



MORE THAN HEAT 30-3000 °C

Material-ID	100023
Hersteller	Ivoclar
Beschreibung	Reserve
Material Name	IPS e.max CAD Crystall/Glaze

Programmnummer	Name	Prozesse				Vortrocknen				Schließen				Vorwärmen				Brennen 1				Brennen 2				Brennen 3				Kühlen				
		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	Kristallisation LT/MT/HT					x		403	360							x	90	830	10	x	x	30	850	420	x					x	STEP	710		
2	Malfarben-/Korrekturbrand					x		403	360							x	90	830	10	x	x	30	850	180	x					x	STEP	710		
3	Fügen/Kristallisation CAD-on					x		403	120							x	30	830	120	x	x	30	850	420	x					x	STEP	610	360	
4	Glasure/Korrektur CAD-on					x		403	360							x	60	830	10	x	x	30	850	180	x					x	STEP	610		
5	Speed-Kristallisation					x		403	30							x	120	850	1	x	x	70	870	210	x					x	STEP	705	1	
6	Crystallization MO/Imp./LT/MT/HT					x		403	360							x	60	780	10	x	x	30	860	600	x					x	STEP	710		

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Program number	Name	Processes				Predrying				Closing				Preheating				Firing 1				Firing 2				Firing 3				cooling				
		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	Crystallization LT/MT/HT					x		403	360							x	90	830	10	x	x	30	850	420	x					x	STEP	710		
2	Corrective / Stains firing					x		403	360							x	90	830	10	x	x	30	850	180	x					x	STEP	710		
3	Fusion/Crystallization firing CAD-on					x		403	120							x	30	830	120	x	x	30	850	420	x					x	STEP	610	360	
4	Corrective/Glaze firing CAD-on					x		403	360							x	60	830	10	x	x	30	850	180	x					x	STEP	610		
5	Speed Crystallization					x		403	30							x	120	850	1	x	x	70	870	210	x					x	STEP	705	1	
6	Crystallization MO/Imp./LT/MT/HT					x		403	360							x	60	780	10	x	x	30	860	600	x					x	STEP	710		