







As a result of the poor thermal conductivity of both materials (Y-TZP and veneering ceramic), higher residual stress can occur in this compound system than in the case of metal ceramics. This residual thermal stress in the veneering

ceramic can be counteracted by slow cooling to below the transformation temperature of the veneering ceramic during the last firing cycle (approx. 600°C for VITA VM 9).

	Predry. °C	 min.	 min.	 °C/min.	Temp. approx. °C	 min.	 °C	 min.	VAC min.
Cleaning firing	500	3.00	6.00	33	700	5.00	–	–	–
Regeneration firing (optional, see page 11)	500	0.00	5.00	100	1000	15.00	–	–	–
Washbake firing	500	2.00	8.11	55	950	1.00	–	–	8.11
MARGIN* firing	500	6.00	8.21	55	960	1.00	–	–	8.21
EFFECT LINER* firing	500	6.00	7.49	55	930	1.00	–	–	7.49
1. dentine firing	500	6.00	7.27	55	910	1.00	600**	–	7.27
2. dentine firing	500	6.00	7.16	55	900	1.00	600**	–	7.16
Glaze firing	500	0.00	5.00	80	900	1.00	600**	–	–
Glaze firing with AKZENT Plus	500	4.00	5.00	80	900	1.00	600**	–	–
Corrective firing with CORRECTIVE*	500	4.00	4.20	80	760	1.00	500**	–	4.20

\*Indication range, see pages 27/28






\*\*Long-term cooling down to the respective temperature is recommended for the respective **last** firing cycle of the veneering ceramic.  
The lift position for VITA VACUMAT furnaces should be > 75%.  
Firing object must be protected against direct supply of air.

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

**Our application-technical recommendations for the firing temperatures (regardless of whether they have been provided orally, in writing or in the form of practical instructions) are based on extensive experience and tests. The user, however, should consider this information only as a reference.**

**Should the surface quality or the degree of transparency or glaze not correspond to the firing result that is achieved under optimum conditions, the firing procedure must be adjusted correspondingly. The crucial factors for the firing procedure are not the firing temperature indicated on the furnace display, but the appearance and the surface quality of the firing object after firing.**

Explanation of the firing parameters:

- Predr. °C      Start temperature
-       Predrying time in minutes, closing time
-       Heating time in minutes
-       Temperature rise rate in degrees Celsius per minute
- Temp. approx. °C      End temperature
-       Holding time for end temperature
-       Long-term cooling
- VAC min.      Vacuum holding time in minutes