Nabertherm

MORE THAN HEAT 30-3000 °C

Material-ID	100035
Hersteller	Ivoclar
Beschreibung	Reserve
Material Name	IPS d.SIGN

	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	1. Opaquerbrand Wash						x		403	360							x	80	900	60	x															
2	2. Opaquerbrand						x		403	360							x	80	890	60	x															
3	1./2. Margin-Brand						x		403	360							x	60	890	60	x															
4	1./2. Dentin-/Incisal-Brand						x		403	240							x	60	870	60	x															
5	Malfarbenbrand Ivocolor						x		403	360							x	60	800	60	x															
6	Malfarbenbrand d.SIGN						x		403	240							x	60	830	60	x															
7	Glanzbrand Ivocolor						x		403	360							x	60	800	60	x															
8	Glanzbrand d.SIGN						x		403	240							x	60	830	60	x															
9	Glanzbrand ohne Glasur						x		403	240							x	60	870	60	x															
10	Margin Add-On-Brand						x		403	240							x	60	830	60	x															
11	Add-On Mix 1:1						x		403	240							x	60	810	60	x															
12	Add-On-Brand						x		403	240							x	60	750	60	x															

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	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	1st Wash Opaquer firing						x		403	360							x	80	900	60	x															
2	2nd Opaquer firing						x		403	360							x	80	890	60	x															
3	1st / 2nd Margin firing						x		403	360							x	60	890	60	x															
4	1st / 2nd Dentin / Incisal firing						x		403	240							x	60	870	60	x															
5	Stains firing Ivocolor						x		403	360							x	60	800	60	x															
6	Stains firing d.SIGN						x		403	240							x	60	830	60	x															
7	Glaze firing Ivocolor						x		403	360							x	60	800	60	x															
8	Glaze firing d.SIGN						x		403	240							x	60	830	60	x															
9	Glaze firing w.o. Glaze						x		403	240							x	60	870	60	x															
10	Margin Add-On firing						x		403	240							x	60	830	60	x															
11	Add-On Mix 1:1 firing						x		403	240							x	60	810	60	x															
12	Add-On firing						x		403	240							x	60	750	60	x															