

CEREC Tessera™

General firing recommendations

| | Drying | Closing | Pre-heating temp. | Pre-heating | Heating rate | Final temp. | Vacuum Holding time | Holding without vacuum | Cooling |
|------------------------------------|--------|---------|-------------------|-------------|--------------|-------------|---------------------|------------------------|---------|
| | min | min | °C | min | °C/min | °C | min | min | min |
| Universal Stain & Glaze | 2:00 | 2:00 | 400 | 2:00 | 55 | 760 | 0 | 2:00 | 0 |
| Universal Spray Glaze | 0:00 | 1:00 | 400 | 1:00 | 55 | 760 | 0 | 2:00 | 0 |

CEREC Tessera™ & Celtra® Ceram

General firing recommendations – Firing program Cut-back Technique

| | Drying | Closing | Pre-heating temp. | Pre-heating | Heating rate | Final temp. | Vacuum Holding time | Holding without vacuum | Cooling | |
|----------------------------|-----------------|---------|-------------------|-------------|--------------|-------------|---------------------|------------------------|---------|------|
| | min | min | °C | min | °C/min | °C | min | min | min | |
| Matrix firing | 0:00 | 1:00 | 400 | 1:00 | 55 | 760 | 0:00 | 2:00 | 0:00 | |
| Cut-back | Dentin 1 | 2:00 | 2:00 | 400 | 2:00 | 55 | 770 | 1:00 | 1:00 | 5:00 |
| | Dentin 2 | 2:00 | 2:00 | 400 | 2:00 | 55 | 760 | 1:00 | 1:00 | 5:00 |
| Glaze firing | 2:00 | 2:00 | 400 | 2:00 | 55 | 750 | 0:00 | 2:00 | 5:00 | |
| Spray Glaze | 0:00 | 1:00 | 400 | 1:00 | 55 | 750 | 0:00 | 2:00 | 5:00 | |
| Stain + Spray Glaze | 1:00 | 1:00 | 400 | 1:00 | 55 | 750 | 0:00 | 2:00 | 5:00 | |
| Add-on | 2:00 | 2:00 | 400 | 2:00 | 55 | 750 | 1:00 | 1:00 | 5:00 | |

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.



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