

Dekema – New Generation.

T					–	min
S					06:00	min
V	500/932	°C/°F			–	min
Temp 1	795/1463	°C/°F	65/149*	°C/°F/min	01:00**	min
Temp 2	–	°C/°F	–	°C/°F/min	–	min
Temp 3	–	°C/°F	–	°C/°F/min	–	min
VAC	795/1463	°C/°F	100	%	01:00	min
Paste Bonder						

T					–	min
S					04:00	min
V	500/932	°C/°F			–	min
Temp 1	795/1463	°C/°F	65/149*	°C/°F/min	01:00**	min
Temp 2	–	°C/°F	–	°C/°F/min	–	min
Temp 3	–	°C/°F	–	°C/°F/min	–	min
VAC	795/1463	°C/°F	100	%	01:00	min
Powder Bonder						

T					–	min
S					04:00	min
V	500/932	°C/°F			–	min
Temp 1	790/1454	°C/°F	65/149*	°C/°F/min	01:00**	min
Temp 2	–	°C/°F	–	°C/°F/min	–	min
Temp 3	–	°C/°F	–	°C/°F/min	–	min
VAC	790/1454	°C/°F	100	%	01:00	min
Opaque 1 + 2						

T					–	min
S					06:00	min
V	500/932	°C/°F			–	min
Temp 1	785/1445	°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	785/1445	°C/°F	100	%	01:00	min
Shoulder firing 1 + 2						

T					–	min
S					06:00	min
V	500/932	°C/°F			–	min
Temp 1	750/1382	°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	750/1382	°C/°F	100	%	01:00	min
Dentin firing 1						

T					–	min
S					04:00	min
V	500/932	°C/°F			–	min
Temp 1	750/1382	°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	750/1382	°C/°F	100	%	01:00	min
Dentin firing 2						

T					–	min
S					04:00	min
V	500/932	°C/°F			–	min
Temp 1	715/1319	°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	715/1319	°C/°F	100	%	01:00	min
Correction firing						

T					–	min
S					04:00	min
V	500/932	°C/°F			–	min
Temp 1	750/1382	°C/°F	65/149*	°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	750/1382	°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	750/1382	°C/°F	100	%	–	min
Glaze firing with glaze liquid						

T					–	min
S					06:00	min
V	500/932	°C/°F			–	min
Temp 1	730/1346	°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	730/1346	°C/°F	100	%	–	min
Touch Up glaze and correction						

* The firing quality can be improved with large restorations by reducing the heat rate.

** Extend the holding time with large restorations to compensate for the poor thermal conductivity of titanium.

*** Glaze firing can be completed with or without vacuum.

Austromat D2											
	START °C/°F	□	↗ min	✦ min	VAC LEVEL	°C/°F ⌚ min*	END °C/°F	✦ min:s **	(V) min:s	∅ 1 min	2 ∅ min
Paste Bonder	500/932	0	6	0	100	65/149	795/1463	1:00	1:00	–	–
Powder Bonder	500/932	0	4	0	100	65/149	795/1463	1:00	1:00	–	–
Opaque 1 + 2	500/932	0	4	0	100	65/149	790/1454	1:00	1:00	–	–
Shoulder firing 1 + 2	500/932	0	6	0	100	55/131	785/1445	1:00	1:00	–	–
Dentin firing 1	500/932	0	6	0	100	55/131	750/1382	1:00	1:00	–	–
Dentin firing 2	500/932	0	4	0	100	55/131	750/1382	1:00	1:00	–	–
Correction firing	500/932	0	4	0	100	55/131	715/1319	1:00	1:00	–	–
Glaze firing	500/932	0	4	0	0***	65/149	750/1382	1:00	–	–	–
Glaze firing with glaze liquid	500/932	0	6	0	100	55/131	750/1382	1:00	–	–	–
Touch Up glaze and correction	500/932	0	6	0	100	55/131	730/1346	1:00	–	–	–

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 Bonder	500/932	0	6	0	9	65/149	795/1463	1:00	1:00	–	–
Powder Bonder	500/932	0	4	0	9	65/149	795/1463	1:00	1:00	–	–
Opaque 1 + 2	500/932	0	4	0	9	65/149	790/1454	1:00	1:00	–	–
Shoulder firing 1 + 2	500/932	0	6	0	9	55/131	785/1445	1:00	1:00	–	–
Dentin firing 1	500/932	0	6	0	9	55/131	750/1382	1:00	1:00	–	–
Dentin firing 2	500/932	0	4	0	9	55/131	750/1382	1:00	1:00	–	–
Correction firing	500/932	0	4	0	9	55/131	715/1319	1:00	1:00	–	–
Glaze firing	500/932	0	4	0	0***	65/149	750/1382	1:00	–	–	–
Glaze firing with glaze liquid	500/932	0	6	0	9	55/131	750/1382	1:00	–	–	–
Touch Up glaze and correction	500/932	0	6	0	9	55/131	730/1346	1:00	–	–	–

