Elegant Dent Metal Ceramic - Firing Parameters

	Drying temp/°C	Drying time/s	Heating time/s	Heating rate/°C/min	Firing temp/°C	Holding time/s	Cooling time/s	Cooling temp/°C	Vacuum start temp/°C	Vacuum end temp/°C
Wash Opaque	550	120	120	60	960	60	240	550	550	960
Opaque	550	180	180	60	940	60	240	550	550	940
Body*	550	180	180	55	920	60	240	550	550	920
Glaze and Stain	550	120	120	55	900	60	240	550	NA	NA
Add-on Ceramic	550	120	120	55	910	60	240	550	550	910
Margin	550	180	180	55	930	60	240	550	550	930

*Body includes Dentine, Opacious Dentine, Enamel, Transparent, Cervical, Gingiva and Effects.

The firing parameter chart above is for reference only. Optimal results will be obtained during practical operation. Firing temperature shall be adjusted according to the technician based on furnace condition, coping design and bridge length as appropriate.

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CE 1434
Issue 01 Date of issue: 23.11.2020