

**Dekema – New Generation.**

T						–	min
S						08:00	min
V	500/932	°C/°F				–	min
Temp 1	950/1742 980/1796	°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 980/1796	°C/°F	100	%	01:00		min

Paste Opaque 1 + 2

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

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

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

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

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

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

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\*\*\*

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

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

For non-precious frameworks, the first paste opaque firing is 30 °C / 86 °F higher.

- \* 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 980/1796	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 980/1796	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/(980) 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 firing quality can be improved with large restorations by extending the holding time.
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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 980 / 1796	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 980 / 1796	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 990 / 1814	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.

Date of information: 11/20

**D**  
DENTAURUM