

Firing Instructions for Proceed Zr

	Preheating temp.	Drying time	Raise of temp.	Vacuum	Final temp.	Holding time	Appearance
Shoulder Firing	450°C	4 min	45°C/min	Yes	830°C	1 min	Shining
Liner-Firing	450°C	4 min	55°C/min	Yes	800°C	1 min	Slightly shining
1st Dentin Firing	450°C	6 min	45°C/min	Yes	810°C	1 min	Slightly shining
2nd Dentin Firing	450°C	6 min	45°C/min	Yes	800°C	1 min	Slightly shining
Glaze Firing	480°C	2 min	45°C/min	---	820°C	---	Shining
Glaze firing with glaze powder	480°C	2 min	45°C/min	---	790°C	1 min	Shining
Correction Powder Firing	450°C	4 min	45°C/min	Yes	690°C	1 min	Shining

The above mentioned firing parameters are only guidelines and therefore always need to be adjusted to the firing furnace and its correct functionality. Most important is to obtain the right firing result. These firing parameters can only be used as guidelines.