


! The following firing temperatures are reference values and can vary according to furnace type. Please note the following information on firing graphs. We recommend, where the construction allows, that a slow cooling phase of six minutes to achieve the stand-by temperature be carried out during the last firing (glaze and stain firing).

Firing table for ZrO₂ restorations


	Starting temperature [°C]	Dry time [min]	Closing time [min]	Vacuum start [°C]	Heat rate [°C / min]	End temperature [°C]	Vacuum end [°C]	Holding time [min]	Opening time [min]
1. Liner firing*	450	6	2	450	60	970	970	1	1
2. Liner firing*	450	6	2	450	60	960	960	1	1
Core Dentin firing*	450	4	2	450	40	810	810	1	1
1. Dentin firing	450	4	2	450	40	765	765	1	1
2. Dentin firing	450	4	2	450	40	760	760	1	1
Correction**	450	4	2	450	45	700	700	1	1
Glaze firing without glazing material	450	4	---	---	45	755	---	1	1
Glaze firing with glazing material	450	3	4	580	45	720	720	1	1

* Not suitable for use with lithium disilicate.


** Correction firing with correction material.

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Firing table for Lithium Disilicate restorations

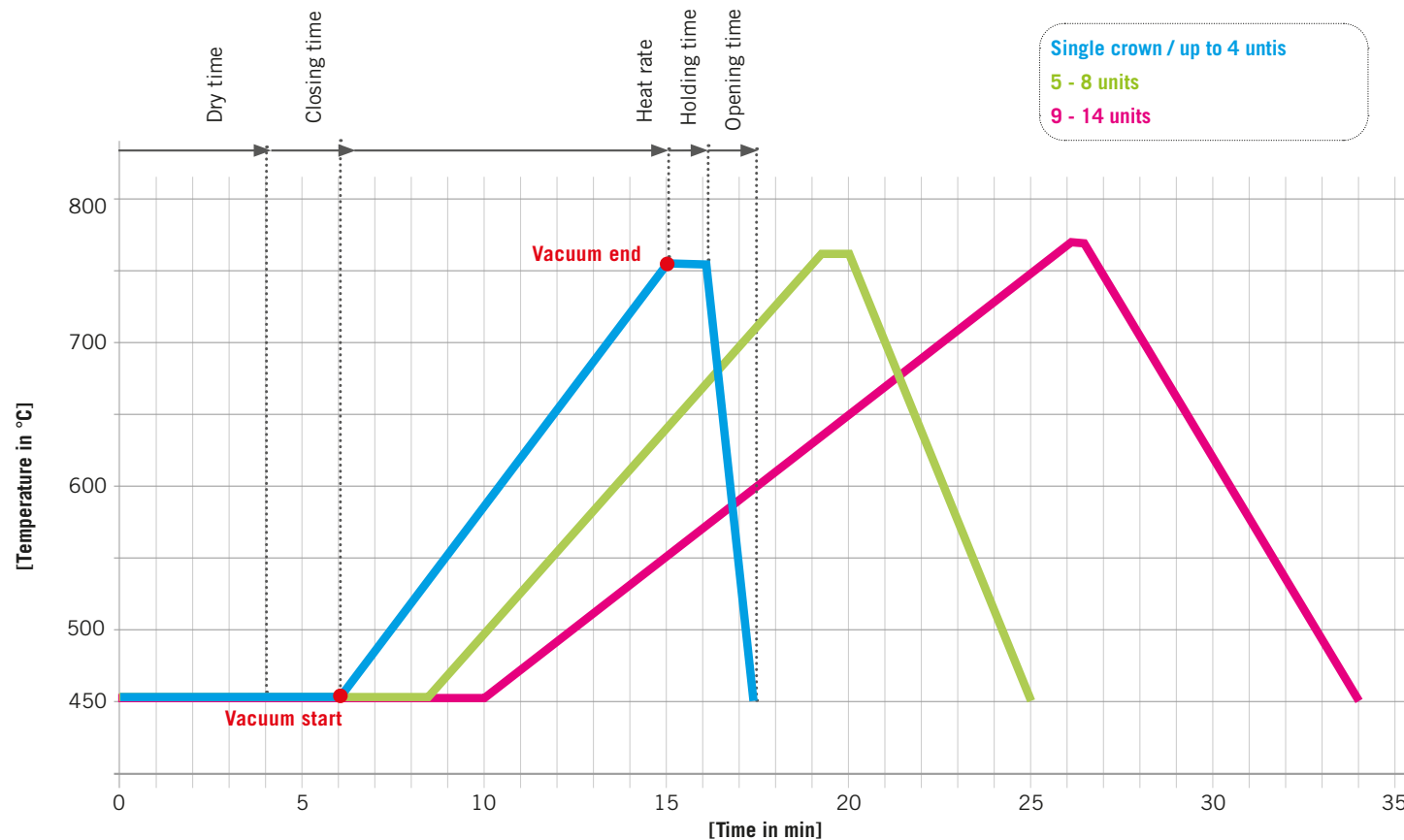
	Starting temperature [°C]	Dry time [min]	Closing time [min]	Vacuum start [°C]	Heat rate [°C / min]	End temperature [°C]	Vacuum end [°C]	Holding time [min]	Opening time [min]
1. Dentin firing	450	4	2	450	40	765	765	1	1
2. Dentin firing	450	4	2	450	40	760	760	1	1
Correction**	450	4	2	450	45	700	700	1	1
Glaze firing <small>without glazing material</small>	450	4	---	---	45	755	---	1	1
Glaze firing <small>with glazing material</small>	450	3	4	580	45	710	710	1	1

