VITA AMBRIA® pressing parameters

VITA VACUMAT 6000 MP (VITA Zahnfabrik)

Pressing programs VITA AMBRIA										
Programs	Pre-drying temperature	Rise time	Heating rate / temperature gradient	Pressing temperature	Holding time	Pressing time 1	Pressing pressure 1	Pressing time 2	Pressing pressure 2	Cooling temperature
	°C	min	°C/min	°C	min	min	bar	min	bar	°C
100 g investment ring	700	3:36	50	880	25:00	3:00	3.0	1:00	3.0	–
200 g investment ring	700	3:48	50	890	30:00	3:00	3.0	1:00	3.0	–

We recommend calibrating the furnace prior to the first pressing (see VITA AMBRIA calibration information #10642).

Firing programs VITA AKZENT Plus / VITA LUMEX AC							
Programs	Pre-drying temperature	Pre-drying time	Temperature gradient	Firing temperature	Firing time	Vacuum	Long-term cooling
	°C	min	°C/min	°C	min	Vac.	°C
Tempering*	400	4:00	55	800	8:00	on	680
Stains fixation firing	400	4:00	80	700	1:00	-	-
First dentine firing	400	6:00	50	760	1:00	on	500**
Second dentine firing	400	6:00	50	755	1:00	on	500**
Glaze firing	400	4:00	80	750	1:00	-	500**
Glaze firing with GLAZE LT	400	6:00	80	750	1:00	-	500**
Corrective firing	400	4:00	50	725	1:00	on	500**

*) Tempering is a firing program which is carried out before the first firing cycle. Tempering increases the flexural strength of the VITA AMBRIA restoration to > 550 MPa.

**) Long-term cooling to the appropriate temperature is recommended for the last firing cycle.
The lift position for VITA VACUMAT 6000M furnaces should be > 75%. The fired items must be protected from drafts after opening the furnace.

The values specified here are guide values and are provided solely as a point of reference. Variations in the firing result can occur. The firing result depends on the performance of the furnace in question, and on the manufacturer and age of the furnace. Due to this, the guide values must be individually adapted to the corresponding furnace.
This information has been carefully prepared and verified by VITA, but does not constitute a guarantee.

VITA AMBRIA® pressing parameters

Programat EP5010 (Ivoclar Vivadent)

Pressing programs VITA AMBRIA					
Programs	**Standby**	**Heating rate**	**End temperature**	**Holding time**	**Stop speed**
	B (°C)	**t ↑ (°C/min)**	**T (°C)**	**H (min)**	**E (µm/min)**
100 g investment ring	700	50	880	25:00	300
200 g investment ring	700	50	890	30:00	300

The pressing parameters specified are guide values and apply to Ivoclar Vivadent Programat EP5010.
With older generation furnaces, the temperature in the firing chamber may vary by approx. ± 10 °C, depending on the age of the firing muffle. Temperature adjustments can not be excluded.

We recommend calibrating the furnace prior to the first pressing (see VITA AMBRIA calibration information #10642).

Firing programs VITA AKZENT Plus / VITA LUMEX AC									
Programs	**Standby temperature**	**Closing time**	**Heating rate**	**Firing temperature**	**Holding time**	**Vacuum 1**	**Vacuum 2**	**Long-term cooling**	**Cooling rate**
	B (°C)	**S (min)**	**t ↗ (°C/min)**	**T_1 (°C)**	**H_1 (min)**	**V1 (°C)**	**V2 (°C)**	**L (°C)**	**tl (°C/min)**
Tempering*	403	4:00	55	800	8:00	400	799	680	0
Stains fixation firing	403	4:00	80	700	1:00	400	699	-	-
First dentine firing	403	6:00	50	760	1:00	400	759	500**	0
Second dentine firing	403	6:00	50	755	1:00	400	754	500**	0
Glaze firing	403	4:00	80	750	1:00	400	749	500**	0
Glaze firing GLAZE LT	403	6:00	80	750	1:00	400	749	500**	0
Corrective firing	403	4:00	50	725	1:00	400	724	500**	0

*) Tempering is a firing program which is carried out before the first firing cycle. Tempering increases the flexural strength of the VITA AMBRIA restoration to > 550 MPa.

**) Long-term cooling to the appropriate temperature is recommended for the last firing cycle. The lift position for VITA VACUMAT 6000M furnaces should be > 75%. The fired items must be protected from drafts after opening the furnace.

The values specified here are guide values and are provided solely as a point of reference. Variations in the firing result can occur. The firing result depends on the performance of the furnace in question, and on the manufacturer and age of the furnace. Due to this, the guide values must be individually adapted to the corresponding furnace.
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VITA – perfect match.

VITA Zahnfabrik H. Rauter GmbH & Co. KG · Spitalgasse 3 · D-79713 Bad Säckingen · Germany · Tel. +49/7761/562-0 · Fax +49/7761/562-299 · www.vita-zahnfabrik.com

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