DENTAL PORCELAIN POWDER
VERSION / MODEL : MF
ISO 6872:2024 TYPE I CERAMICS
G-CERAM MF Metal-Ceramic is a natural feldspathic porcelain powder, which is used to make metal sub-structured porcelain crowns and bridges, porcelain veneer and dental inlays-onlays.

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G-CERAM	FIRING CHART							
	Bond	**Base Paste**	**Opaque Powder**	**1st and 2nd Shoulder**	**1st Dentine**	**2nd Dentine**	**Glaze High & Stains**	**Add On**
Dry Time	3 min	3-4 min	6-8 min	3-4 min	6 min	6 min	3-5 min	3-5 min
Start Temp	500°C	500°C	550°C	550°C	550°C	550°C	550°C	550°C
Heat Rate °C/min	60°C	100 °C	55°C	55°C	55°C	55°C	55°C	55°C
Vacuum Start	500°C	500 °C	600°C	600°C	600°C	600°C	None	Optional
Vacuum Stop	979°C	975 °C	965 °C	950 °C	900 °C	895 °C	None	Optional
High Temp	980°C	975 °C 980 °C	965 °C 970 °C	950 °C 955 °C	905 °C	900 °C	895 °C	850 °C
Hold Time	2 min	1 min	1 min	1 min	45-60 sec	30-45 sec	1 min	1 min
Cool Time	1 min / 3 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 **
Texture	Eggshell Shiny	Eggshell Shiny	Eggshell Shiny	Eggshell	Grainy Shiny	Grainy Shiny	Glossy	Glossy
Thickness (approx.)	0.1-0.3mm	0.1-0.3mm	0.1-0.3mm	0.1-0.3mm	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.

This document does not replace the official Instructions for Use (IFU). For full handling and safety instructions, refer to the IFU.

These values are provided in good faith based on internal testing. Final results may vary and must be verified by the user.

COLOUR COMBINATION TABLE

Opaque	Shoulder	Opaque - Dentine Chroma - Dentine	Dentine	Incisal
A0	Bleach	A0	A0	I1
A1	Light	A1	A1	I1
A2	Medium	A2	A2	I2
A3	Medium	A3	A3	I2
A3.5	Medium Dark	A3.5	A3.5	I3
A4	Dark	A4	A4	I3
B0	Bleach	B0	B0	I1
B1	Light	B1	B1	I1
B2	Medium Light	B2	B2	I2
B3	Medium Dark	B3	B3	I3
B4	Medium Dark	B4	B4	I3
C1	Light	C1	C1	I3
C2	Medium	C2	C2	I1
C3	Dark	C3	C3	I2
C4	Dark	C4	C4	I3
D2	Light	D2	D2	I3
D3	Medium Light	D3	D3	I2
D4	Medium	D4	D4	I2

PRODUCT GROUP	CTE $\times 10^{-6}$ K^{-1} (Linear thermal expansion)	Tg (Glass transition temperature)
MF DENTINE	**12,8±0,5 × 10^{-6} K^{-1}**	**530±20 °C**
MF CHROMA DENTINE	**12,8±0,5 × 10^{-6} K^{-1}**	**530±20 °C**
MF OPAK DENTINE	**12,8±0,5 × 10^{-6} K^{-1}**	**530±20 °C**
MF GUM SHADE	**12,8±0,5 × 10^{-6} K^{-1}**	**530±20 °C**
MF DENTINE MODIFIER	**12,8±0,5 × 10^{-6} K^{-1}**	**530±20 °C**
MF INCISAL	**12,8±0,5 × 10^{-6} K^{-1}**	**570±20 °C**
MF INCISAL MODIFIER	**12,8±0,5 × 10^{-6} K^{-1}**	**570±20 °C**
MF INCISAL TRANSPARENT	**12,8±0,5 × 10^{-6} K^{-1}**	**570±20 °C**
MF OPAK	**13,1 ±0,5 × 10^{-6} K^{-1}**	**535±20 °C**
MF OPAK MODIFIER	**13,1 ±0,5 × 10^{-6} K^{-1}**	**535±20 °C**

General Warning

- For professional use only.
- Oven parameters are critical.
- Compatibility with metal infrastructure must be checked.
- Dusts must not be inhaled.
- Mixing with liquid components must be done carefully.
- Eye contact must be avoided.
- Calibration of the oven device must be done regularly.

- Material must be homogenized before use.
- Allergy reaction must be monitored.
- Storage conditions must be observed.

Storage Conditions:
Store in a cool, dry place away from direct sunlight. Keep the container tightly closed. Use before the expiration date indicated on the label.