

SUPER PORCELAIN TI-22

PORCELAIN GUIDELINE	(Unit)	1	2	3	4	5	6	7	8	9	10	11	12
DRY-OUT TIME	(min.)	5	5	5	5	3	7	10	15	5	10	7	3
LOW TEMPERATURE	(°C)	500	500	500	500	500	500	500	500	500	500	500	500
	(°F)	930	930	930	930	930	930	930	930	930	930	930	930
START VACUUM	(°C)	500	500	500	500	500	500	500	500	---	---	---	500
	(°F)	930	930	930	930	930	930	930	930	---	---	---	930
HEAT RATE	(°C/min.)	50	50	50	50	50	40	40	40	50	50	50	50
	(°F/min.)	90	90	90	90	90	70	70	70	90	90	90	90
VACUUM LEVEL	(cm/Hg)	72	72	72	72	65	72	72	72	---	---	---	74
RELEASE VACUUM	(°C)	790	790	770	760	720	750	760	770	---	---	---	790
	(°F)	1455	1455	1420	1400	1330	1380	1400	1420	---	---	---	1455
HOLD TIME	(min.)	---	0.25-0.5	---	---	---	---	---	0.5	---	---	---	3
HIGH TEMPERATURE	(°C)	800	800	780	770	730	760	770	770	760	770	750	800
	(°F)	1470	1470	1435	1420	1345	1400	1420	1420	1400	1420	1380	1470

PORCELAIN GUIDELINE

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| <ul style="list-style-type: none"> 1. Bonding Porcelain → 1-6 units 2. Bonding Porcelain → more than 7 units 3. Opaque Porcelain 4. Margin Porcelain 5. Margin Retouching Powder (MRP) 6. Body/Enamel → single crown (1st & 2nd Bake) | <ul style="list-style-type: none"> 7. Body/Enamel → 2-6 units (1st & 2nd Bake) 8. Body/Enamel → over 6 units (1st & 2nd Bake) 9. Glaze → single-3 units 10. Glaze → over 3 units 11. Glaze → glazing powder 12. Oxidation Treatment of pure Titanium |
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Note :

The above schedule is only a guideline.
 Different porcelain furnaces may necessitate adjustments to recommended temperatures