

Li ₂ O	9 - 13
Al ₂ O ₃	1.5 - 4
Si O ₂	65 - 84
Na ₂ O	0 - 1
K ₂ O	0 - 1
P ₂ O ₅	1.5 - 4
Zr O ₂	0 - 1
BaO+SrO+LaO	0 - 12
Ca O	0 - 1
Coloring Oxides	0 - 5

Specific glass-ceramic compositions which may be useful in this invention are as per Table IV.

Date : 04 DEC 1995

Table IV

	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
SiO ₂	81.0	84.0	84.0	83.0	82.0	84.0	81.0	83.0	83.0	81.5	80.0	86.0	84.0	81.0	82.0	82.0	81.0	78.5	80.6	72.5
Al ₂ O ₃	3.5	3.0	3.0	3.0	4.0	3.3	3.3	3.5	3.5	3.0	6.0	1.5		3.0	3.3	3.5	3.0	2.5	2.3	2.5
Li ₂ O	11.0	10.5	10.5	10.5	10.5	10.0	11.0	9.0	8.0	12.0	10.5	10.5	11.0	11.0	10.0	10.0	11.0	10.5	12.5	10.5
P ₂ O ₅	3.0	2.0	2.0	2.0	2.0	1.5	1.5	3.0	3.0	2.0	2.0	2.0	3.0	1.0	1.5	2.2	3.0	2.0	2.0	2.0
ZrO ₂	1.0	0.5		0.5	0.5		2.0			0.5	0.5		1.0	2.0		2.0	1.0	0.5	1.0	0.5
TiO ₂	0.4					0.1	1.0	0.5					0.4	0.4		0.5	0.4	0.1	0.1	0.1
CaO	0.5	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25		0.50	0.50		0.25	0.50	0.35	0.35	0.42
MnO ₂		0.5	0.5	0.5	0.5				0.5	0.5	0.5	0.5								0.75
NiO ₂							0.06											0.02	0.02	
K ₂ O			0.5	0.5	0.5	1.0			1.0	0.5	0.5						0.5	0.5		
Na ₂ O	0.5					0.2	0.2	0.5	0.5						0.2	3.0				
Fe ₂ O ₃						0.09	0.09	0.09								0.09				
BaO															3.0			3.0	0.5	0.0
MgO								1.0												
CaO									1.0									0.4	0.4	0.4

As to a general range of compositions which are preferred for use in conjunction with this invention the glass-ceramic compositions as defined in Table II are preferred.

The most preferred glass-ceramic composition for use in accordance with this invention is the glass-ceramic composition as is defined by composition 18 of Table IV.

The glass-ceramic composition as defined by Table I to IV above are particularly advantageous over the prior art in that;

1. They are stronger than the prior art glass-ceramic compositions.
2. Those compositions which incorporate barium and cerium oxides are florescent in ultra violet light.
3. The expansion rates of many of these glass ceramic compositions are compatable with the expansion rate of existing altering porcelain materials.
4. They retain their structural integrity at higher temperatures than those of the prior art, thereby permitting altering at higher temperatures.

As is listed in Tables I to IV, coloring oxides may be added to the glass-ceramic material in order to achieve the desired coloration of the glass-ceramic dental restoration.

Suitable coloring oxides for use in glass-ceramic compositions which can be used in this invention, some of which are illustrated in Table I to IV are SnO_2 , MnO , CeO , Fe_2O_3 , Ni_2O , V_2O_3 , Cr_2O_3 , TiO_2

etc. These coloring oxides may be used singularly or in combination.

After formation of a glass-ceramic restoration in accordance with the process of this invention, the resulting dental restoration is heat treated in order to effect the formation of crystals in the dental restoration. This crystal formation is generally referred to as heat treating and enhances the physical and esthetic properties of the dental restoration. A suitable heat treating sequence for use with the glass-ceramic compositions of Tables I to IV is as per Table V below.

For the glass compositions which may be used in this invention the best nucleating temperatures are about 25° to 50°C above the upper anneal point of the glass-ceramic. It has also been determined that a slow increase in temperature from just above the upper anneal point to some 50°C. higher produces the best results in achieving maximum nucleation. It is also well known that the temperature then must be raised to a higher temperature to affect crystallization, this temperature depends upon the composition of the particular glass-ceramic material being used.

If the heating sequence in the heat treating stage is improper or is incorrectly controlled the dental restoration may slump or deform. It is understood by one skilled in the art that an optimum heat treating procedure should be developed for each particular glass-ceramic material in order to allow the dental restoration to maintain its structural integrity during the heat treating process.

In the preferred embodiment the heat treat cycle is such that

in the crystalline phase the glass-ceramic material incorporates a large number of fine crystals which are evenly dispersed throughout the glass matrix. It has been found that when the crystalline phase is very fine and evenly dispersed a dental restoration of maximum strength results. Further a fine crystalline structure tends to produce translucent dental restorations.

From the above discussion it is obvious that dental restorations produced in accordance with this invention can be heat treated after the dental restoration is removed from the investment material and the sprue is cut away.

In accordance with an alternate preferred embodiment of this invention the heat treating of the dental restoration may be effected while the dental restoration is still in the invested state. That is heat treating can be effected while the dental restoration is still encased in the investment material.

In accordance with still another embodiment, the dental restoration can be removed from the investment material in which it was formed and finished or partially finished prior to heat treating. For heat treating the material is then reinvested in an investment material which enhances the heat treatment process. After reinvestment the heat treating is carried out in accordance with the procedure described above.

Whenever the dental restoration is heat treated in the invested state the shrinkage of the dental restoration is minimized if not eliminated.

In heat treating and in particular in the formation of a

crystalline phase shrinkage of the dental restoration occurs. This shrinkage can amount to 3 percent. Naturally, this shrinkage is undesirable as it adversely affects the fit of the dental restoration back into the patients mouth.

As a way of overcoming the shrinkage problem, it is within the scope of this invention to invest the wax form in an investment material which expands when it hardens and is heated. That is the investment material expands when it hardens to produce an oversize mold cavity. This oversize mold cavity naturally produces an oversize dental restoration. This oversize dental restoration is then shrunk back to the correct size during the heat treating process.

For example since the glass-ceramic material shrinks about 3 percent during the heat treating process the original wax form may be invested using an investment material which expands about 3 percent when it hardens and is heated. Using this procedure a dental restoration which is 3 percent oversize results. This oversize dental restoration is then heat treated whereupon it shrinks about 3 percent to produce a finished dental restoration of the correct size.

In order to achieve proper fit, if the restoration is to be heat treated after removal from the investment, an investment material which expands on hardening and heating by about 3 percent must be used. Investment materials which are useful with metals are not particularly suited for use in the invention as they only expand about 1.75 percent. Investments which expand about 3

percent upon hardening and heating and hence permit this type of process are manufactured by Whipmix Corporation of Louville, Ky. and sold under the designation GIJM 3-23-94; 1

The preferred heat treating process for use with the glass-ceramic compositions of Table I to IV is as per Table V

TABLE V

Heat Restoration To	500
Ramp or Soak at	500 - 600°C for 2 - 6 hours
Ramp at	600 - 925°C for 2 - 3 hours
Soak at	925°C for 1 - 2 hours
Cool to	Room temperature

After heat treating the resulting dental restoration may be further finished. This finishing may include a step wherein the dental restoration is altered with one or more porcelains in order to achieve the precise shape, shade and shading desired. For those glass-ceramic materials of Tables I to IV which have a C.T.E. (Coefficient of Thermal Expansion) of from about 135 to about 145 at the set point temperature, it is desired that the C.T.E. of the altering porcelain material be from about 125 to about 135 and always less the C.T.E. of the glass ceramic material. The process wherein the C.T.E. is measured is defined in the description of the Examples herein below.

