





Firing chart for VITAVM®13

	Predr. °C	 min.	 min.	 °C/min.	approx.* temp. °C	 min.	VAC min.
Oxidation firing	Please heed alloy manufacturer's instructions !!!						
WASH OPAQUE firing	500	2.00	5.12	75	890	2.00	5.12
WASH OPAQUE PASTE firing	500	4.00	5.12	75	890	2.00	5.12
OPAQUE firing	500	2.00	5.12	75	890	1.00	5.12
OPAQUE PASTE firing	500	4.00	5.12	75	890	1.00	5.12
MARGIN firing*	500	6.00	7.05	55	890	2.00	7.05
EFFECT LINER firing*	500	6.00	7.05	55	890	1.00	7.05
1st dentine firing	500	6.00	6.55	55	880	1.00	6.55
2nd dentine firing	500	6.00	6.44	55	870	1.00	6.44
Glaze firing	500	0.00	4.45	80	880	2.00	-
Glaze firing VITA Akzent	500	4.00	4.45	80	880	1.00	-
Correction firing with CORRECTIVE	500	4.00	6.00	50	800	1.00	6.00

* area of indication see page 27

When using dental ceramic, the firing result largely depends on the individual firing procedure of the user, i.e. among other aspects, on the type of furnace, the location of the temperature sensor, the firing tray as well as the size of the workpiece during the firing cycles.

Our recommendations with regard to practical applications for the firing temperatures (regardless of whether they have been provided orally, in writing or in the form of practical instructions) are based on numerous own experiences and tests. The user, however, should consider this information only as a general guideline.

If surface, transparency and degree of gloss should not correspond to the firing result that is achieved under optimal conditions, the firing procedure must be adjusted correspondingly. Not the firing temperature displayed by the furnace is decisive for the firing procedure, but the appearance and surface condition of the firing object after the firing process.

In the case of alloys with a CTE (25-600°C) $\geq 14.5 \cdot 10^{-6} \text{ K}^{-1}$, slow cooling should be used from the 1st dentine firing onwards.