

FIRING TABLES

Stain and glaze firing on zirconia (without microlayering)

Firings	Start temperature	Drying time / Closing time	Temperature rise	Vacuum	End temperature	Hold time	Slow cooling to 500 °C
Stain/glaze single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	800 °C	1 min.	0 min.
Stain/glaze > 4 units	450 °C	6+6 min.	35 °C/min.	Yes	850 °C	1 min.	9 min.
Stain/glaze > 8 units	450 °C	6+6 min.	25 °C/min.	Yes	880 °C	1 min.	9 min.

Stain and glaze firing on lithium silicate (without microlayering)

Firings	Start temperature	Drying time / Closing time	Temperature rise	Vacuum	End temperature	Hold time	Slow cooling
Stain/glaze single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	760 °C	1 min.	0 min.

The duration of the pre-drying time, the temperature rise, the final temperature and the slow cooling - all depend on the size of the restoration. Large-volume restorations need longer pre-drying, slower preheating, firing at a higher temperature and slowly cooled. The pre-drying and total closing time of 12 min and slow cooling of 9 min must be strictly observed for large-volume restorations.

FIRING TABLES

Stain, Microlayering ZI-F, glaze firing on zirconia

Firings	Start temperature	Drying time / Closing time	Temperature rise	Vacuum	End temperature	Hold time	Slow cooling to 500 °C
Characterisation single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	800 °C	1 min.	0 min.
Characterisation > 4 units	450 °C	6+6 min.	25 °C/min.	Yes	850 °C	1 min.	9 min.
Microlayering ZI-F single crown	450 °C	3+3 min.	45 °C/min.	Yes	830 °C	1 min.	0 min.
Microlayering ZI-F > 4 units	450 °C	6+6 min.	35 °C/min.	Yes	840 °C	1 min.	9 min.
Microlayering ZI-F > 8 units	450 °C	6+6 min.	25 °C/min.	Yes	850 °C	1 min.	9 min.
Stain/glaze single crown	450 °C	3+3 min.	45 °C/min.	Yes	780 °C	1 min.	0 min.
Stain/glaze > 4 units	450 °C	6+6 min.	25 °C/min.	Yes	800 °C	1 min.	9 min.

Stain, Microlayering LS, glaze firing on lithium silicate

Firings	Start temperature	Drying time / Closing time	Temperature rise	Vacuum	End temperature	Hold time	Slow cooling
Characterisation single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	760 °C	1 min.	0 min.
Microlayering LS single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	780 °C	1 min.	0 min.
Stain/glaze single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	760 °C	1 min.	0 min.

FIRING TABLES

Surface staining and glazing of fully veneered ceramic restorations

Ceramic	Firings	Start temperature	Drying time / Closing time	Temperature rise	Vacuum	End temperature	Hold time	Slow cooling to 500 °C
Creation ZI-F stain/glaze								
ZI-F	Stain/glaze single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	780 °C	1 min.	0 min.
ZI-F	Stain/glaze > 4 units	450 °C	6+6 min.	25 °C/min.	Yes	800 °C	1 min.	9 min.
Creation ZI-CT stain/glaze								
ZI-CT	Stain/glaze single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	840 °C	1 min.	0 min.
ZI-CT	Stain/glaze > 4 units	450 °C	6+6 min.	25 °C/min.	Yes	860 °C	1 min.	9 min.
Creation LS stain/glaze								
LS	Stain/glaze single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	760 °C	1 min.	0 min.
Creation CC stain/glaze								
CC	Stain/glaze single tooth crown	450 °C	3+3 min.	45 °C/min.	Yes	880 °C	1 min.	0 min.
CC	Stain/glaze > 4 units	450 °C	3+3 min.	45 °C/min.	Yes	900 °C	1 min.	0 min.