Deformable crucible 8 is a critical part of the subject

invention. Crucible 8 in its preferred embodiment has a circular base and hence is generally cylindrical. However it is understood by one skilled in the art that the crucible of this invention can have configurations other than circular. The crucible is formed by heat sintering a particulate mixture of components, such as, fused silica, aluminum oxide, zirconium oxide, magnesium oxide with a glass such as borosilicate glass, soda lime glass, bottle glass, window glass, etc., clay or other materials that those skilled in the art of crucible making might use, to form a crucible suitable for use with a glass-ceramic material. In the broad concept of this invention one forms the crucible of a mixture of materials, such that, at the temperature where the glass-ceramic material is in the working range of about $\log 3$ to $\log 4$ P the crucible has a viscosity of about $\log 5$ to $\log 7$ P.

Crucibles for use in this invention are formed by slip casting. The formation of crucibles by slip casting is well known to those skilled in the art and is described in greater detail in the Examples below.

In the description, as set forth above, the compositions which are used to form crucibles which are useful in this invention may utilize a wide range of materials. While many glasses can be used to form crucibles which are useful in the subject invention, because of their toxicity, glasses which contain heavy metals such as lead, cadmium etc. should not be used.

An alternate method for the formation of crucibles for use in this invention is by powder pressing and then sintered.

In this invention the composition from which the crucible is formed contains materials such that it will be heat-pressure deformable at the desired temperature i.e. about log 3 to log 4 P working temperature of the glass-ceramic. The heat-pressure deformation properties of the crucibles used in this invention is to be contrasted with the crucibles of the prior art which are designed to be rigid at the working temperature of the glass-ceramic material which is contained therein.

In the alternate structure, as is shown in Figures 8, 9, and 10, the sealing of the deformed crucible against the mold is enhanced. In the structure as shown, mold 64 incorporates a circular depression 66 having vertical walls 68 and 70 to which crucible 8 may seal. Vertical walls 72 and 74 of mold 65 may further incorporate a plurality of annular grooves 76. As is further shown in Figure 10, the sealing of crucible 8 against mold 65 is enhanced by the flowing of the upper extremities of crucible 8 into annular grooves 76 during the deformation process.

EXAMPLES

The present invention is illustrated by the following Examples however, these examples are not to be construed as limiting the invention.

Dental restorations were prepared in accordance with the below listed examples. In these examples wax models of a tooth were prepared. A sprue was then attached to the wax model. The wax model with the sprue attached was then placed in an investment

ring. An investment material was then prepared by mixing 90 gram of Kerr Thermovest with 17 ml of a mixture of 2 parts of Thermovest liquid with 1 part water. The resulting mixture was then mixed to a uniform consistency. The mixed investment was then vibrated into the investment ring and around the wax model. The mold was allowed to dry and harden overnight. The investment ring was then placed in a burn out furnace at room temperature and the temperature raised to 600°C where upon the wax model was burnt out of the investment material.

The crucibles as used in these examples were prepared by slip casting. In this process a female plaster of paris mold was prepared by mixing 1247.4 grams of plaster of paris with 946 ml of water to a uniform consistency. The resulting mold was allowed to harden for 36 hours. A slurry of a particulate crucible formulation mixture, as is identified in the examples below was then placed in the preformed plaster of paris mold. The green crucible was removed from the mold and fired in a furnace for 15 minutes at 1100°C to sinter the crucible to a hardened more durable form.

The slurry used to form the crucible was formed by mixing 1 pound of particulate material with 160 ml water.

Because of the hyorasiopic nature of the plaster of paris mold the particulate crucible formulation slurry coagulates in the plaster of paris mold. When the desired crucible wall thickness was achieved the remainder of the slurry was poured out of the mold resulting in a green crucible structure which was allowed to dry.

In the listed examples and in this application, the coefficient of thermal expansion (C.T.E.) was measured from room temperature to 250°C and is reported in units of $\times 10^{-7} / ^\circ\text{C}$.

The translucency of the resulting dental restoration was measured by visual inspection given a value of 0 to 5 wherein value of 0 was deemed to be perfectly clear and 5 was deemed to be opaque.

In the below listed Examples for purposes of injecting the molten glass and glass ceramic material into the mold a pressure of 30 P.S.I. was utilized, with the exception of Examples 26, and 27 wherein a pressure of about 50 P.S.I. was utilized.

The referenced heat treating sequence for all Examples except Examples 26, and 27 is in accordance with Table IV above.

In the below Examples the glass-ceramic test rods for measuring modules of rupture (MOR) and thermal expansion (C.T.E) were formed along with color tab test samples. These test rods and color tab samples were subjected to the heat treatment process of Table VI whereby the glasses were crystallized in situ to glass-ceramics. The test rod samples were .120" X 1.25". The Examples also record the visual appearance of each glass-ceramic and values of various properties exhibited by the glass-ceramic, such as, linear coefficient of thermal expansion (C.T.E.), reported in terms of $\times 10^{-7} / ^\circ\text{C}$, modules of rupture (MOR), cited in terms of K.S.I. (thousands of pounds per square inch) as determined in accordance with measurement techniques conventional in the art. K.S.I. may be converted to its metric equivalent MPa by dividing K.S.I. by .145.



The components used in these Examples are as follows:

Thermovest and Therovest Liquid as sold by Kerr Manufacturing Co. Romulus, Mi. 48174.

3I Fused Silica as sold by Harbison Walker Refractories division of Indresco Inc., Pittsburg, Pa. 15223.

SP921 TF (borosilicate glass) as sold by Specialty Glass Inc. of Oldsmar, Florida and has the following compositions in weight percent.

TABLE VI

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

Example 1

An attempt was made to form a Glass-ceramic dental restoration in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 90.8 grams of SP921TF glass in 363.2 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6. The crucible cracked and hence no dental restoration was formed.

Example 2

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 136.2 grams of SP921TF glass and 317.8 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650° C.

The composition of the glass-ceramic material used is in accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400° C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting dental restoration had excellent definition and a M.O.R. of 41 K.S.I., a C.T.E. of 148, a translucency of 3.5 and a softening temperature of 975° c.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold.

Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Additional tests were conducted wherein it was determined that the crucible of this Example deformed and sealed well at 1375 and 1425°C

Example 3

A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 181.6 grams of SP921TF glass and 272.4 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The preheated crucible without glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes.

During the heating process, the crucible lost its structural integrity and was not capable of effecting a seal with a mold. Therefore, no molding process was carried out.

Example 4

A mold was prepared in accordance with the procedure described

above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 227 grams of SP921TF glass and 227 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes.

During the heating process, the crucible melted and hence was not capable of forming an effective seal with the mold. Therefore, no molding process was carried out.

Example 5

Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 118 grams of SP921TF glass and 336 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The composition of the glass-ceramic material used is in

accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400° C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting dental restoration had excellent definition and physical properties as are reported with Example 2.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform. Further tests were conducted on crucibles having the composition as set forth above wherein it was determined that the crucible cracked and hence was not functional at 1375°C. An additional test demonstrated that the crucible of this example deformed and sealed at 1425°C.

