

G-CERAM <sup>®</sup>	FIRING CHART							
	Oxide	Base Paste	Opaque Powder	1 <sup>st</sup> and 2 <sup>st</sup> Shoulder	1 <sup>st</sup> Dentine	2 <sup>st</sup> Dentine	Glaze High & Stains	Add On
<b>Dry Time</b>	-	3-4 min	4-5 min	3-4 min	6 min	6 min	3-5 min	3-5 min
<b>Start Temp</b>	600°C	500°C	550°C	550°C	550°C	550°C	550°C	550°C
<b>Heat Rate °C/min</b>	100°C	100°C	55°C	55°C	55°C	55°C	55°C	55°C
<b>Vacuum Start</b>	600°C	500°C	600°C	600°C	600°C	600°C	None	Optional
<b>Vacuum Stop</b>	980°C	975°C	965°C	950°C	900°C	895°C	None	Optional
<b>High Temp</b>	980°C 990°C	975°C 980°C	965°C 970°C	950°C 955°C	905°C	900°C	895°C	850°C
<b>Hold Time</b>	1 min 10 min*	1 min	1 min	1 min	20-30 sec	20-30 sec	1 min	1 min
<b>Cool Time</b>	1 min	1 min	1 min	1 min 3 min**	1 min 3 min**	1 min 3 min**	1 min 3 min**	1 min 3 min*
<b>Texture</b>	Tin oxide surface	Eggshell Shiny	Eggshell Shiny	Eggshell	Grainy Shiny	Grainy Shiny	Glossy	Glossy
<b>Thickness (approx.)</b>	-	0.1-0.3mm	0.1-0.3mm	0.2mm	0.5-1.0mm	0.5-1.0mm	-	-

\* During oxidation process, Hold Time will be 10 min in Nickel Free Chrome Cobalt Alloy.

\*\* Slow cooling must be performed when Nickel Free Chrome Cobalt Alloy is used.

#### 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.
- We have compiled and checked all values and other datas with great care. However, we cannot under any circumstances be liable for your results.
- Recommended alloy CTE range :  $14.0-14.6 \times 10^{-6} \text{K}^{-1}$  25°C - 600°C