


- ! The following firing temperatures are reference values and can vary according to furnace type.
- For firing large-span bridges or massive pontics, the heating rate must be adjusted to approx. 30°C/min.

Firing table for precious / non-precious alloys (14 CTE)

	Start 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]
Wash firing	450	4	3	450	80	950	950	1	1
Opaque firing	450	4	3	450	80	950	950	1	1
1. Margin firing	450	3	3	450	60	900	900	1	1
2. Margin firing	450	3	3	450	60	890	890	1	1
1. Dentin firing	450	4	3	450	60	880	880	1	1
2. Dentin firing	450	4	3	450	60	870	870	1	1
Correction firing*	450	4	3	450	60	800	800	1	1
Glaze firing without glazing material	450	---	3	---	55	860	---	1	1
Glaze / Stain firing with glazing material	450	4	3	600	50	780	780	1	1

* with correction material