Example 6

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance

with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 127.1 grams of SP921TF glass and 336.9 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The composition of the glass-ceramic material used is in accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400° C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting dental restoration had excellent definition and physical properties as are in accordance with Example 2.

During the forming process, the crucible retained its structural integrity and formed an effective seal for the mold. Further, during the heat treating process, the dental restoration retained its structural integrity and did not slump or deform. Additional tests were conducted on the crucible of this example wherein it was determined that the crucible would deform and seal at both 1375 and 1425°C.

Example 7

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure described above by mixing 145.3 grams of SP921TF glass and 308.7 grams of 3I fused silica with 160 ml of water. After slip casting and drying, the crucible was sintered at a temperature of 1100° C. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650°C.

The composition of the glass-ceramic material used is in accordance with composition #1 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400° C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting dental restoration had excellent definition and physical properties as are reported in accordance with example 2.

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During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the dental restoration retained its structural integrity and did not slump or deform. Additional tests were conducted on the crucible of this Example wherein it was determined that the crucible functioned at 1375°C. However at 1425°C the crucible slumped and hence could not be used in the process of this invention.

Example 3

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and description described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #2 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is

illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heated treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 46.7 K.S.I., a C.T.E. of 138 a translucency of 2.75 and a softening temperature of 975° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Example 9

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and description described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #3 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7

and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heated treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 43 K.S.I., a C.T.E. of 141 a translucency of 3.0 and a softening temperature of 975°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Example 10

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and description described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #4 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heated treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 48 K.S.I., a C.T.E. of 133 a translucency of 2.5 and a softening temperature of 975°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Example 11

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #5 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 42 K.S.I., a C.T.E. of 140 a translucency of 2.5 and a softening temperature of 975°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Example 12

A Glass-ceramic dental restoration was prepared in accordance

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with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #6 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 41.5 K.S.I., a C.T.E. of 162 a translucency of 4 and a softening temperature of 950°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

Example 13

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material is in accordance with a composition #7 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heated treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 53.5 K.S.I., a C.T.E. of 136 a translucency of 4.0 and a softening temperature of 950° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental

restoration retained its structural integrity and did not slump or deform during heat treating.

Example 14

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The glass-ceramic material used was Di-Cor as sold by the Densply Corporation and as is described above. Di-Cor is thought to be fluoró-mica glass-ceramic.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated in the investment.

While the glass-ceramic properly filled the mold the resulting dental restoration cracked as a result of shrinkage during the heat

treating process. This cracking is thought to result from the fact that the forming investment was not suitable for use in the heat treating sequence.

Example 15

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 2. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass used in weight percent was;

TABLE VII

SiO ₂	50.2
B ₂ O ₃	8.6
AlF ₃	.7
Al ₂ O ₃	16.0
BaO	4.75
ZnO	19.75

The preheated crucible and glass-ceramic material was then

placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1400°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

A satisfactory dental restoration resulted which was then removed from the investment material cut apart from the sprue.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 4 K.S.I., a C.T.E. of 56 a translucency of 0.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Because the material used was a glass the resulting dental restoration was not heat treated.

Example 16

Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 8 of Table IV. After melting, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 30 K.S.I., a C.T.E. of 157, a translucency of 40 and a softening temperature of 925°C.

The test samples cracked during heat treating therefore the composition was deemed to be unsuitable as a material for use in

preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 17

A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 9 of Table IV. After melting, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 24 K.S.I., a C.T.E. of 145, and a softening temperature of 975°C.

Because the test samples had a M.O.R. of only 24 and the glass-ceramic was hard to melt and form the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 18

A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 10 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test

samples had a M.O.R. of 41.4 K.S.I., a C.T.E. of 129, a translucency of 2.5 and a softening temperature of 975°C.

Because the test samples had a C.T.E. of less than 130 the composition may not be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 19

A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 11 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 35 K.S.I., a C.T.E. of 80, a translucency of 3.5 and a softening temperature of 975°C.

Because the test samples had a C.T.E. of 80 the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 20

A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 12 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 31 K.S.I., a C.T.E. of 127, and a translucency of 2.5.

Because the test samples had a C.T.E. of 127 therefore the composition may not be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 21

A Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 13 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 32 K.S.I., a C.T.E. of 256, and a translucency of 5.

Because the test samples had a C.T.E. of 256 the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 22

Glass-ceramic dental composition was prepared and heat treated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 14 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a M.O.R. of 13 K.S.I., a C.T.E. of 126, and a translucency of 4.5.

Because the test samples had a low C.T.E. and a low M.O.R. the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 23

A Glass-ceramic dental composition was prepared and elevated in accordance with this invention. The composition of the glass-ceramic material is in accordance with the composition No. 15 of Table IV. After preparation, test samples were prepared in accordance with the procedure described above. The resulting test samples had a translucency of 5.0.

Because the test samples turned opaque during heat treating therefore the composition was deemed to be unsuitable as a material for use in preparation of dental restorations, accordingly, further tests were not carried out and a dental restoration was not formed.

Example 24

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #16 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1425°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 35 K.S.I., a C.T.E. of 148 translucency of 3.5 and a softening temperature of 950° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental

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restoration retained its structural integrity and did not slump or deform during heat treating.

The investment material utilized was Whipmix GTJM 3-23-94; As described herein above. The investment material had an expansion rate of about 3%. As a result of this expansion rate the resulting dental restoration had excellent fit.

Example 25

Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and preheated to a temperature of 650 °C.

The composition of the glass-ceramic material used is in accordance with composition #17 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1425°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated in the investment material.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 40 K.S.I., a C.T.E. of 138 a translucency of 3.5 and a softening temperature of 950° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

The investment material utilized was Thermovest and after heat treating was removed and the resulting dental restoration had excellent fit.

Example 26

A glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible.

The composition of the glass-ceramic material used is in accordance with composition 18 of Table IV.

The crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figures 7a and 7b and heated to a temperature of 1425° C for a period of 5 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 47 K.S.I., a translucency of 4.0 and a softening temperature of 950° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental

restoration retained its structural integrity and did not slump or deform during heat treating.

The investment material utilized was Whipmix GTJM 3-23-94; As described herein above. The investment material had an expansion rate of about 3%. As a result of this expansion rate the resulting dental restoration had excellent fit.

Example 27

A Glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was then placed in the crucible and not preheated .

The composition of the glass-ceramic material used is in accordance with composition 19 of Table IV.

The crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figures 7a and 7b and heated to a temperature of 1425° C for a period of 5 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then removed from the investment material cut apart from the sprue and heat treated.

The resulting test samples and dental restoration had excellent definition and a M.O.R. of 52 K.S.I., a translucency of 3.5 and a softening temperature of 950 ° C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

The investment material utilized was Whipmix GTJM 3-23-94; As described herein above. The investment material had a total expansion rate of about 3%. As a result of this expansion rate the resulting dental restoration had excellent fit.

Examples 26 and 27 represent the preferred process and glass ceramic compositions in accordance with this invention. As is mentioned the resulting dental restorations of these Examples were heat treated the heat treating procedure used for Examples 26 and 27 is per Table VIII.

