

Firing Guide

PROGRAMAT/IVOCLAR VIVADENT	B [°C]	S [min.]	t \nearrow [°C/min.]	T [°C]	H [min.]	VAC 1 [°C]/ VAC 2 [°C]	L [°C]	tL [°C/min.]
Celtra Paint-on Glaze (12:30 cycle time)	500	3:30	60	820	1:00	-	750	50
2nd & subsequent Glaze Firing (if needed) (10:00 cycle time)	500	3:00	60	770	1:00	-	750	50
Spray Glaze (Indenco) (11:00 cycle time)	500	2:00	60	820	1:00	-	750	50
Polish & Fire (10:00 cycle time)	500	1:00	60	820	1:00	-	750	50
Correction Porcelain	500	3:30	60	820	1:00	V1=500C V2=819C	750	50

Please note: A Dentsply Sirona Representative must program the oven in the doctor's office so that it is ready to properly fire Celtra Duo (ZLS). Don't assume that the doctor or someone else in the office will program it; using a firing program for a material other than Celtra Duo (ZLS) will result in restoration failure.

Explanation of the Ivoclar Programat Parameters

- B Stand-by temperature [°C]
- S Closing time [min.]
- t \nearrow Temperature increase rate [°C/min.]
- T Holding temperature [°C]
- H Holding time [min.]
- VAC 1 Vacuum on [°C]
- VAC 2 Vacuum off [°C]
- L Long-term cooling [°C]
- tL Cooling temperature rate