

BAKING SCHEDULE

	DRY-OUT TIME	PREDRYING TEMPERATURE		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	°C	°F	°C	°F	min.	min.
Wash Bake	5	500	932	600	1,112	45	81	96	740	1,364	740	1,364	1	4
Internal Stain	5	500	932	-	-	45	81	0	-	-	700	1,292	-	4
Liner/Enamel/ Translucent/ Luster/Clear Cervical	7	500	932	600	1,112	45	81	96	740	1,364	740	1,364	1	4
Minor Adjustment	5	500	932	600	1,112	45	81	96	730	1,346	730	1,346	0.5	4
Tissue	5	500	932	600	1,112	45	81	96	720	1,328	720	1,328	1	4
Self Glaze	5	500	932	-	-	45	81	0	-	-	710	1,310	-	4
CERABIEN™ ZR FC Paste Stain	5	500	932	600	1,112	45	81	96	730	1,346	730	1,346	1	4

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.