

BAKING SCHEDULE

	DRY- OUT TIME	PREDRYING TEMP.		START VACUUM		HEAT RATE		VACUUM LEVEL	RELEASE VACUUM		HIGH TEMPERATURE		HOLD TIME IN THE AIR	COOL TIME
	min.	°C	°F	°C	°F	°C / min.	°F / min.	kPa*1	°C	°F	°C	°F	min.	min.
Wash Bake	5	500	932	600	1112	45	81	96	740	1364	740	1364	1	4
Internal Stain	5	500	932	-	-	45	81	0	-	-	700	1292	-	4
Liner/Enamel/ Opacious Body/ Body/ Mamelon/ Translucent/ Luster/ Clear Cervical*2	7-10	500	932	600	1112	45	81	96	740-770	1364-1418	740-770	1364-1418	1	4
Minor Adjustment*2*3	7-10	500	932	600	1112	45	81	96	730-760	1346-1400	730-760	1346-1400	0.5	4
Tissue*2	7-10	500	932	600	1112	45	81	96	720-750	1328-1382	720-750	1328-1382	1	4
Self Glaze*2	5	500	932	-	-	45	81	0	-	-	710-740	1310-1364	-	4
CERABIEN™ ZR FC Paste Stain	5	500	932	600	1112	45	81	96	730	1346	730	1346	1	4

*1 96 kPa = 72 cmHg (29 inchesHg)

*2 The lower baking limit is based on the assumption of a single crown. When baking multiple or large restorations, adjust the dry-out time and temperature according to the upper baking limits.

*3 This is the baking temperature for cases where Liner, Opacious Body, Body, Enamel, Translucent, Luster, Clear Cervical, and Mamelon are additionally applied.

The above program is only a guideline. Baking temperature may be varied with the peculiarities of different furnace. Porcelain furnace temperature variations may be significant in the lower ranges. Determine the exact baking schedule by making a preliminary test before baking an actual case restoration.