


CERAMIX FINE GRAIN PORCELAIN SYSTEM FIRING CHART *

	Ceramic					Ceramic LF				Metal Conditioner
	Opaque / Opacious Dentine	Gingival / Incisal	Natural Glaze	Artificial Glaze Low-Fuse	Artificial Glaze Hi- Fuse	Low Fuse Opaque / Opacious Dentine ‡	Low Fuse Gingival / Incisal ‡	Natural Glaze	Artificial Glaze 1450	Met - Con *
Dryout	3-5min	3-5min	3-5min	3-5min	3-5min	3-5min	3-5min	3-5min	3-5min	3-5min
Insertion	593°C 1100°F	593°C 1100°F	593°C 1100°F	515°C 960°F	593°C 1100°F	371°C 700°F	371°C 700°F	371°C 700°F	371°C 700°F	593° 1100°F
Heat Rise Rate °/min.	55°C 100°F	55°C 100°F	55°C 100°F	55°C 100°F	55°C 100°F	44°C 80°F	44°C 80°F	44°C 80°F	44°C 80°F	55°C 100°F
Vacuum Setting	680-755MM 26"-29"	680-755MM 26"-29"	None	None	None	680-755MM 26"-29"	680-755MM 26"-29"	None	None	680-755MM 26"-29"
Firing Temp.	977°C 1790°F	960°C 1760°F	960°C 1760°F	849°C 1560°F	960°C 1760°F	804°C 1480°F	788°C 1450°F	788°C 1450°F	788°C 1450°F	1043°C 1910°F
Cooling	Bench Cool	Bench Cool	Bench Cool	Bench Cool	Bench Cool	Bench Cool	Bench Cool	Bench Cool	Bench Cool	Bench Cool
Texture	Eggshell	Shiny/Grainy Eggshell	Glossy	Glossy	Glossy	Eggshell	Shiny/Grainy Eggshell	Glossy	Glossy	Semi-Gloss
Thickness (approx)	0.2mm	1.3mm		Thin Coat	Thin Coat	0.2mm	1.3mm		Thin Coat	Thin Coat
Hold Time	None	None	15 sec.	15 sec.	15 sec.	1 min.	1 min.	15 sec.	15 sec.	None

*The above temperatures are recommended and can vary with individual furnaces and geographic location.

Las temperaturas anteriores son recomendadas y pueden variar de acuerdo con el horno usado y la ubicación geografica (altitud).

‡Ceramic LF Porcelain can be used as a post-completion repair add on for Ceramic Fine Grain Porcelain.

La porcelana de baja fusión Ceramic LF, puede ser usada para reparaciones despues de terminada la restauración hecha con Porcelana Regular - Ceramic Fine Grain.

* Met-Con is a bond enhancer and color controller for OPTIONAL use with all alloys that produce excessive oxide.

Met-Con es un mejorador de adhesión y controlador del color de uso OPCIONAL con aleaciones metalicas que produzcan excesivo oxido.