Table VIII

Heat Dental Restoration to	450° C at furnace rate
Ramp or soak at	450-550° C for 6 hours
Ramp at	550-850° C for 2 hours
Hold at	850° C for 45 minutes
Ramp at	850-900° C at furnace rate
Soak at	900° C for 15 minutes
Cool to	Room Temperature

After heat treating the dental restorations of Examples 26 and 27 were further finished by altering the shape and shade with a high fusing porcelain sold under the trademark Ceramco II and a low fusing porcelain sold under the trademark Final Touch. Both of the high and low fusing porcelains fired and adhered well. Likewise, both porcelains had thermal expansions which were compatible with the glass-ceramics from which the dental restorations were formed.

The Ceramco II and Final Touch porcelains as used herein are manufactured and sold by Ceramco, Inc. of six Terri Lane, Burlington, N.J. 08016.

Relative to the dental restorations as were produced in accordance with Examples 26 and 27 above it should be noted that these restorations were exceptionally strong in that they had M.O.R. ratings of about 50 K.S.I.

It should be noted that the M.O.R. ratings of Examples 26 and 27 do not correlate with the M.O.R. ratings as are specified relative to the other examples in that a different test protocol was used for measuring the M.O.R. of Examples 26 and 27. The M.O.R. for Examples 26 and 27 were tested on a Lloyd Instrument type No.TG 18 as manufactured by John Chatillon & Sons Inc. of Greensboro, N.C.. These measurements were made in accordance with I.S.O test No. 6872 using cylindrical bars of 0.125" diameter with a 1" span, 3 point bending with a crosshead speed of 1 m.m. per minute.

In contrast the M.O.R. measurements of the other Examples were made on a piece of equipment which was manufactured by the

applicant. This piece of equipment has characteristics which are similar to those of the above described Lloyd instrument type No. TG 18 and used the same test bars. Generally it could be said that the M.O.R. rating of those Examples other than Examples 26 and 27 appear to be low.

For a correlation between the M.O.R. test protocol of Examples 26 and 27 and the test protocol of the other Examples Table IX should be referred to

Table IX

Example No.	Reported M.O.R. As per test used for Examples 1-25	M.O.R. as per. I.S.O. Test No. 6872
26	42	47
27	45	52

Example 28

A glass-ceramic dental restoration was prepared in accordance with the following procedure. A mold was prepared in accordance with the procedure described above.

By use of slip casting techniques, a crucible was prepared in accordance with the procedure and composition described above in connection with Example 6. A glass button weighing 6 grams was

then placed in the crucible and preheated to a temperature of 650°C.

The composition of the glass-ceramic material used is in accordance with composition 10 of Table IV.

The preheated crucible and glass-ceramic material was then placed in an apparatus which is similar to that shown in Figure 7 and heated to a temperature of 1425°C for a period of 10 minutes. The ram was then actuated, the crucible was brought into contact with the mold in accordance with the general procedure as is illustrated in Figures 3 through 6.

The dental restoration was then heat treated.

The resulting test samples and dental restoration had excellent definition and a C.T.E. of 111 a translucency of 3.5 and a softening temperature of 850°C.

During the forming process, the crucible retained its structural integrity and formed an effective seal with the mold. Further, during the heat treating process, the finished dental restoration retained its structural integrity and did not slump or deform during heat treating.

It should be understood that the invention is not limited to the embodiment shown and described in Figures 1-10 and examples 1 to 28 since the process and composition parameters can be varied and the configuration of the apparatus can be altered without departing from the scope of the invention.

The above description and drawings are illustrative only since



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modifications could be made without departing from the present invention, the scope of which is to be limited only by the following claims.

**WHAT IS CLAIMED:**

1. A process for forming a ceramic dental restoration comprising the steps of;

a. Placing a glass-ceramic material in a heat-pressure deformable crucible,

b. Heating the crucible and glass-ceramic material to a temperature at which said crucible becomes heat-pressure deformable and the glass-ceramic material is moldable,

c. Bringing the heated crucible into contact with the sprue end of a mold having a preformed cavity therein,

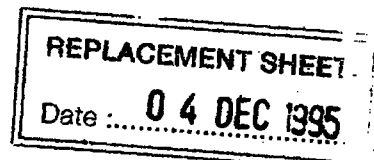
d. Continue to move the crucible into contact with the mold thereby causing the crucible to deform against the mold, and causing a seal to form there between and causing the moldable glass-ceramic material to be injected into said cavity, thereby forming a dental restoration,

e. Cooling the mold and the glass- ceramic dental restoration therein.

f. Removing the formed ceramic restoration from the mold,



- g. Heat treating the dental restoration
- h. Finishing the dental restoration .
2. The process of claim 1 wherein the crucible containing the glass ceramic material therein and the mold are axially disposed in relation to each other.
 3. The process of claim 1 wherein the crucible containing the glass-ceramic material therein and the mold are vertically disposed in relation to each other.
 4. The process of claim 1 wherein the dental restoration is heat treated in the mold.
 5. The process of claim 1 wherein the dental restoration is removed from the mold and reinserted prior to heat treating.
 6. The process of claim 1 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P and the crucible has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.
 7. The process of claim 2 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P



and the crucible and has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.

8. The process of claim 3 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P and the crucible and has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.
9. The process of claim 4 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P and the crucible and has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.
10. The process of claim 5 wherein the glass-ceramic material is heated to a temperature above its liquidus temperature, to a working range where its viscosity is about log 3 to about 4 P and the crucible and has a viscosity of about log 5 to about 7 P at the working range of the glass-ceramic material.
11. The process of claim 1 wherein the glass-ceramic material has the following composition (by weight percent)

Li ₂ O	8 - 15
Al ₂ O ₃	1.5 - 5.0



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SiO ₂	60 - 85
Na ₂ O	0 - 2
K ₂ O	0 - 2
P ₂ O ₅	1.5 - 5
ZrO ₂	0 - 3
CaO	0 - 1
BaO+SrO+LiO	0 - 12
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to 74 percent of fused silica and from about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent)

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

12. The process of claim 2 wherein the glass-ceramic material has the following composition (by weight percent)

Li ₂ O	8 - 15
Al ₂ O ₃	1.5 - 5.0
SiO ₂	60 - 85



Na ₂ O	0 - 2
K ₂ O	0 - 2
P ₂ O ₅	1.5 - 5
ZrO ₂	0 - 3
CaO	0 - 1
BaO+SrO+LiO	0 - 12
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to about 74 percent of fused silica and from about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

13. The process of claim 3 wherein the glass-ceramic material has the following composition (by weight percent)

Li ₂ O	8 - 15
Al ₂ O ₃	1.5 - 5.0
SiO ₂	60 - 85



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Na ₂ O	0 - 2
K ₂ O	0 - 2
P ₂ O ₅	1.5 - 5
ZrO ₂	0 - 3
CaO	0 - 1
BaO+SrO+LiO	0 - 12
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to about 74 percent of fused silica and about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

14. The process of claim 6 wherein the glass-ceramic material has the following composition (by weight percent)

Li ₂ O	8 - 15
Al ₂ O ₃	1.5 - 5.0



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SiO ₂	60 - 85
Na ₂ O	0 - 2
K ₂ O	0 - 2
P ₂ O ₅	1.5 - 2.5
ZrO ₂	0 - 3
CaO	0 - 1
BaO+SrO+LiO	0 - 12
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to about 74 percent of fused silica and from about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent)

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

15. The process of claim 6 wherein the glass-ceramic material has the following composition (by weight percent)

Li ₂ O	10 - 13.5
Al ₂ O ₃	2 - 3.0



REPLACEMENT SHEET

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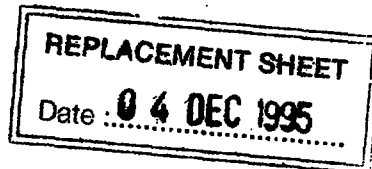
SiO ₂	75 - 84
K ₂ O	0 - 1
P ₂ O ₅	1.5 - 4
ZrO ₂	0 - 1
CaO	0 - 1
BaO+SrO+LiO	.5 - 4
Coloring Oxides	0 - 5

and the crucible is formed by the heat sintering of a particulate mixture of from about 68 to about 74 percent of fused silica and from about 26 to about 32 percent of a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

and the glass-ceramic restoration is heat treating to affect crystal formation.

