



MORE THAN HEAT 30-3000 °C

Material-ID	100053
Hersteller	Noritake Goldquadrat
Beschreibung	Reserve
Material Name	Quattro Ceramic HI 2007

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.	Opakerbrand (Waschbrand)	x		450	240		x		450	120						x	55	820	120	x													
2.	Opakerbrand	x		450	240		x		450	120						x	55	820	120	x													
3.	Marginbrand	x		500	60		x		500	60						x	45	780	60	x													
4.	Marginbrand	x		500	60		x		500	60						x	45	770	60	x													
5.	Dentinbrand	x		500	120		x		500	60		x		500	60	x	45	770	60	x													
6.	Dentinbrand	x		500	120		x		500	60		x		500	60	x	45	760	60	x													
7.	Glanzbrand ohne Glasurmasse						x			60						x	45	740	60														
8.	Glanzbrand mit Glasurmasse						x			60						x	45	740	120														
9.	1. Korrekturbrand						x			60						x	45	730	120	x													
10.	2. Korrekturbrand						x			60						x	45	730	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		
1.	opaque fire (wash fire)	x		450	240		x		450	120						x	55	820	120	x													
2.	opaque fire	x		450	240		x		450	120						x	55	820	120	x													
3.	margin firing	x		500	60		x		500	60						x	45	780	60	x													
4.	margin firing	x		500	60		x		500	60						x	45	770	60	x													
5.	dentine firing	x		500	120		x		500	60		x		500	60	x	45	770	60	x													
6.	dentine firing	x		500	120		x		500	60		x		500	60	x	45	760	60	x													
7.	Glaze firing without glazing material						x			60						x	45	740	60														
8.	Glaze firing with glazing material						x			60						x	45	740	120														
9.	1. Correction firing						x			60						x	45	730	120	x													
10.	2. Correction firing						x			60						x	45	730	60	x													