

Material-ID	100027
Hersteller	Ivoclar
Beschreibung	Reserve
Material Name	IPS InLine PoM

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	1./2. Pulveropaquer-Brand					x		403	240							x	100	960	120	x																		
2	1./2. Pastenopaquer-Brand					x		403	360							x	100	930	120	x																		
3	Touch Up-Brand					x		403	240							x	60	840	60	x																		
4	Malfarbenbrand Ivocolor					x		403	360							x	60	710	60	x																		
5	Malfarbenbrand InLine					x		403	360							x	60	800	60	x																		
6	Glanzbrand Ivocolor					x		403	360							x	60	710	60	x																		
7	Glanzbrand InLine					x		403	360							x	60	800	120	x																		
8	Add-On nach Glanzbrand 690°C					x		403	240							x	60	690	60	x																		

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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	Enable	Rate [°/min]	Temperature [°]	Hold time [s]	Vacuum			
1	1st / 2nd powder opaquer firing					x		403	240							x	100	960	120	x																			
2	1st / 2nd paste opaquer firing					x		403	360							x	100	930	120	x																			
3	Touch Up firing					x		403	240							x	60	840	60	x																			
4	Stains firing Ivocolor					x		403	360							x	60	710	60	x																			
5	Stains firing InLine					x		403	360							x	60	800	60	x																			
6	Glaze firing Ivocolor					x		403	360							x	60	710	60	x																			
7	Glaze firing InLine					x		403	360							x	60	800	120	x																			
8	Add-On after Glaze firing 690°C					x		403	240							x	60	690	60	x																			