Firing table for Titanium restorations

	Starting temperature [°C]	Dry time [min]	Closing time [min]	Vacuum start [°C]	Heat rate [°C / min]	End temperature [°C]	Vacuum end [°C]	Holding time [min]	Opening time [min]
Opaque firing*	450	4	2	450	55	800	800	2	1
Core Dentin firing*	450	4	2	450	45	800	800	1	1
1. Dentin firing	450	4	2	450	45	760	760	1	1
2. Dentin firing	450	4	2	450	45	750	750	1	1
Correction**	450	4	2	450	45	700	700	1	1
Glaze firing <small>without glazing material</small>	450	4	---	---	45	735	---	1	1
Glaze firing <small>with glazing material</small>	450	3	4	580	45	720	720	1	1

* Not suitable for use with lithium disilicate. | ** Correction firing with correction material.

! The firing temperatures indicated in the firing tables are standard values and may vary depending on the type of furnace. On the other hand, since ZrO₂ is a poor heat conductor, so the size of the restoration has a decisive influence on the firing result. The first dentin firing is used as an example to illustrate this; the firing procedure should be adapted accordingly for the other firings.



DRY TIME

- Single crown / 2-4 pontic units : 4 min
- 5 - 8 pontic units: 5 min
- 9 - 14 pontic units: 6 min

CLOSING TIME

- Single crown / 2-4 pontic units: 2 min
- 5 - 8 pontic units: 3 min
- 9 - 14 pontic units: 4 min

HEAT RATE

- Single crown / 2-4 pontic units: 40°/ min
- 5 - 8 pontic units: 30°/ min
- 9 - 14 pontic units: 20°/ min

FINAL TEMPERATURE

- Single crown / 2-4 pontic units: 765°C
- 5 - 8 pontic units: 770°C
- 9 - 14 pontic units: 775°C

HOLDING TIME

- Single crown / 2-4 pontic units: 1 min
- 5 - 8 pontic units: 40 sec
- 9 - 14 pontic units: 20 sec

OPENING TIME

- Single crown / 2-4 pontic units: 1 min
- 5 - 8 pontic units: 5 min
- 9 - 14 pontic units: 8 min