Firing Instructions

Cercon ceram love – General firing instructions

	Pre-heating °C	Drying/ Pre-heating min	Heating °C/min	Firing °C	Holding min	Vacuum hPa	Long-term cooling min
Paste liner 1	575	9	55	970	1:00	50	–
Paste liner 2	575	9	55	960	1:00	50	–
Margin 1	450	6	55	950	2:00	50	–
Margin 2	450	6	55	950	1:00	50	–
Dentine 1	450	5	55	900	1:30	50	–
Dentine 2	450	5	55	890	1:30	50	–
Glaze	450	5	55	880	1:00	–	6:00
Add-On	450	5	55	750	1:00	50	6:00
Final Shoulder	450	5	55	750	1:00	50	6:00

CE 0124

Slow cooling is mandatory after the last firing; this includes correction firings of restorations after try-in.

The firing temperature must be adapted to the number of units fired in the same cycle. 5 to 9 units require an increase by 5 °C to 10 °C; 10 or more units require an increase by 10 °C to 20 °C.
The values listed here are intended for orientation only and should be regarded only as guidelines.
Your firing results may differ. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. Therefore, the guideline values will have to be adapted individually for each firing. We recommend running a test firing cycle to evaluate the performance of the furnace used. We have compiled and checked all values and other data with great care. However, we cannot under any circumstances be liable for your results.

Last revision: September 2009

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Firing Instructions

Cercon ceram love – Firing instructions Cergo Compact / Press

	Drying		Closing	Pre-heating		Heating	Vacuum			Final-temp.	Holding		Cooling	
	°C	min	min	°C	min	°C/min	cont/off	on °C	off °C	°C	V min	min	°C	min
Paste liner 1	135	6:00	2:00	575	3:00	55	cont	575	970	970	–	1:00	–	–
Paste liner 2	135	6:00	2:00	575	3:00	55	cont	575	960	960	–	1:00	–	–
Margin 1	135	3:00	3:00	450	3:00	55	cont	450	950	950	–	2:00	–	–
Margin 2	135	3:00	3:00	450	3:00	55	cont	450	950	950	–	1:00	–	–
Dentine 1	135	2:00	3:00	450	3:00	55	cont	450	900	900	–	1:30	–	–
Dentine 2	135	2:00	3:00	450	3:00	55	cont	450	890	890	–	1:30	–	–
Glaze	135	2:00	3:00	450	3:00	55	off	–	–	880	–	1:00	–	6
Add-On	135	2:00	3:00	450	3:00	55	cont	450	750	750	–	1:00	–	6
Final Shoulder	135	2:00	3:00	450	3:00	55	cont	450	750	750	–	1:00	–	6

CE 0124 **Slow cooling is mandatory after the last firing; this includes correction firings of restorations after try-in.**

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Firing Instructions

Cercon ceram love – Firing instructions Mach 2

	Pre-heating °C	Drying min	Pre-heating min	Vacuum min	Firing min	Firing °C	Heating	Vacuum hPa	Cooling level
Paste liner 1	575	7	4	1.0	2.0	970	55	50	–
Paste liner 2	575	7	4	1.0	2.0	960	55	50	–
Margin 1	450	5	4	1.0	3.0	950	55	50	–
Margin 2	450	5	4	1.0	2.0	950	55	50	–
Dentine 1	450	3	4	1.5	2.5	900	55	50	–
Dentine 2	450	3	4	1.5	2.5	890	55	50	–
Glaze	450	2	3	0.0	1.0	880	55	–	2
Add-On	450	2	4	1.0	2.0	750	55	50	2
Final Shoulder	450	2	4	1.0	2.0	750	55	50	2

CE 0124

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Firing Instructions

Cercon ceram love – Firing instructions Multimat Touch & Press / Touch & Press 2 / NT / NTpress / Easy

	Pre-heating °C	Drying min	Pre-heating min	Vacuum hPa	Heating °C/min.	Firing °C	Vacuum min	Firing min	Cooling level
Paste liner 1	575	7:00	4:00	50	55	970	1:00	2:00	–
Paste liner 2	575	7:00	4:00	50	55	960	1:00	2:00	–
Margin 1	450	5:00	4:00	50	55	950	1:00	3:00	–
Margin 2	450	5:00	4:00	50	55	950	1:00	2:00	–
Dentine 1	450	3:00	4:00	50	55	900	1:30	2:30	–
Dentine 2	450	3:00	4:00	50	55	890	1:30	2:30	–
Glaze	450	2:00	3:00	–	55	880	0:00	2:00	1
Add-On	450	2:00	4:00	50	55	750	1:00	2:00	1
Final Shoulder	450	2:00	4:00	50	55	750	1:00	2:00	1

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Firing Instructions

Cercon ceram love – Firing instructions Profire

	Drying °C	Drying min	Closing min	Pre-heating °C	Pre-heating min	Vacuum	Vacuum on	Vacuum off	Heating °C/min	Firing °C	Vacuum min	Holding min	Tempe-ring °C	Tempe-ring min	Cooling min
Paste liner 1	135	6	2	575	3	cont	575	970	55	970	0	1	0	0	0
Paste liner 2	135	6	2	575	3	cont	575	960	55	960	0	1	0	0	0
Margin 1	135	3	3	450	3	cont	450	950	55	950	0	2	0	0	0
Margin 2	135	3	3	450	3	cont	450	950	55	950	0	1	0	0	0
Dentine 1	135	2	3	450	3	cont	450	900	55	900	0	1:30	0	0	0
Dentine 2	135	2	3	450	3	cont	450	890	55	890	0	1:30	0	0	0
Glaze	135	2	3	450	3	off	–	–	55	880	0	1	0	0	6:00
Add-On	135	2	3	450	3	cont	450	750	55	750	0	1	0	0	6:00
Final Shoulder	135	2	3	450	3	cont	450	750	55	750	0	1	0	0	6:00

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