

FIRING CHART

G-CERAM[®]

| | 1 st and 2 st Shoulder | Wash Firing (Base Dentine) | 1 st Dentine | 2 st Dentine | Glaze Low &Stains | Add On |
|-----------------------------------|---|-------------------------------|----------------------------|----------------------------|-------------------------|----------------|
| Dry Time | 4 min | 4 min | 6 min | 4 min | 4 min | 4 min |
| Start Temp | 550°C | 550°C | 550°C | 550°C | 550°C | 550°C |
| Heat Rate^{°C/min} | 55°C | 55°C | 55°C | 55°C | 55°C | 55°C |
| Vacuum Start | 600°C | 600°C | 600°C | 600°C | None | 600°C |
| Vacuum Stop | 955°C | 940°C | 895°C | 890°C | None | 840°C |
| High Temp | 960°C | 940°C | 900°C | 895°C | 895°C | 840°C |
| Hold Time | 1 min | 1 min | 20 sec | 20 sec | 1 min | 1 min |
| Cool Time | 1 min | 1 min | 3 min 650°C | 3 min 650°C | 3 min 650°C | 3 min 600°C |
| Texture | Eggshell | Grainy Shiny | Grainy Shiny | Grainy Shiny | Glossy | Glossy |

Zirconia framework is a lower thermal conduction characteristic material. Due to this physical characteristic, thermal stress will be generated in between framework and porcelain in cooling process. This situation will be higher in big bridges and full restorations. This residual thermal stress in the veneering porcelain can be resisted by slow cooling to reduce the transformation temperature of the veneering porcelain during the firing cycle (approx. 650°C).

Please note:

- 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 brand, model, age of the furnace and calibration.
- 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.