

Amber Mill Firing Schedule – Standard Mode

[Austromat 624i, DEKEMA]

HT

Dry			--:--
Close			02:00
Preheat	450°C		01:00
Temperature 1	830°C	60°C/min	15:00
Temperature 2	690°C	60°C/min	--:--
Temperature 3	___°C	___°C/min	--:--
VAC(off/level/hold)	830°C	100%	15:00

MT

Dry			--:--
Close			02:00
Preheat	450°C		01:00
Temperature 1	840°C	60°C/min	15:00
Temperature 2	690°C	60°C/min	--:--
Temperature 3	___°C	___°C/min	--:--
VAC(off/level/hold)	840°C	100%	15:00

LT (31:10)

Dry			--:--
Close			02:00
Preheat	450°C		01:00
Temperature 1	855°C	60°C/min	15:00
Temperature 2	690°C	60°C/min	--:--
Temperature 3	___°C	___°C/min	--:--
VAC(off/level/hold)	855°C	100%	15:00

MO

Dry			--:--
Close			02:00
Preheat	450°C		01:00
Temperature 1	875°C	60°C/min	15:00
Temperature 2	690°C	60°C/min	--:--
Temperature 3	___°C	___°C/min	--:--
VAC(off/level/hold)	875°C	100%	15:00

Amber Mill Firing Schedule – Rapid Mode

[Austromat 624i, DEKEMA]

HT(16:00)

Dry			--:--
Close			01:00
Preheat	400°C		01:00
Temperature 1	780°C	90°C/min	00:00
Temperature 2	830°C	30°C/min	05:00
Temperature 3	___°C	___°C/min	--:--
VAC(off/level/hold)	830°C	100%	05:00

MT(15:00)

Dry			--:--
Close			01:00
Preheat	400°C		01:00
Temperature 1	780°C	90°C/min	00:00
Temperature 2	840°C	30°C/min	03:00
Temperature 3	___°C	___°C/min	--:--
VAC(off/level/hold)	840°C	100%	03:00

LT(15:30)

Dry			--:--
Close			01:00
Preheat	400°C		01:00
Temperature 1	780°C	90°C/min	00:00
Temperature 2	855°C	30°C/min	03:00
Temperature 3	___°C	___°C/min	--:--
VAC(off/level/hold)	855°C	100%	03:00

MO(16:00)

Dry			--:--
Close			01:00
Preheat	400°C		01:00
Temperature 1	780°C	90°C/min	00:00
Temperature 2	875°C	30°C/min	03:00
Temperature 3	___°C	___°C/min	--:--
VAC(off/level/hold)	875°C	100%	03:00

NOTE:

- Standard Mode for crowns more than two-unit bridge with glaze made by paste or powder.
- Rapid Mode for veneer or crowns with only spray type glaze.

Amber Mill Firing Schedule – Rapid Mode

[Programat CS, Ivoclar vivadent]

	Stand-by temperature B [°C]	Closing time S [min]	Heating rate t ₁ [°C/min]	Firing temperature T ₁ [°C]	Holding time H ₁ [min]	Heating rate t ₂ [°C/min]	Firing temperature T ₂ [°C]	Holding time H ₂ [min]	Vacuum 1 V ₁₁ /V ₁₂ [°C]	Vacuum 2 V ₂₁ /V ₂₂ [°C]	Long-term cooling L [°C]	Cooling rate t _i [°C/mic]
HT (16:00)	400	1:00	90	780	0:00	30	815	5:00	690/780	780/815	690	40
MT (14:30)	400	1:00	90	780	0:00	30	830	3:00	690/780	780/830	690	40
LT (15:30)	400	1:00	90	780	0:00	30	845	3:00	690/780	780/845	690	40
MO (16:00)	400	1:00	90	780	0:00	30	865	3:00	690/780	780/865	690	40

NOTE:

- Standard Mode for crowns more than two-unit bridge with glaze made by paste or powder.
- Rapid Mode for veneer or crowns with only spray type glaze.