Austromat 3001	
Paste Bonder*/**	C500 T360.L9 V9 TO65.C795 T60 V0 C0 L0 T2 C500
Powder Bonder*/**	C500 T240.L9 V9 TO65.C795 T60 V0 C0 L0 T2 C500
Opaque 1 + 2*/**	C500 T240.L9 V9 TO65.C790 T60 V0 C0 L0 T2 C500
Shoulder firing 1 + 2*/**	C500 T360.L9 V9 TO55.C785 T60 V0 C0 L0 T2 C500
Dentin firing 1*/**	C500 T360.L9 V9 TO55.C750 T60 V0 C0 L0 T2 C500
Dentin firing 2*/**	C500 T300.L9 V9 TO55.C750 T60 V0 C0 L0 T2 C500
Correction firing*/**	C500 T240.L9 V9 TO55.C715 T60 V0 C0 L0 T2 C500
Glaze firing*/**/**	C500 T240.L9 TO55.C750 T65 C0 L0 T2 C500
Glaze firing with glaze liquid*/**	C500 T360.L9 V9 TO55.C750 V0 T60 C0 L0 T2 C500
Touch Up glaze and correction*/**	C500 T360.L9 V9 TO55.C730 V0 T60 C0 L0 T2 C500

* The firing quality can be improved with large restorations by reducing the heat rate.

** Extend the holding time with large restorations to compensate for the poor thermal conductivity of titanium.

*** Glaze firing can be completed with or without vacuum.

P90 / P95							
	Base temperature °C / °F	Heat rate/ min*	Firing temperature °C / °F	Closing time min	Holding time min**	Vacuum ON	Vacuum OFF
Paste Bonder	403 / 757.4	65	795 / 1463	6	1	450	795
Powder Bonder	403 / 757.4	65	795 / 1463	4	1	450	795
Opaque 1 + 2	403 / 757.4	65	790 / 1454	4	1	450	790
Shoulder firing 1 + 2	403 / 757.4	55	785 / 1445	6	1	450	785
Dentin firing 1	403 / 757.4	55	750 / 1382	6	1	450	750
Dentin firing 2	403 / 757.4	55	750 / 1382	4	1	450	750
Correction firing	403 / 757.4	55	715 / 1319	4	1	450	715
Glaze firing***	403 / 757.4	65	750 / 1382	4	1	***	***
Glaze firing with glaze liquid	403 / 757.4	55	750 / 1382	6	1	450	749
Touch Up glaze and correction	403 / 757.4	55	730 / 1346	6	1	450	729

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 Bonder	500 / 932	795 / 1463	6	5	1	6	–
Powder Bonder	500 / 932	795 / 1463	4	5	1	6	–
Opaque 1 + 2	500 / 932	790 / 1454	4	5	1	6	–
Shoulder firing 1 + 2	500 / 932	785 / 1445	6	5	1	6	–
Dentin firing 1	500 / 932	750 / 1382	6	5	1	6	–
Dentin firing 2	500 / 932	750 / 1382	6	5	1	6	–
Correction firing	500 / 932	715 / 1319	4	4	1	5	–
Glaze firing***	500 / 932	750 / 1382	4	4	1	***	–
Glaze firing with glaze liquid	500 / 932	750 / 1382	6	5	1	6	–
Touch Up glaze and correction	500 / 932	730 / 1346	6	5	1	6	–

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 Bonder	500 / 932	6	–	1.0	2.0	805 / 1481	65	50 / 122
Powder Bonder	500 / 932	4	–	1.0	2.0	805 / 1481	65	50 / 122
Opaque 1 + 2	500 / 932	4	–	1.0	2.0	800 / 1472	65	50 / 122
Shoulder firing 1 + 2	500 / 932	6	–	1.0	2.0	795 / 1463	55	50 / 122
Dentin firing 1	500 / 932	6	–	1.0	2.0	760 / 1400	55	50 / 122
Dentin firing 2	500 / 932	4	–	1.0	2.0	760 / 1400	55	50 / 122
Correction firing	500 / 932	4	–	1.0	2.0	725 / 1337	55	50 / 122
Glaze firing***	500 / 932	4	–	***	1.5 - 2.5	760 / 1400	65	0 / 32
Glaze firing with glaze liquid	500 / 932	6	–	1.0	2.0	760 / 1400	55	50 / 122
Touch Up glaze and correction	500 / 932	6	–	1.0	2.0	740 / 1364	55	50 / 122

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** Extend the holding time with large restorations to compensate for the poor thermal conductivity of titanium.

*** Glaze firing can be completed with or without vacuum.

Firing charts

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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.

Important:

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

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