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## Dentistry — Machinable ceramic blanks

*Médecine bucco-dentaire — Ébauches en céramique usinables*



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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 106, *Dentistry*, Subcommittee SC 9, *Dental CAD/CAM systems*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 55, *Dentistry*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

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## Introduction

A variety of ceramic blank materials are being used in machining systems for fabrication of various restorations. Although all these materials can have different chemical and microstructural makeup, there are some unique and common concerns for machining and performance of these materials. Machining damage, minimum machined thickness, and machining tolerances all are common concerns for these materials.

The overwhelming use of zirconia and alumina is in the form of green or partially sintered blanks with shrinkage values of 20 % to 35 % by volume when sintered to full density. In order for the restoration to be fabricated with proper accuracy, the blank density should be carefully measured and conveyed to the computer controlled milling unit. This allows for proper oversizing and shrinkage to provide an accurate fit. Furthermore, the blank should be homogeneous throughout the body, otherwise differential shrinkage occurs resulting in significant warping and departure from linearity.

With respect to glass ceramics, a subset requires crystallization post-machining during which distortion can occur placing the machined part out of the tolerance specified for the restoration. Also, another subset is machined in the crystallized state that can cause significant machining damage affecting the properties of the material.

The machining process can cause surface and subsurface damage that can decrease the flexural strength of the material. Furthermore, damage can limit the minimum thickness of the material that can be achieved with the machining process and affect the accuracy of the final part with respect to the original designed dimensions.

This document provides guidance for evaluating the effects of machining on ceramic materials, the dimensional changes occurring after crystallization and after sintering, and assessing machining damage.

Specific qualitative and quantitative recommendations for freedom from biological hazard are not included in this document, however when assessing possible biological or toxicological hazards, reference should be made to ISO 10993-1 and ISO 7405. Basic material properties are not included in this document, however when assessing material properties, reference should be made to ISO 6872.