16. The dental restoration which is formed from the process of claim 1.
17. The dental restoration which is formed from the process of claim 2.



18. The dental restoration which is formed from the process of claim 3.
19. The dental restoration which is formed from the process of claim 4.
20. The dental restoration which is formed from the process of claim 5.
21. An apparatus which is suitable for the formation of a dental restoration which comprises a mold having a cavity therein, a means for retaining said mold in a fixed position, a heat deformable crucible containing a molten glass-ceramic material therein, a means for supporting said crucible, a means for uniformly heating said crucible and said glass-ceramic material, and a means for bringing said crucible into contact with said mold thereby causing said crucible to deform and seal against mold and causing the molten glass-ceramic material to be injected into the cavity which is integral with the mold.
22. The apparatus for claim 21 wherein means are provided for rotating the crucible while it is being heated in order to facilitate its uniform heating.
23. The apparatus of claim 21 wherein means are provided for



automatically controlling the uniform heating of the crucible in accordance with a predetermined cycle and a means are provided for automatically moving said crucible into contact with said mold in accordance with a predetermined cycle.

24. The apparatus of claim 22 wherein means are provided for automatically controlling the uniform heating of the crucible in accordance with a predetermined cycle and a means are provided for automatically moving said crucible into contact with said mold in accordance with a predetermined cycle.
25. The apparatus of claim 21 which further incorporates a waisted aperture wherein the crucible is guided into contact with the mold.
26. A heat deformable crucible having a base and a side portion wherein said crucible is formed by the heat sintering of a particulate mixture of a glass and a metal oxide.
27. The heat deformable crucible of claim 26 wherein the percentage of the particulate mixture comprises from about 26 to about 32 percent glass and from about 68 to about 74 percent of a metal oxide.
28. The heat deformable crucible of claim 26 wherein the glass is a borosilicate glass.



29. The heat deformable crucible of claim 27 wherein the glass is a borosilicate glass.
30. The heat deformable crucible of claim 26 wherein the metal oxide is silica.
31. The heat deformable crucible of claim 27 wherein the metal oxide is silica.
32. The heat deformable crucible of claim 28 wherein the metal oxide is silica.
33. The heat deformable crucible of claim 29 wherein the metal oxide is silica.
34. The heat deformable crucible of claim 26 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

35. The heat deformable crucible of claim 27 wherein the glass is a borosilicate glass having the following composition (by



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weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

36. The heat deformable crucible of claim 30 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

37. The heat deformable crucible of claim 31 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
B ₂ O ₃	15
Al ₂ O ₃	2.5
Na ₂ O	4.5

38. The heat deformable crucible of claim 32 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO ₂	78
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B_2O_3	15
Al_2O_3	2.5
Na_2O	4.5

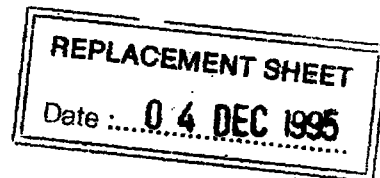
39. The heat deformable crucible of claim 33 wherein the glass is a borosilicate glass having the following composition (by weight percent).

SiO_2	78
B_2O_3	15
Al_2O_3	2.5
Na_2O	4.5

40. The heat deformable crucible of claim 36 wherein the particulate mixture comprises 28 percent borosilicate glass and 72 percent silica.

41. The process of claim 1 wherein the sprue end of the mold incorporates a circular cavity which interacts with the crucible when the deformable crucible is brought into contact with the mold.

42. The process of claim 1 wherein the sprue end of the mold incorporates a circular cavity the axis of which is parallel with the axis of the mold, the outer edges of said cavity having a plurality of annular grooves, which interact with the crucible when the deformable crucible is brought into contact

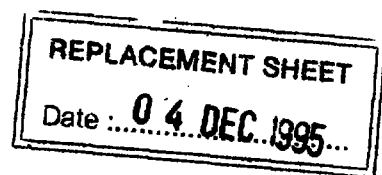


with the mold.

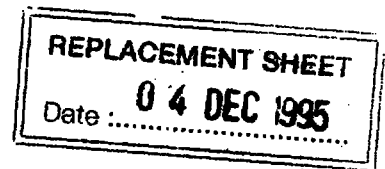
43. The process of claim 1 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
44. The process of claim 6 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
45. The process of claim 7 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
46. The process of claim 8 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
47. The process of claim 9 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point. .



48. The process of claim 10 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
49. The process of claim 14 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains, having C.T.E.'s of from about 125 to 135 at their set point.
50. The process of claim 15 wherein the finishing of the dental restoration includes the altering of said dental restoration with one or more porcelains having C.T.E.'s of from about 125 to 135 at their set point.
51. The process of claim 1 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
52. The process of claim 6 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.



53. The process of claim 7 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
54. The process of claim 8 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
55. The process of claim 9 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
56. The process of claim 10 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.
57. The process of claim 14 wherein the preformed cavity is formed by investing a wax model in an investment which



expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax out of the cavity.

58. The process of claim 15 wherein the preformed cavity is formed by investing a wax model in an investment which expands about 3 per cent upon hardening and heating and removing the wax model from the cavity by burning the wax model out of the cavity.

59. The process of claim 6 wherein the glass-ceramic material has the following composition (by weight percent)

SiO ₂	78.5
Al ₂ O ₃	2.5
LiO ₂	10.5
K ₂ O	0.5
P ₂ O ₅	2.0
ZiO ₂	0.5
CeO	.35
NiO ₂	.02
TiO ₂	0.1
BaO	3.0
CaO	0.4

60. A dental restoration which is formed from a glass- ceramic material having the following composition (by weight



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percent);

Li_2O	8 - 15
Al_2O_3	1.5 - 5.0
Si O_2	60 - 85
Na_2O	0 - 2
K_2O	0 - 2
P_2O_5	1.5 - 5
ZrO_2	0 - 3
CaO	0 - 1
$\text{BaO}+\text{SrO}+\text{LaO}$	0 - 12
Coloring Oxide	0 - 5

61. A dental restoration which is formed from a glass- ceramic material having the following compopsition (by weight percent);

Li_2O	10 - 13.5
Al_2O_3	2 - 3
SiO_2	70 - 84
K_2O	0 - 1
P_2O_5	1.5 - 4
ZrO_2	0 - 1
$\text{Ba}+\text{SrO}+\text{LaO}$	.5 - 4
CaO	0 - 1
Coloring Oxides	0 - 5

62. A dental restoration which is formed from a glass ceramic



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material having the following composition (by weight percent);

