

FIRING CHART VACUMAT

	Start temp. ° C	Heat rate ° C / min	Firing °C	Up-time min	Hold time min	Vaccum Start °C
Wash	400	80	880	6	1	450
1 st Opaquer	400	60	870	6	1	450
2 nd Opaquer	400	80	870	6	1	450
1 st Margin	400	55	830	4	1	450
2 nd Margin	400	55	820	4	1	450
1 st Dentine	400	45	810	5	1 - 1,5	450
2 nd Dentine	400	45	800	4	1 – 1,5	450
Glaze, without vac.	400	70	780	8	1	--