

FIRING CHART UNIVERSAL

	Start temp. ° C	Heat rate ° C / min	Up-time min	Firing °C	Hold time min	Vacuum Start °C
Wash	400	80	6	1 st firing 880	1	450
Opaquer	400	60	6	1 st firing 880	1	450
		80	6	2 nd firing 870		
Margin	400	55	4	1 st firing 830	1	450
		55	4	2 nd firing 820		
Dentine	400	45	6	1 st firing 790	1	450
				2 nd firing 780		
Add-on	400	55	4	780	1	450
Glaze	400	70	6	770	1	