

“AL” Pressing Guidelines						
Base Temp. (°C)	Rate of Climb ↑ (C°/min)	End Temp. (°C)	Press Time (min)	Hold Time (min)	Start Vacuum (°C)	End Vacuum (°C)
700	60	920 - 930	9 - 12	20	500	920 - 930

“AL” FIRING CHART	Start Temp. (°C)	Heat Rate (C°/min)	Finish Temp. (°C)	Dry Time (min)	Hold Time (min)	Vacuum Start (°C)	Vacuum End (°C)
Liner	400	60	1040	4	1	450	1039
1st Margin	400	60	840	4	1	450	839
2nd Margin	400	60	830	4	1	450	829
1st Dentin	400	45	780	4	1	450	779
2nd Dentin	400	45	770	4	1	450	769
3rd Dentin	400	45	760	4	1	450	759
Stain & Glaze Technique	400	45	780	4	1	450	779
Natural Glaze (Using Layering Technique)	400	45	760	4	1	0	0
Glaze Firing with Glaze	400	45	750	4	1	450	749
Correction/Add-on Material	400	45	740	4	1	450	739

*Temperature specifications are only reference as furnaces vary in temperatures



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