

Dekema – New Generation.

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|---------------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 08:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 950/1742 | °C/°F | 75/167* | °C/°F/min | 01:00** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | 950/1742 | °C/°F | 100 | % | 01:00 | min |
| Paste Opaque 1 + 2 | | | | | | |

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|----------------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 06:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 930/1706 | °C/°F | 75/167* | °C/°F/min | 01:00** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | 930/1706 | °C/°F | 100 | % | 01:00 | min |
| Powder Opaque 1 + 2 | | | | | | |

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|------------------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 06:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 900/1652 | °C/°F | 55/131* | °C/°F/min | 01:00** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | 900/1652 | °C/°F | 100 | % | – | min |
| Shoulder firing 1 + 2 | | | | | | |

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|------------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 06:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 870/1598 | °C/°F | 55/131* | °C/°F/min | 02:00** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | 870/1598 | °C/°F | 100 | % | – | min |
| Dentin firing 1 | | | | | | |

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|------------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 04:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 870/1598 | °C/°F | 55/131* | °C/°F/min | 01:00** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | 870/1598 | °C/°F | 100 | % | – | min |
| Dentin firing 2 | | | | | | |

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|-----------------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 04:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 860/1580 | °C/°F | 75/167* | °C/°F/min | 00:20** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | 860/1580 | °C/°F | 100 | % | – | min |
| Correction firing*** | | | | | | |

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|-----------------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 04:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 860/1580 | °C/°F | 75/167* | °C/°F/min | 00:20** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | 860/1580 | °C/°F | 100 | % | – | min |
| Stains fixation bake | | | | | | |

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|---------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 04:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 870/1598 | °C/°F | 75/167* | °C/°F/min | 01:00** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | – | °C/°F | – | % | – | min |
| Glaze firing | | | | | | |

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|---------------------------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 06:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 860/1580 | °C/°F | 75/167* | °C/°F/min | 01:00** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | 860/1580 | °C/°F | 100 | % | – | min |
| Glaze firing with glaze liquid | | | | | | |

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|--------------------------------------|----------|-------|---------|-----------|---------|-----|
| T | | | | | – | min |
| S | | | | | 06:00 | min |
| V | 500/932 | °C/°F | | | – | min |
| Temp 1 | 860/1580 | °C/°F | 75/167* | °C/°F/min | 00:20** | min |
| Temp 2 | – | °C/°F | – | °C/°F/min | – | min |
| Temp 3 | – | °C/°F | – | °C/°F/min | – | min |
| VAC | 860/1580 | °C/°F | 100 | % | – | min |
| Touch Up glaze and correction | | | | | | |

* The firing quality can be improved with large restorations by reducing the heat rate.
 ** The firing quality can be improved with large restorations by extending the holding time.
 *** The correction masse has to be mixed 1 : 1 with Base Dentin, Dentin or Incisal.

| Austromat D2 | | | | | | | | | | | |
|--------------------------------|----------------|---|----------|----------|----------|--------------------|--------------|------------------|--------------|---------------|---------------|
| | START °C/°F | □ | ↗ min | ✦ min | VAC % | °C/°F ↻ min* | END °C/°F | ✦ min:s ** | (V) min:s | ∅ 1 min | 2 ∅ min |
| Paste Opaque 1 + 2 | 500/932 | 0 | 8 | 0 | 100 | 75/167 | 950/1742 | 01:00 | 01:00 | - | - |
| Powder Opaque 1 + 2 | 500/932 | 0 | 6 | 0 | 100 | 75/167 | 930/1706 | 01:00 | 01:00 | - | - |
| Shoulder firing 1 + 2 | 500/932 | 0 | 6 | 0 | 100 | 55/131 | 900/1652 | 01:00 | - | - | - |
| Dentin firing 1 | 500/932 | 0 | 6 | 0 | 100 | 55/131 | 870/1598 | 02:00 | - | - | - |
| Dentin firing 2 | 500/932 | 0 | 4 | 0 | 100 | 55/131 | 870/1598 | 01:00 | - | - | - |
| Correction firing*** | 500/932 | 0 | 4 | 0 | 100 | 75/167 | 860/1580 | 00:20 | - | - | - |
| Stains fixation bake | 500/932 | 0 | 4 | 0 | 100 | 75/167 | 860/1580 | 00:20 | - | - | - |
| Glaze firing | 500/932 | 0 | 4 | 0 | 0 | 75/167 | 870/1598 | 01:00 | - | - | - |
| Glaze firing with glaze liquid | 500/932 | 0 | 6 | 0 | 100 | 75/167 | 860/1580 | 01:00 | - | - | - |
| Touch Up glaze and correction | 500/932 | 0 | 6 | 0 | 100 | 75/167 | 860/1580 | 00:20 | - | - | - |

