

Firing Temperatures

IMPORTANT: DO NOT PREHEAT THE INGOTS.

	100g Ring	200g Ring	300g Ring
Start Temp	700°C / 1292°F	700°C / 1292°F	700°C / 1292°F
Heat Rate (/min)	60°C / 140°F	60°C / 140°F	60°C / 140°F
End Temp	920°C / 1688°F	930°C / 1706°F	940°C / 1724°F
Hold Time	20 - 25 min.	20 - 25 min.	20 - 25 min.
Press Time	6 - 10 min.	8 - 12 min.	10 - 14 min.
Vacuum Start	700°C / 1292°F	700°C / 1292°F	700°C / 1292°F
Vacuum End	920°C / 1688°F	930°C / 1706°F	940°C / 1724°F
Air Pressure	4.5 bars / 63 psi	4.5 bars / 63 psi	4.5 bars / 63 psi

*The 'Hold Time' required depends on the distance from the burnout oven to the pressing furnace. The greater the distance from each other, the greater hold time. As a benchmark, if the burnout and pressing furnaces are next to each other, 20 minute hold time is recommended.

	Dry	Start Temp	Heat Rate	Finish Temp	Start Vac.	Finish Vac.	Hold
	Min	°C/°F	°C/°F per min	°C/°F	°C/°F	°C/°F	Min
Opaque - Press	6	400/752	60/140	950/1742	400/752	949/1740	2
Opaque - 800	6	400/752	60/140	810/1490	400/752	809/1488	2
Staining Technique							
Stain Fixation Bake	3	400/752	55/131	700/1292	400/752	699/1290	0
Glaze	5	400/752	55/131	760/1400	400/752	759/1398	1
Layering Technique							
1st Margin	4	400/752	45/113	750/1382	400/752	749/1380	1
2nd Margin	4	400/752	45/113	740/1364	400/752	739/1362	1
1st Dentin/Incisal	5	400/752	45/113	730/1346	400/752	729/1344	1
2nd+ Dentin/Incisal	5	400/752	50/122	720/1328	400/752	719/1326	1
Correction Bake	5	400/752	45/113	700/1292	400/752	699/1290	1
Layered Fixation Bake	3	400/752	55/131	630/1166	400/752	629/1164	1
Stain & Glaze	5	400/752	50/122	710/1310	400/752	709/1308	1

These are only guidelines. Temperatures will vary with the furnace used.