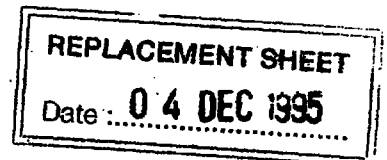
Li ₂ O	9 - 13
Al ₂ O ₃	1.5 - 4
SiO ₂	65 - 84
Na ₂ O	0 - 1
K ₂ O	0 - 1
P ₂ O ₅	1.5 - 4
ZrO ₂	0 - 1
BaO+SrO+LaO	0 - 12
CaO	0 - 1
Coloring Oxides	0 - 5

63. A dental restoration which if formed from a glass ceramic material having the following composition (by weight percent);

Li ₂ O	10.5
Al ₂ O ₃	2.5
SiO ₂	78.5
K ₂ O	0.5
P ₂ O ₅	2.0
ZrO ₂	0.5
TiO ₂	0.1
CaO	0.35
NiO ₂	0.02
BaO	3.0



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CaO

0.4

64. The dental restoration of claim 60 which is altered with a porcelain material which has a C.T.E. which is slightly less than the C.T.E. of the glass ceramic material.
65. The dental restoration of claim 61 which is altered with a porcelain material which has a C.T.E. which is slightly less than the C.T.E. of the glass ceramic material.
66. The dental restoration of claim 62 which is altered with a porcelain material which has a C.T.E. which is slightly less than the C.T.E. of the glass ceramic material.
67. The dental restoration of claim 63 which is altered with a porcelain material which has a C.T.E. which is slightly less than the C.T.E. of the glass ceramic material.
68. The dental restoration of claim 60 wherein the resulting dental restoration has a M.O.R. of at least 30 K.S.I.
69. The dental restoration of claim 61 wherein the resulting dental restoration has a M.O.R. of at least 30 K.S.I.
70. The dental restoration of claim 62 wherein the resulting dental restoration has a M.O.R. of at least 30 K.S.I.



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71. The dental restoration of claim 63 wherein the resulting dental restoration has a M.O.R. of at least 40 K.S.I.