| Austromat M | | | | | | | | | | | |
|--------------------------------|----------------|---|----------|----------|--------------|--------------------|--------------|------------------|--------------|---------------|---------------|
| | START °C/°F | □ | ↗ min | ✦ min | VAC LEVEL | °C/°F ↻ min* | END °C/°F | ✦ min:s ** | (V) min:s | ∅ 1 min | 2 ∅ min |
| Paste Opaque 1 + 2 | 500/932 | 0 | 8 | 0 | 9 | 75/167 | 950/1742 | 01:00 | 01:00 | - | - |
| Powder Opaque 1 + 2 | 500/932 | 0 | 6 | 0 | 9 | 75/167 | 930/1706 | 01:00 | 01:00 | - | - |
| Shoulder firing 1 + 2 | 500/932 | 0 | 6 | 0 | 9 | 55/131 | 900/1652 | 01:00 | - | - | - |
| Dentin firing 1 | 500/932 | 0 | 6 | 0 | 9 | 55/131 | 870/1598 | 02:00 | - | - | - |
| Dentin firing 2 | 500/932 | 0 | 4 | 0 | 9 | 55/131 | 870/1598 | 01:00 | - | - | - |
| Correction firing*** | 500/932 | 0 | 4 | 0 | 9 | 75/167 | 860/1580 | 00:20 | - | - | - |
| Stains fixation bake | 500/932 | 0 | 4 | 0 | 9 | 75/167 | 860/1580 | 00:20 | - | - | - |
| Glaze firing | 500/932 | 0 | 4 | 0 | 9 | 75/167 | 870/1598 | 01:00 | - | - | - |
| Glaze firing with glaze liquid | 500/932 | 0 | 6 | 0 | 9 | 75/167 | 860/1580 | 01:00 | - | - | - |
| Touch Up glaze and correction | 500/932 | 0 | 6 | 0 | 9 | 75/167 | 860/1580 | 00:20 | - | - | - |

| Austromat 3001 | |
|------------------------------------|---|
| Paste Opaque 1 + 2*/** | C500 T480.L9 V9 TO75.C950 T60 V0 C0 L0 T2 C500 |
| Powder Opaque 1 + 2*/** | C500 T360.L9 V9 TO75.C930 T60 V0 C0 L0 T2 C500 |
| Shoulder firing 1 + 2*/** | C500 T360.L9 V9 TO55.C900 V0 T60 C0 L0 T2 C500 |
| Dentin firing 1*/** | C500 T360.L9 V9 TO55.C870 V0 T120 C0 L0 T2 C500 |
| Dentin firing 2*/** | C500 T300.L9 V9 TO55.C870 V0 T60 C0 L0 T2 C500 |
| Correction firing*/**/** | C500 T240.L9 V9 TO75.C860 V0 T20 C0 L0 T2 C500 |
| Stains fixation bake*/** | C500 T240.L9 V9 TO75.C860 V0 T20 C0 L0 T2 C500 |
| Glaze firing*/** | C500 T240.L9 TO75.C870 T60 C0 L0 T2 C500 |
| Glaze firing with glaze liquid*/** | C500 T360.L9 V9 TO75.C860 V0 T60 C0 L0 T2 C500 |
| Touch Up glaze and correction*/** | C500 T360.L9 V9 TO75.C860 V0 T20 C0 L0 T2 C500 |

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 *** The correction masse has to be mixed 1 : 1 with Base Dentin, Dentin or Incisal.

| P90 / P95 | | | | | | | |
|--------------------------------|-----------------------------|--------------------|-------------------------------|---------------------|-----------------------|--------------|---------------|
| | Base temperature °C / °F | Heat rate/ min* | Firing temperature °C / °F | Closing time min | Holding time min** | Vacuum ON | Vacuum OFF |
| Paste Opaque 1 + 2 | 403 / 757.4 | 75 | 950 / 1742 | 8 | 1 | 450 | 950 |
| Powder Opaque 1 + 2 | 403 / 757.4 | 75 | 930 / 1706 | 6 | 1 | 450 | 930 |
| Shoulder firing 1 + 2 | 403 / 757.4 | 55 | 900 / 1652 | 6 | 1 | 450 | 899 |
| Dentin firing 1 | 403 / 757.4 | 55 | 870 / 1598 | 6 | 2 | 450 | 869 |
| Dentin firing 2 | 403 / 757.4 | 55 | 870 / 1598 | 4 | 1 | 450 | 869 |
| Correction firing*** | 403 / 757.4 | 75 | 860 / 1580 | 4 | 00:20 | 450 | 859 |
| Stains fixation bake | 403 / 757.4 | 75 | 860 / 1580 | 4 | 00:20 | 450 | 859 |
| Glaze firing | 403 / 757.4 | 75 | 870 / 1598 | 4 | 1 | 450 | 869 |
| Glaze firing with glaze liquid | 403 / 757.4 | 75 | 860 / 1580 | 6 | 1 | 450 | 859 |
| Touch Up glaze and correction | 403 / 757.4 | 75 | 860 / 1580 | 6 | 00:20 | 450 | 859 |

