Nabertherm

MORE THAN HEAT 30-3000 °C

Material-ID	100019
Hersteller	Ivoclar
Beschreibung	Reserve
Material Name	IPS e.max Press Schichttechnik

	Prozesse	Vortrocknen					Schließen					Vorwärmen					Brennen 1					Brennen 2					Brennen 3					Kühlen				
Programm-nummer	Name	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum	Freigeschaltet	Rate [°/min]	Temperatur [°]	Haltezeit [s]	Vakuum
1	Washbrand (Foundation)						x			240							x	90	650	1	x	x	20	730	120	x										
2	Washbrand Charakterisierung						x			240							x	90	650	1	x	x	20	730	120	x										
3	1./2. Dentin / Incisal						x			240							x	90	650	1	x	x	20	730	120	x										
4	Malfarbenbrand e.max Ceram						x			360							x	60	725	60	x															
5	Malfarbenbrand Ivocolor						x			360							x	60	710	60	x															
6	Glanzbrand e.max Ceram						x			360							x	60	725	60	x															
7	Glanzbrand Ivocolor						x			360							x	60	710	60	x															
8	Add-On + Glanzbrand e.max Ceram						x			360							x	60	725	60	x															
9	Add-On mit Glanzbrand Ivocolor						x			360							x	60	710	60	x															
10	Add-On nach Glanzbrand						x			360							x	50	700	60	x															

Material-ID	100019
Manufacturer	Ivoclar
Description	Reserve
Material name	IPS e.max Press layering technique

	Processes	Predrying					Closing					Preheating					Firing 1					Firing 2					Firing 3					cooling				
Program number	Name	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum
1	Washbrand (Foundation)						x			240							x	90	650	1	x	x	20	730	120	x										
2	Wash firing characterization						x			240							x	90	650	1	x	x	20	730	120	x										
3	1./2. Dentin / Incisal						x			240							x	90	650	1	x	x	20	730	120	x										
4	Stain firing e.max Ceram						x			360							x	60	725	60	x															
5	Stain firing Ivocolor						x			360							x	60	710	60	x															
6	Glaze firing e.max Ceram						x			360							x	60	725	60	x															
7	Glaze firing Ivocolor						x			360							x	60	710	60	x															
8	Add-On + Glaze firing e.max Ceram						x			360							x	60	725	60	x															
9	Add-On with Glaze firing Ivocolor						x			360							x	60	710	60	x															
10	Add-On after Glaze firing						x			360							x	50	700	60	x															