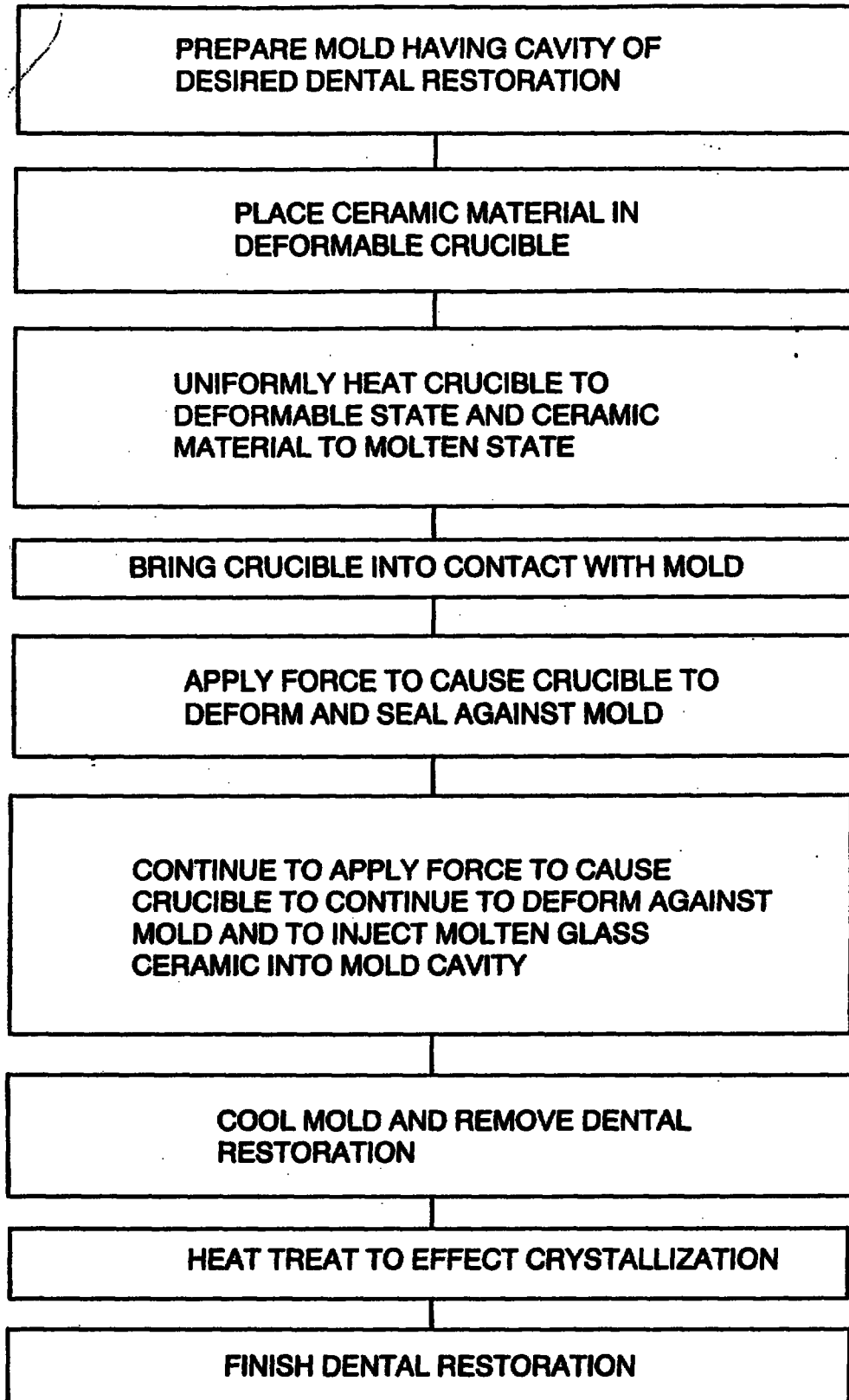


Fig. 1

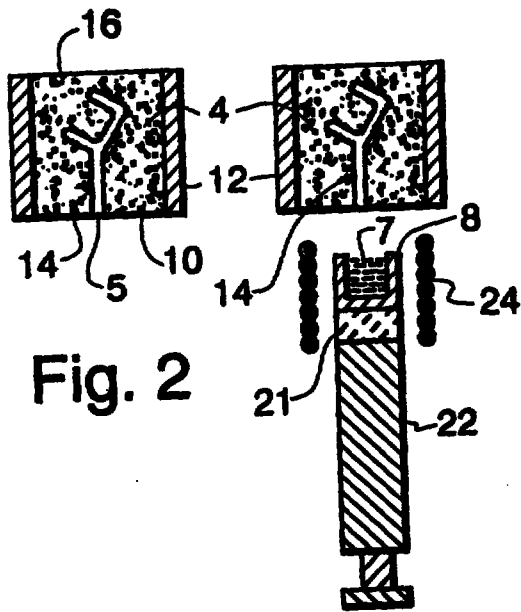


Fig. 2

Fig. 3

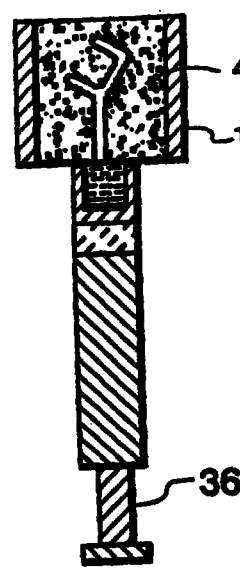


Fig. 4

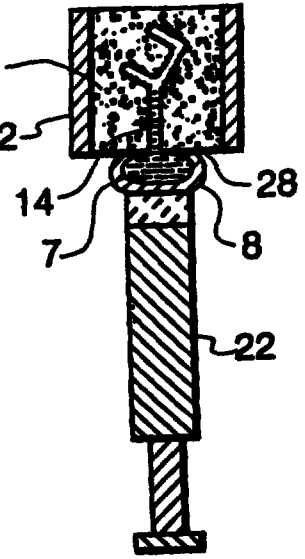


Fig. 5

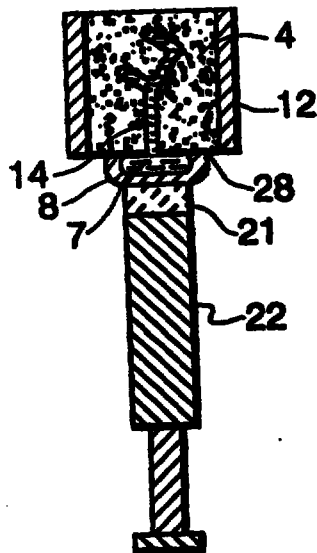


Fig. 6

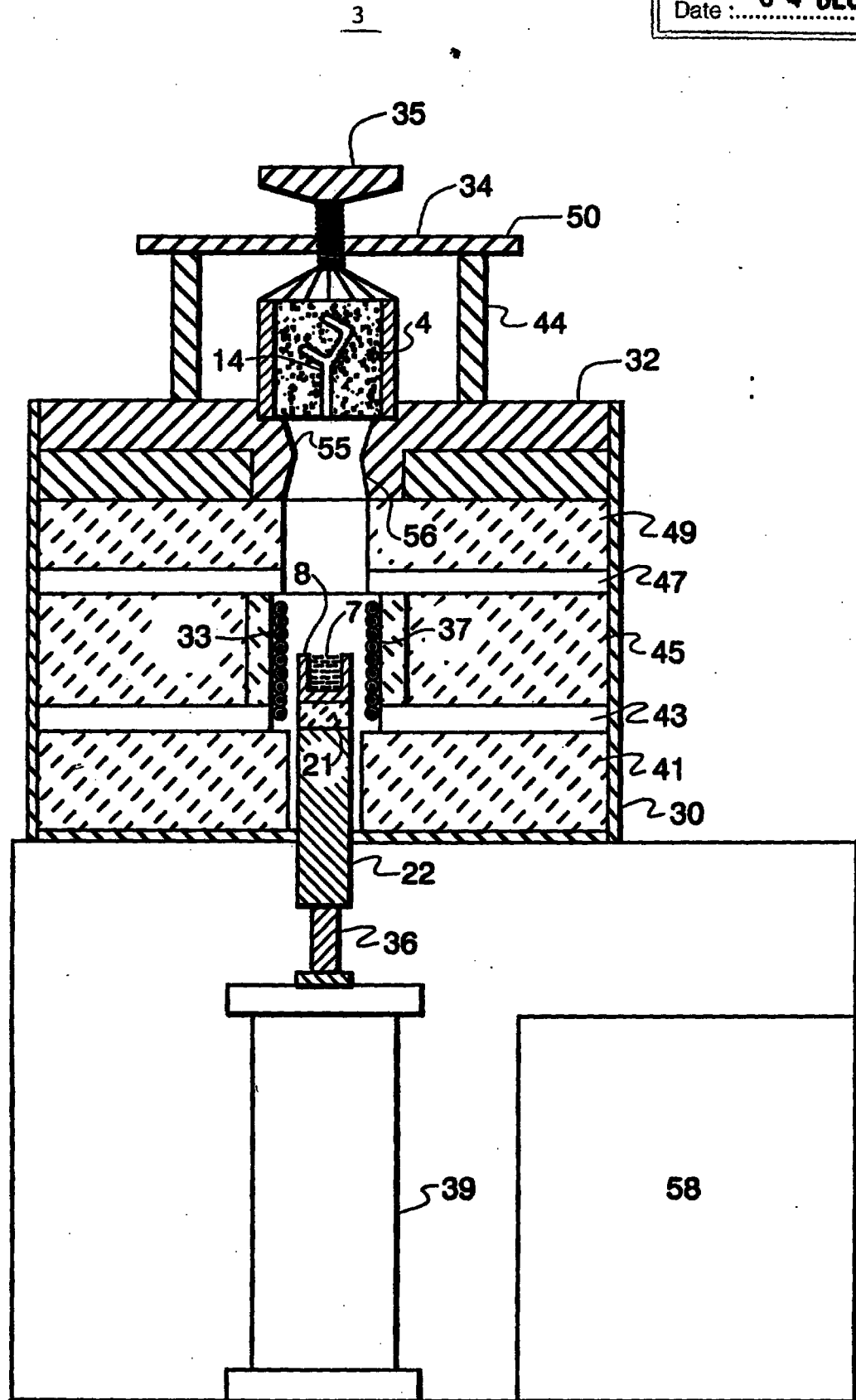


Fig. 7

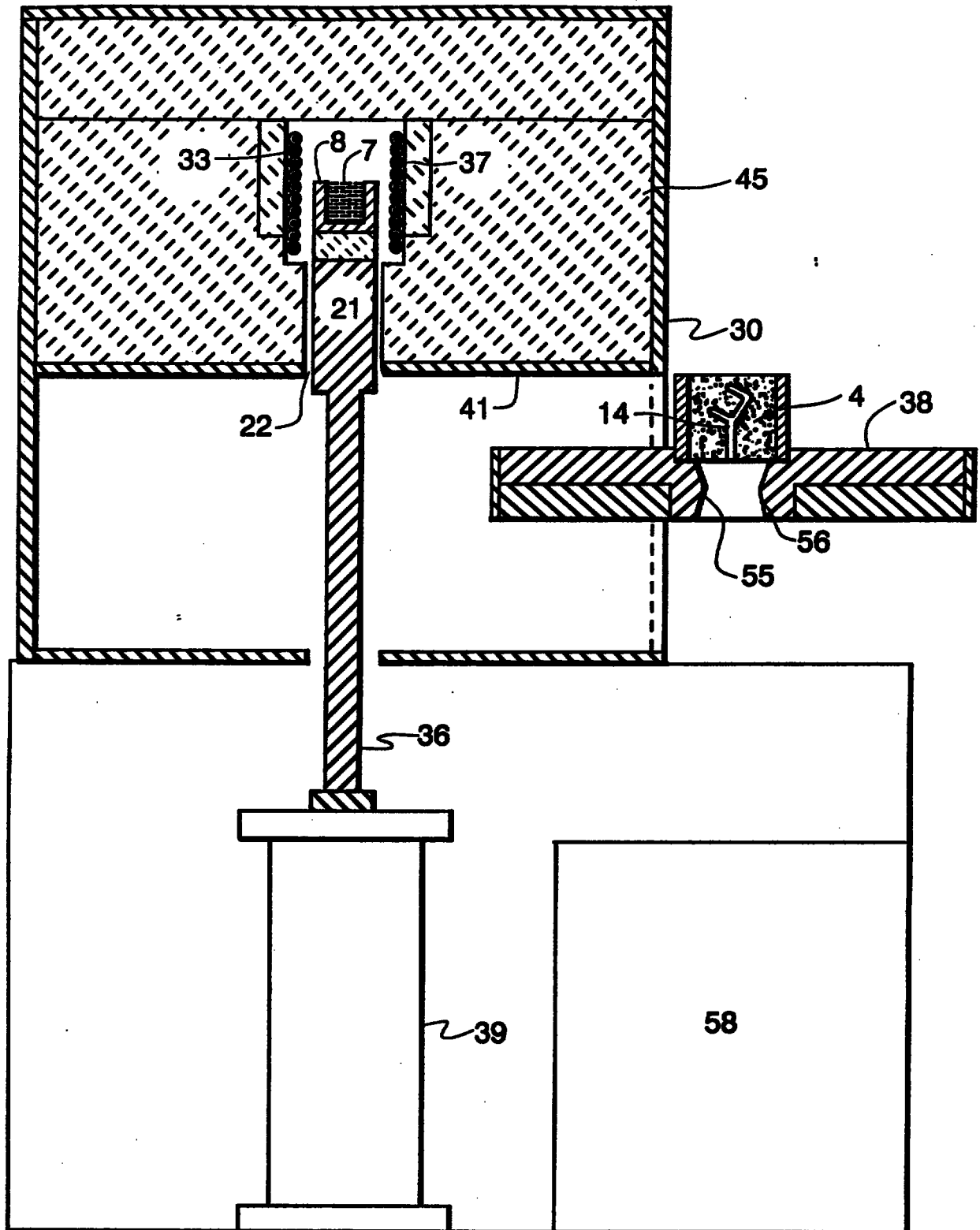


Fig. 7A

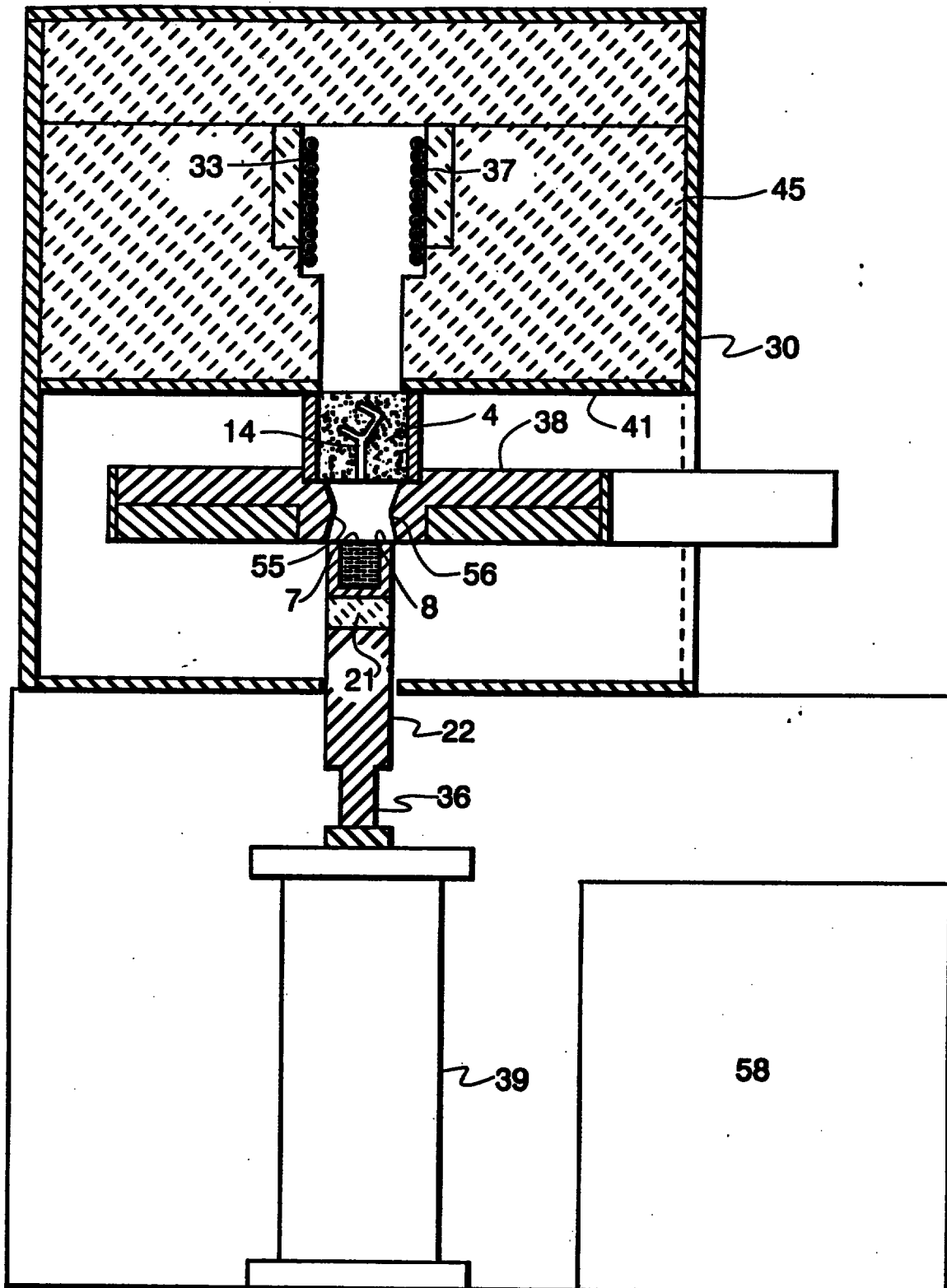


Fig. 7B

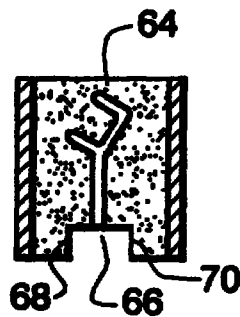


Fig. 8

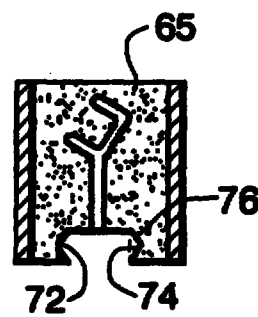


Fig. 9

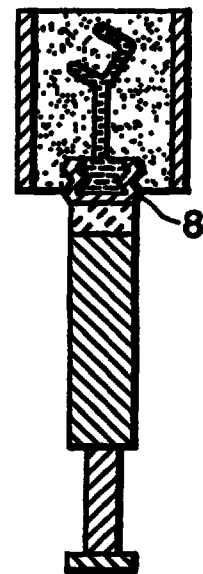


Fig. 10

Method for Molding Dental Restoration and Related ApparatusAbstract

The invention is a process for forming dental restorations from glass-ceramic materials and the resulting dental restorations. The dental restoration is prepared by placing glass-ceramic material in a heat-pressure deformable crucible and heating the crucible to above the liquidus temperature of glass-ceramic material. The crucible's properties are such that the crucible is heat-pressure deformable without rupturing at the working temperature of the glass-ceramic material. The heated crucible is brought into contact with a mold having a preformed cavity, in the shape of the desired dental restoration. The crucible is deformed to form a seal with the mold injecting molten glass-ceramic into the mold cavity. The resulting dental restoration has superior optical esthetic and strength properties. The invention further includes heat-pressure deformable crucibles and related apparatus.