



Firing chart for VITAVM.9

	Predr. °C	 min.	 min.	 °C/min.	approx. Temp. °C	 min.	VAC min.
Regeneration firing (optional, see page 7)	500	-	5.00	100	1000	15.00	-
EFFECT BONDER firing	500	6.00	6.00	80	980	1.00	6.00
EFFECT BONDER PASTE firing	500	6.00	6.00	80	980	2.00	6.00
BASE DENTINE washbake (cf. page 8)	500	2.00	8.11	55	950	1.00	8.11
MARGIN* firing	500	6.00	8.21	55	960	1.00	8.21
EFFECT LINER* firing	500	6.00	7.49	55	930	1.00	7.49
1 st dentine firing	500	6.00	7.27	55	910	1.00	7.27
2 nd dentine firing	500	6.00	7.16	55	900	1.00	7.16
Glaze firing	500	-	5.00	80	900	1.00	-
Glaze firing VITA AKZENT Glaze/Fluid	500	4.00	5.00	80	900	1.00	-
Corrective firing with CORRECTIVE *	500	4.00	4.20	60	760	1.00	4.20





* Indication range see page 25

When using dental ceramics, the firing result largely depends on the individual firing procedure of the user; i.e. among other aspects the type of furnace, the location of the temperature sensor, the firing tray as well as the size of the workpiece during the firing cycles.

Our application-technical recommendations for the firing temperatures (regardless whether they have been provided orally, in writing or in the form of practical instructions) are based on numerous experiences and tests. The user, however, should consider this information only to provide basic values.

If surface, transparency and degree of gloss do not correspond to the firing result that is achieved under optimal conditions, the firing procedure must be adjusted correspondingly. The crucial factors for the firing procedure are not the firing temperature displayed by the furnace but the appearance and the surface condition of the firing object after the firing process.

Explanation of the firing parameters:

- Predr. °C Start temperature
-  min. Predrying time in min, closing time
-  min. Heating time in min
-  °C/min. Temperature rise rate
- approx. Temp. °C End temperature
-  min. Holding time for end temperature
- VAC min. Vacuum holding time