

Dekema – New Generation.

T					–	min
S					04:00	min
V	500/932	°C/°F			–	min
Temp 1	810/1490	°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	810/1490	°C/°F	100	%	02:00	min
Connecting firing Liner						

T					–	min
S					06:00	min
V	500/932	°C/°F			–	min
Temp 1	780/1436	°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	780/1436	°C/°F	100	%	02:00	min
Connecting firing Base Dentin /Dentin						

T					–	min
S					06:00	min
V	500/932	°C/°F			–	min
Temp 1	780/1436	°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	780/1436	°C/°F	100	%	02:00	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	02:00**	min
Temp 2	–	°C/°F	–	°C/°F/min	–	min
Temp 3	–	°C/°F	–	°C/°F/min	–	min
VAC	750/1382	°C/°F	100	%	02:00	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	02:00**	min
Temp 2	–	°C/°F	–	°C/°F/min	–	min
Temp 3	–	°C/°F	–	°C/°F/min	–	min
VAC	750/1382	°C/°F	100	%	02:00	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	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	***	°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 ZrO₂.
 *** Glaze firing can be completed with or without vacuum.

Austromat D2											
	START °C/°F	□	↗ min	✦ min	VAC %	°C/°F ↻ min*	END °C/°F	✦ min:s **	(V) min:s	∅ 1 min	2 ∅ min
Connecting firing Liner 1 + 2	500/932	0	4	0	100	55/131	810/1490	02:00	02:00	–	–
Connecting firing Base Dentin/Dentin	500/932	0	6	0	100	55/131	780/1436	02:00	02:00	–	–
Shoulder firing 1 + 2	500/932	0	6	0	100	55/131	780/1436	02:00	02:00	–	–
Dentin firing 1	500/932	0	6	0	100	55/131	750/1382	02:00	02:00	–	–
Dentin firing 2	500/932	0	4	0	100	55/131	750/1382	02:00	02:00	–	–
Correction firing	500/932	0	4	0	100	55/131	715/1319	01:00	01:00	–	–
Glaze firing	500/932	0	4	0	100	55/131	750/1382	01:00	***	–	–
Glaze firing with glaze liquid	500/932	0	6	0	0***	55/131	750/1382	01:00	–	–	–
Touch Up glaze and correction	500/932	0	6	0	100	55/131	730/1346	01:00	–	–	–

Austromat M											
	START °C/°F	□	↗ min	✦ min	VAC LEVEL	°C/°F ↻ min*	END °C/°F	✦ min:s **	(V) min:s	∅ 1 min	2 ∅ min
Connecting firing Liner 1 + 2	500/932	0	4	0	9	55/131	810/1490	02:00	02:00	–	–
Connecting firing Base Dentin/Dentin	500/932	0	6	0	9	55/131	780/1436	02:00	02:00	–	–
Shoulder firing 1 + 2	500/932	0	6	0	9	55/131	780/1436	02:00	02:00	–	–
Dentin firing 1	500/932	0	6	0	9	55/131	750/1382	02:00	02:00	–	–
Dentin firing 2	500/932	0	4	0	9	55/131	750/1382	02:00	02:00	–	–
Correction firing	500/932	0	4	0	9	55/131	715/1319	01:00	01:00	–	–
Glaze firing	500/932	0	4	0	9	55/131	750/1382	01:00	***	–	–
Glaze firing with glaze liquid	500/932	0	6	0	0***	55/131	750/1382	01:00	–	–	–
Touch Up glaze and correction	500/932	0	6	0	9	55/131	730/1346	01:00	–	–	–

Austromat 3001	
Connecting firing Liner 1 + 2*/**	C500 T240.L9 V9 TO55.C810 T120 V0 C0 L0 T2 C500
Connecting firing Base Dentin/Dentin*/**	C500 T360.L9 V9 TO55.C780 T120 V0 C0 L0 T2 C500
Shoulder firing 1 + 2*/**	C500 T360.L9 V9 TO55.C780 T120 V0 C0 L0 T2 C500
Dentin firing 1*/**	C500 T360.L9 V9 TO55.C750 T120 V0 C0 L0 T2 C500
Dentin firing 2*/**	C500 T300.L9 V9 TO55.C750 T120 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 T60 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

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** Extend the holding time with large restorations to compensate for the poor thermal conductivity of ZrO₂.

*** 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
Connecting firing Liner 1 + 2	403 / 757.4	55	810 / 1490	4	2	450	810
Connecting firing Base Dentin/Dentin	403 / 757.4	55	780 / 1436	6	2	450	780
Shoulder firing 1 + 2	403 / 757.4	55	780 / 1436	6	2	450	780
Dentin firing 1	403 / 757.4	55	750 / 1382	6	2	450	750
Dentin firing 2	403 / 757.4	55	750 / 1382	4	2	450	750
Correction firing	403 / 757.4	55	715 / 1319	4	1	450	715
Glaze firing***	403 / 757.4	55	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
Connecting firing Liner 1 + 2	500 / 932	810 / 1490	4	6	2	8	–
Connecting firing Base Dentin/Dentin	500 / 932	780 / 1436	6	6	2	8	–
Shoulder firing 1 + 2	500 / 932	780 / 1436	6	6	2	8	–
Dentin firing 1	500 / 932	750 / 1382	6	6	2	8	–
Dentin firing 2	500 / 932	750 / 1382	4	6	2	8	–
Correction firing	500 / 932	715 / 1319	4	4	1	5	–
Glaze firing***	500 / 932	750 / 1382	4	5	1	***	–
Glaze firing with glaze liquid	500 / 932	750 / 1382	6	5	1	5	–
Touch Up glaze and correction	500 / 932	730 / 1346	6	4	1	4	–

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
Connecting firing Liner 1 + 2	500 / 932	4	–	2.0	3.0	820 / 1508	55	50 / 122
Connecting firing Base Dentin/Dentin	500 / 932	6	–	2.0	3.0	790 / 1454	55	50 / 122
Shoulder firing 1 + 2	500 / 932	6	–	2.0	3.0	790 / 1454	55	50 / 122
Dentin firing 1	500 / 932	6	–	2.0	3.0	760 / 1400	55	50 / 122
Dentin firing 2	500 / 932	4	–	2.0	3.0	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	55	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

* 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 ZrO₂.

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

Firing charts

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cera^{motion}[®]_{Zr}

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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DENTAURUM