


# Firing Instructions

TI



	Preheating temp.	Drying time	Raise of temp.	Vacuum start @	Final temp.	Holing time	Appearance
Ti Bonder Firing	400° C	4 min + 2 min → ↑	50° C/min	500° C, Yes	810° C	1 min	High Shining
1st Opaque Firing	400° C	4 min + 2 min → ↑	50° C/min	500° C, Yes	820° C	1 min	High Shining
2nd Opaque Firing	400° C	4 min + 2 min → ↑	50° C/min	500° C, Yes	820° C	1 min	High Shining
Shoulder Firing	400° C	4 min ↑	40° C/min	500° C, Yes	810° C	1 min	Slightly Shining
1st Dentine Firing	350° C	6 min + 2 min ↑ ↑	40° C/min	500° C, Yes	790° C	1 min	Slightly Shining
2nd Dentine Firing	350° C	6 min + 2 min ↑ ↑	40° C/min	500° C, Yes	775° C	1 min	Slightly Shining
Glaze Firing	400° C	2 min ↑	40° C/min	.....	785° C	1 min	Shining
Glaze firing with glaze powder	430° C	2 min ↑	40° C/min	.....	780° 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  
 겉표면(Appearance)이 오른쪽 도표 같이 꼭 나타나야함.