




Firing Instructions

LF



	Preheating temp.	Drying time	Raise of temp.	Vacuum start @	Final temp.	Holing time	Appearance
Oxidation	Refer to the alloy manufacturer's instructions						
1st Opaque Firing	400° C	4 min → 2 min ↑	50° C/min	500° C, Yes	840° C	1 min	High Shining
2nd Opaque Firing	400° C	4 min → 2 min ↑	50° C/min	500° C, Yes	830° C	1 min	High Shining
1st and 2nd Shoulder Firing	400° C	4 min ↑	50° C/min	500° C, Yes	820° C	1 min	Slightly Shining
1st Dentine Firing	400° C	6 min → 2 min ↑	40° C/min	500° C, Yes	780° C	1 min	Slightly Shining
2nd Dentine Firing	400° C	6 min → 2 min ↑	40° C/min	500° C, Yes	760° C	1 min	Slightly Shining
Glaze Firing	430° C	2 min ↑	40° C/min	780° C	Shining
Glaze firing with glaze powder	430° C	2 min ↑	40° C/min	750° C	1 min	Shining
Correction powder firing	350° C	4 min ↑	40° C/min	500° C, Yes	690° C	1 min	Shining

Final Temperature 는 guide line 일뿐 porcelain furnace 마다 다르므로 조정해야함.
 즉, Final Temperature 가 몇도를 가르키는 것과 상관없이 crown 을 bake 한후
 결표면(Appearance)이 오른쪽 도표 같이 꼭 나타나야함.