

Celtra® Duo (ZLS) Firing Schedules – Ivoclar Ovens

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 and 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

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



Celtra® Duo (ZLS) Firing Schedules – Vita Ovens

General Firing Recommendation and VACUMAT / VITA	Pre-drying °C	→ min. Pre-drying	↗ °C/min.	T °C End temperature	→ min. Holding time	↘ min. Long-term cooling	VAC min.
Celtra Paint-On Glaze	500	4:00	60	820	1:00	3:00	-
2 nd & Subsequent Glaze Firing – if needed	500	4:00	60	770	1:00	3:00	-
Spray Glaze (Indenco)	500	3:00	60	820	1:00	3:00	-
Polish and Fire	500	2:00	60	820	1:00	3:00	-
Correction Porcelain	500	4:00	60	820	1:30	3:00	1:30

Explanation of the General Recommendation/VITA VACUMAT firing parameters

Pre-drying °C	Start temperature
→	Pre-drying time in minutes, closing time
↗	Heating time in minutes
↗	Temperature rise rate in degrees Celsius per minute
T °C	End temperature
→	Holding time for end temperature in minutes
VAC min.	Vacuum holding time in minutes
↘	Long-term cooling in degrees Celsius

- Firing times range from 11-14 minutes, depending on Vita model