| Vacumat 50 / 100 / 200 | | | | | | | |
|--------------------------------|-----------------------------|------------------------------|-----------------------|--------------------|-----------------------|---------------|---------|
| | Base temperature °C / °F | Final temperature °C / °F | Predrying time min | Heat rate/ min* | Holding time min** | Vacuum min | Cooling |
| Paste Opaque 1 + 2 | 500 / 932 | 950 / 1742 | 8 | 6 | 1 | 7 | - |
| Powder Opaque 1 + 2 | 500 / 932 | 930 / 1706 | 6 | 6 | 1 | 7 | - |
| Shoulder firing 1 + 2 | 500 / 932 | 900 / 1652 | 6 | 6 | 1 | 6 | - |
| Dentin firing 1 | 500 / 932 | 870 / 1598 | 6 | 7 | 2 | 7 | - |
| Dentin firing 2 | 500 / 932 | 870 / 1598 | 4 | 6 | 1 | 6 | - |
| Correction firing*** | 500 / 932 | 860 / 1580 | 4 | 5 | 00:20 | 5 | - |
| Stains fixation bake | 500 / 932 | 860 / 1580 | 4 | 5 | 00:20 | 5 | - |
| Glaze firing | 500 / 932 | 870 / 1598 | 4 | 5 | 1 | - | - |
| Glaze firing with glaze liquid | 500 / 932 | 860 / 1580 | 6 | 5 | 1 | 5 | - |
| Touch Up glaze and correction | 500 / 932 | 860 / 1580 | 6 | 5 | 00:20 | 5 | - |

| Multimat MCII, Mach 1, Mach 2, Touch 8 Press | | | | | | | | |
|--|-----------------------------------|--------------------|-------------------|---------------|----------------------|-------------------------------|--------------------|-------------------|
| | Preheating temperature °C / °F | Drying time min | Preheating min | Vacuum min | Firing time min** | Firing temperature °C / °F | Heat rate/ min* | Vacuum °C / °F |
| Paste Opaque 1 + 2 | 500 / 932 | 8 | - | 1.0 | 2.0 | 960 / 1760 | 75 | 50 / 122 |
| Powder Opaque 1 + 2 | 500 / 932 | 6 | - | 1.0 | 2.0 | 940 / 1724 | 75 | 50 / 122 |
| Shoulder firing 1 + 2 | 500 / 932 | 6 | - | 1.0 | 2.0 | 910 / 1670 | 55 | 50 / 122 |
| Dentin firing 1 | 500 / 932 | 6 | - | 2.0 | 3.0 | 880 / 1616 | 55 | 50 / 122 |
| Dentin firing 2 | 500 / 932 | 4 | - | 1.0 | 2.0 | 880 / 1616 | 55 | 50 / 122 |
| Correction firing*** | 500 / 932 | 4 | - | 1.0 | 1.0 | 870 / 1598 | 75 | 50 / 122 |
| Stains fixation bake | 500 / 932 | 4 | - | 1.0 | 1.0 | 870 / 1598 | 75 | 50 / 122 |
| Glaze firing | 500 / 932 | 4 | - | - | 1.5 - 2.5 | 880 / 1616 | 75 | 0 / 32 |
| Glaze firing with glaze liquid | 500 / 932 | 6 | - | 1.0 | 2.0 | 870 / 1598 | 75 | 50 / 122 |
| Touch Up glaze and correction | 500 / 932 | 6 | - | 1.0 | 1.0 | 870 / 1598 | 75 | 50 / 122 |

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Firing charts

HOTLINE +49 72 31 / 803 - 410

ceraMotion®
Me

Firing control

We recommend carrying out a test firing in order to assess the firing temperature of your furnace, as this is the only method of determining the firing procedure correctly.

The test sample is prepared by mixing transpa material T with the Modelling Liquid (REF 254-000-10).

Carry out the first dentin firing. When firing, place the test sample onto platinum foil and not onto a piece of firing wool, otherwise the results may appear cloudy.

The furnace temperature is correct if the fired test sample is clearly transparent and has sharp edges.

If the furnaces end temperature is too high, the fired test sample will be extremely shiny and has no sharp edges. If the end temperature is too low, the fired test sample will be milky white in colour.

Please increase/decrease the end temperature of the furnace in 10 °C / 50 °F steps. Subsequently re-fire the test sample.

Firing guide line

ceraMotion® Me has been developed specially for rapid cooling, this also concerns the use of non-precious alloys.

The surface of the ceramic should show a shiny appearance after baking.

For long-span bridges with massive pontics we are recommending the use of pins in every crown to support the construction.

Important:

Maintain furnace always closed. Close furnace after use or switch to night modus to prevent up-take of humidity.

D
DENTAURUM