Firing charts

HOTLINE +49 72 31 / 803 - 410

ceramotion® Lf

Dekema – New Generation.

T					–	min
S					08:00	min
V	500/932	°C/°F			–	min
Temp 1	800/1472	°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	800/1472	°C/°F	100	%	–	min
Paste Opaque Base						

T					–	min
S					08:00	min
V	500/932	°C/°F			–	min
Temp 1	800/1472	°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	800/1472	°C/°F	100	%	–	min
Paste Opaque 1 + 2						

T					–	min
S					06:00	min
V	450/842	°C/°F			–	min
Temp 1	780/1436	°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	780/1436	°C/°F	100	%	01:00	min
Shoulder firing 1 + 2						

T					–	min
S					06:00	min
V	450/842	°C/°F			–	min
Temp 1	765/1409	°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	765/1409	°C/°F	100	%	01:00	min
Dentin firing 1						

T					–	min
S					04:00	min
V	450/842	°C/°F			–	min
Temp 1	765/1409	°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	765/1409	°C/°F	100	%	01:00	min
Dentin firing 2						

T					–	min
S					04:00	min
V	450/842	°C/°F			–	min
Temp 1	745/1373	°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	745/1373	°C/°F	100	%	–	min
Correction firing						

T					–	min
S					04:00	min
V	450/842	°C/°F			–	min
Temp 1	765/1409	°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	450/842	°C/°F			–	min
Temp 1	765/1409	°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	765/1409	°C/°F	100	%	–	min
Glaze firing with glaze liquid						

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

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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 Base	500/932	0	8	0	100	75/167	800/1472	01:00	0	–	–
Paste Opaque 1 + 2	500/932	0	8	0	100	75/167	800/1472	01:00	0	–	–
Shoulder firing 1 + 2	450/842	0	6	0	100	55/131	780/1436	01:00	01:00	–	–
Dentin firing 1	450/842	0	6	0	100	55/131	765/1409	01:00	01:00	–	–
Dentin firing 2	450/842	0	4	0	100	55/131	765/1409	01:00	01:00	–	–
Correction firing	450/842	0	4	0	100	55/131	745/1373	01:00	0	–	–
Glaze firing	450/842	0	4	0	0	75/167	765/1409	01:00	0	–	–
Glaze firing with glaze liquid	450/842	0	6	0	100	55/131	765/1409	01:00	0	–	–

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 Base	500/932	0	8	0	9	75/167	800/1472	01:00	0	–	–
Paste Opaque 1 + 2	500/932	0	8	0	9	75/167	800/1472	01:00	0	–	–
Shoulder firing 1 + 2	450/842	0	6	0	9	55/131	780/1436	01:00	01:00	–	–
Dentin firing 1	450/842	0	6	0	9	55/131	765/1409	01:00	01:00	–	–
Dentin firing 2	450/842	0	4	0	9	55/131	765/1409	01:00	01:00	–	–
Correction firing	450/842	0	4	0	9	55/131	745/1373	01:00	0	–	–
Glaze firing	450/842	0	4	0	0	75/167	765/1409	01:00	0	–	–
Glaze firing with glaze liquid	450/842	0	6	0	9	55/131	765/1409	01:00	0	–	–

Austromat 3001

Paste Opaque Base	C500 T480.L9 V9 TO75.C800 V0 T60 C0 L0 T2 C500
Paste Opaque 1 + 2	C500 T480.L9 V9 TO75.C800 V0 T60 C0 L0 T2 C500
Shoulder firing 1 + 2	C450 T360.L9 V9 TO55.C780 T60 V0 C0 L0 T2 C500
Dentin firing 1*/**	C450 T360.L9 V9 TO55.C765 T60 V0 C0 L0 T2 C500
Dentin firing 2*/**	C450 T300.L9 V9 TO55.C765 T60 V0 C0 L0 T2 C500
Correction firing	C450 T240.L9 V9 TO55.C745 V0 T60 C0 L0 T2 C500
Glaze firing	C450 T240.L9 TO75.C765 T60 C0 L0 T2 C500
Glaze firing with glaze liquid	C450 T360.L9 V9 TO55.C765 V0 T60 C0 L0 T2 C500

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Firing charts

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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 Base	403 / 757.4	75	800 / 1472	8	1	450	799
Paste Opaque 1 + 2	403 / 757.4	75	800 / 1472	8	1	450	799
Shoulder firing 1 + 2	403 / 757.4	55	780 / 1436	6	1	450	780
Dentin firing 1	403 / 757.4	55	765 / 1409	6	1	450	765
Dentin firing 2	403 / 757.4	55	765 / 1409	4	1	450	765
Correction firing	403 / 757.4	55	745 / 1373	4	1	450	744
Glaze firing	403 / 757.4	75	765 / 1409	4	1	450	–
Glaze firing with glaze liquid	403 / 757.4	55	765 / 1409	6	1	450	764

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 Base	500 / 932	800 / 1472	8	5	1	5	–
Paste Opaque 1 + 2	500 / 932	800 / 1472	8	5	1	5	–
Shoulder firing 1 + 2	450 / 842	780 / 1436	6	6	1	7	–
Dentin firing 1	450 / 842	765 / 1409	6	6	1	7	–
Dentin firing 2	450 / 842	765 / 1409	4	6	1	7	–
Correction firing	450 / 842	745 / 1373	4	5	1	5	–
Glaze firing	450 / 842	765 / 1409	4	5	1	5	–
Glaze firing with glaze liquid	450 / 842	765 / 1409	6	5	1	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 Base	500 / 932	8	–	1.0	2.0	810 / 1490	75	50 / 122
Paste Opaque 1 + 2	500 / 932	8	–	1.0	2.0	810 / 1490	75	50 / 122
Shoulder firing 1 + 2	450 / 842	6	–	1.0	2.0	790 / 1454	55	50 / 122
Dentin firing 1	450 / 842	6	–	1.0	2.0	775 / 1427	55	50 / 122
Dentin firing 2	450 / 842	4	–	1.0	2.0	775 / 1427	55	50 / 122
Correction firing	450 / 842	4	–	1.0	2.0	755 / 1391	55	50 / 122
Glaze firing	450 / 842	4	–	–	1.5 - 2.5	775 / 1427	75	0 / 32
Glaze firing with glaze liquid	450 / 842	6	–	1.0	2.0	775 / 1427	55	50 / 122

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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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