

DEKEMA Austromat 654 / 624i¹⁾

	HT+			HT			MT			LT			MO		
Dry			---			---			---			---			---
Close			06:00			06:00			06:00			06:00			06:00
Preheat/°C	430		00:00	430		00:00	430		00:00	430		00:00	430		00:00
Tem.1/°C	840	60/min	15:00	850	60/min	15:00	855	60/min	15:00	860	60/min	15:00	880	60/min	15:00
Tem.2/°C	690	60/min	---	690	60/min	---	690	60/min	---	690	60/min	---	690	60/min	---
Tem.3/°C	—	—/min	---	—	—/min	---	—	—/min	---	—	—/min	---	—	—/min	---
VAC (off/level/hold)	840	100%	15:00	850°C	100%	15:00	855	100%	15:00	860	100%	15:00	880	100%	15:00

* The firing chamber must not be opened during long term cooling.

1) Austromat 654 / 624i is a registered trademark of DEKEMA.

IVOCLAR VIVADENT PROGRAMAT CS²⁾

B °C	S min.	↑ °C/min.	T °C		H min.	VAC. 1/ VAC. 2 °C		L °C	tl*
430	6:00	60	HT+	840	15:00	HT+	550/840	690	0
			HT	850		HT	550/850		
			MT	855		MT	550/855		
			LT	860		LT	550/860		
			MO	880		MO	550/880		

* The firing chamber must not be opened during long term cooling.

2) PROGRAMAT CS is a registered trademark of IVOCALR VIVADENT.

VITA VACUMAT³⁾

Predry °C	→ min.	↗ min.	↗ °C / min.	T °C		→ min.	VAC min.		↘ °C*	
430	6:00	HT+	6:50	60	HT+	840	15:00	HT+	21:50	690
		HT	7:00		HT	850		HT	22:00	
		MT	7:05		MT	855		MT	22:05	
		LT	7:10		LT	860		LT	22:10	
		MO	7:30		MO	880		MO	22:30	

* The firing chamber must not be opened during long term cooling.

3) VACUMAT is a registered trademark of VITA.

! for Re-firing

- Do not exceed 885°C as the maximum temperature for any heat treatment, including re-firing.
- The re-firing schedule uses the same temperature as the initial firing schedule.
(HT+: 840°C / HT: 850°C / MT: 855°C / LT: 860°C / MO: 880°C)
- Use Amber Mill VCK to measure the actual furnace temperature during the crystallization process.
Based on the measurement results, adjust the maximum temperature of the crystallization schedule accordingly.

! for Build up

- Veneering powder for Amber Mill is highly compatible and can be used with LS2 veneering powders that have a *CTE of $10 \times 10^{-6} / ^\circ\text{C}$ or lower. *Coefficient of Thermal Expansion
It is also compatible with certain zirconia veneering powders, provided that their firing temperature does not exceed 850°C.

Q. If crystallization is performed under HT+ conditions (840°C / 15 mins) and the build-up powder is fired at 850°C for 1 min, will there be any change in translucency? (In general, the holding time at the peak temperature during powder firing is less than 1 min.)

A. Even if the peak firing temperature of the build-up powder is higher than that of the crystallization process, there is no change in translucency because the holding time at the peak temperature is less than 1 min.

Translucency Designations by Porcelain Powder

- HT+ Transparent Enamel translucency
- HT Enamel translucency
- MT Medium translucency (between HT and LT)
- LT Dentin translucency
- MO Opaque Dentin translucency

! Crystallization firing must be performed under vacuum.