



MORE THAN HEAT 30-3000 °C

Material-ID	100067
Hersteller	Vita Zahnfabrik
Beschreibung	Reserve
Material Name	In-Ceram SPINELL Schleiftechnik

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	Reinigungsbrand	x		600	180		x		600	180						x	33	700	300														
2	Optimizerbrand	x		200	600		x		200	720						x	78	1140	2400														
3	Glasinfiltrationsbrand	x		600	240		x		600	720						x	44	1130	1200	x													
4	Glaskontrollbrand	x		600			x		600	300						x	80	1000	300														

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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	Cleansing firing	x		600	180		x		600	180						x	33	700	300														
2	Optimizer firing	x		200	600		x		200	720						x	78	1140	2400														
3	Glass infiltration firing	x		600	240		x		600	720						x	44	1130	1200	x													
4	Glass control firing	x		600			x		600	300						x	80	1000	300														