

HeraCeram® Stains universal

FIRING PROGRAMMES

IMPORTANT: The firing temperatures quoted here are guidelines only. Deviations may occur due to differences in furnace performance and may have to be compensated for if necessary.

General Firing Programme

	HeraCeram	HeraCeram Zirkonia	HeraCeram Press	Lithium Disilicate	Monolithic Zirconium Oxide
Preheating or starting temperature [°C]	600	600	600	600	600
Predrying and preheating time [min]	6	6	6	6	6
Heat rate [°C/min]	100	100	100	60	100
Final temperature [°C]	850	850	860	725	800
Holding time [min]	0,5–1	0,5–1	0,5–1	0,5–1	1
Vacuum start [°C]	–	–	–	600	600
Vacuum stop [°C]	–	–	–	725	800

Contact in Germany

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Heramat C/C2/C3/C3 press

	HeraCeram	HeraCeram Zirkonia	HeraCeram Press	Lithium Disilicate	Monolithic Zirconium Oxide
START [°C]	600	600	600	600	600
DRY [min]	5	4	5	4	4
PRE HEAT	1	2	1	2	2
HEAT RATE [°C/min]	100	100	100	60	100
HIGH TEMP [°C]	850	850	860	725	800
HOLD [min]	0,5-1	0,5-1	0,5-1	0,5-1	1
TEMPER [°C]	-	-	-	-	-
TEMP HOLD [min]	-	-	-	-	-
COOL TIME [min]	-	-	-	-	-
V ON [°C]	-	-	-	600	600
V OFF [°C]	-	-	-	725	800
V HOLD [min]	-	-	-	-	-

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Austromat 3001/Press-i-dent

HeraCeram	C600 T300•L9 T60 T099•C850 T30 C0 L0 T2 C600
HeraCeram Zirkonia	C600 T240•L9 T120 T099•C850 T30 C0 L0 T2 C600
HeraCeramPress	C600 T300•L9 T60 T099•C860 T30 C0 L0 T2 C600
Lithium Disilicate	C600 T240•L9 T120 V9 T060•C725 V0 T60 C0 L0 T2 C600
Monolithic Zirconium Oxide	C600 T240•L9 T120 V9 T099•C800 V0 T60 C0 L0 T2 C600

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Austromat M

	HeraCeram	HeraCeram Zirkonia	HeraCeram Press	Lithium Disilicate	Monolithic Zirconium Oxide
START	600	600	600	600	600
→	0	0	0	0	0
↑	5	4	5	4	4
→	1	2	1	2	2
Vac.	–	–	–	9	9
°C/min.	99	99	99	60	99
END	850	850	860	725	800
→	0:30–01:00	0:30–01:00	0:30–01:00	01:00	01:00
↘	0	0	0	0	0
↘	0	0	0	0	0

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Gemini II bzw. HT/HT Press

	HeraCeram	HeraCeram Zirkonia	HeraCeram Press	Lithium Disilicate	Monolithic Zirconium Oxide
Low temp. [°C]	600	600	600	600	600
Up time [min]	5	4	5	4	4
Preheat time	1	2	1	2	2
Heat rate [°C/min]	100	100	100	60	100
Vac. start [°C]	–	–	–	600	600
Vac. end [°C]	–	–	–	725	800
Vac. delay [min]	–	–	–	–	–
Vac. level [mm/Hg]	–	–	–	710	710
High temp. [°C]	850	850	860	725	800
Temp. delay [min]	0,5–1	0,5–1	0,5–1	1	1
Final temp. [°C]	–	–	–	–	–
Final delay [min]	–	–	–	–	–
Down time [min]	–	–	–	–	–

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Multimat MC II/Mach 2/Touch & Press

	HeraCeram	HeraCeram Zirkonia	HeraCeram Press	Lithium Disilicate	Monolithic Zirconium Oxide
Preheat temp. [°C]	600	600	600	600	600
Drying [min]	5	4	5	4	4
Preheating [min]	1	2	1	2	2
Vacuum time [°C]	–	–	–	1	1
Firing time [min]	1	1	1	2	2
Firing temp. [°C]	850	850	860	725	800
Heat rate [°C/min]	100	100	100	60	100
Vacuum [hPa]	–	–	–	50	50

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Programat P90/P95

	HeraCeram	HeraCeram Zirkonia	HeraCeram Press	Lithium Disilicate	Monolithic Zirconium Oxide
Standby temp. [°C]	600	600	600	600	600
Heat rate [°C/min]	100	100	100	60	100
Firing temp. [°C]	850	850	860	725	800
Clos. time [min]	6	6	6	6	6
Holding time [min]	0,5–1	0,5–1	0,5–1	1	1
Vac. ON [°C]	–	–	–	600	600
Vac. OFF [°C]	–	–	–	724	799
Vacuum [mbar]	–	–	–	50	50

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Programat X1/EP 600

	HeraCeram	HeraCeram Zirkonia	HeraCeram Press	Lithium Disilicate	Monolithic Zirconium Oxide
Standby temp. [°C]	600	600	600	600	600
Clos. time [min]	6	6	6	6	6
Heat rate [°C/min]	100	100	100	60	100
Firing temp. [°C]	850	850	860	725	800
Holding time [min]	0,5–1	0,5–1	0,5–1	1	1
Vac. ON [°C]	–	–	–	600	600
Vac. OFF [°C]	–	–	–	1° unter T	1° unter T

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Vacumat 2500

	HeraCeram	HeraCeram Zirkonia	HeraCeram Press	Lithium Disilicate	Monolithic Zirconium Oxide
Standby temp. [°C]	600	600	600	600	600
Final temp. [°C]	850	850	860	725	800
Drying [min]	6	6	6	6	6
Heat rate [°C/min]	100	100	100	60	100
Holding time [min]	0,5–1	0,5–1	0,5–1	1	1
Vac. time [min]	–	–	–	3	3

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Cergo Compact/Press

	HeraCeram	HeraCeram Zirkonia	HeraCeram Press	Lithium Disilicate	Monolithic Zirconium Oxide
Drying [°C]	–	–	–	–	–
Drying [min]	0	0	0	0	0
Closing time [min]	5	4	5	4	4
Preheating [°C]	600	600	600	600	600
Preheating [min]	1	2	1	2	2
Heat rate [°C/min]	100	100	100	60	100
Vacuum	–	–	–	0n	0n
Vac. ON [°C]	–	–	–	600	600
Vac. OFF [min]	–	–	–	725	800
Final temp. [°C]	850	850	860	725	800
V HOLD [min]	0	0	0	0	0
HOLD [min]	0,5–1	0,5–1	0,5–1	1	1
TEMPER [min]	0	0	0	0	0
TEMPER [°C]	–	–	–	–	–
COOL TIME [min]	0	0	0	0	0

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