

Firing Schedule for VINTAGE *Halo* Porcelain System

110 v	Drying Temp.	Drying Time (min)	Entry Temp.
Firing of Powder Opaque I	*	1	680 C° (1256 F°)
Firing of Powder Opaque II	*	3	680 C° (1256 F°)
Firing of Paste Opaque I	*	6	450 C° (842 F°)
Firing of Paste Opaque II	*	6	450 C° (842 F°)
Porcelain Margin, 1st firing	*	5	680 C° (1256 F°)
Porcelain Margin, 2nd firing	*	5	680 C° (1256 F°)
Firing of Body, Opaque-Dentine, Incisal and Translucent, 1st firing	*	5-7	680 C° (1256 F°)
Correction Body Bake, 2nd firing	*	5-7	680 C° (1256 F°)
Self-Glazing	*	5-7	680 C° (1256 F°)
CPM & CPM Fine	*	5-7	680 C° (1256 F°)
Firing of correction (Add-On Porcelain)	*	5-7	680 C° (1256 F°)
Firing of gingiva (Vintage pink, dk pink)	*	5-7	680 C° (1256 F°)

* Drying time/temperature is oven dependent; it's very important in eliminating steam tears. Call Shofu technical support for additional info. The information above is a recommended guideline.

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Vacuum	Incr. Temp (min)	Vacuum Final Temp	Final Temp	Holding Time
full	50 C° (90 F°)	940-950 C° (1724-1742 F°)	940-950 C° (1724-1742 F°)	0
full	50 C° (90 F°)	940-950 C° (1724-1742 F°)	940-950 C° (1724-1742 F°)	0
full	50 C° (90 F°)	950 C° (1742 F°)	950 C° (1742 F°)	1
full	50 C° (90 F°)	940 C° (1724 F°)	940 C° (1724 F°)	1
full	50 C° (90 F°)	940-950 C° (1724-1742 F°)	940-950 C° (1724-1742 F°)	0
full	50 C° (90 F°)	940-950 C° (1724-1742 F°)	940-950 C° (1724-1742 F°)	0
full	50 C° (90 F°)	920-930 C° (1688-1706 F°)	920-930 C° (1688-1706 F°)	0
full	50 C° (90 F°)	910-920 C° (1670-1688 F°)	910-920 C° (1670-1688 F°)	0
0	50 C° (90 F°)	910-920 C° (1670-1688 F°)	910-920 C° (1670-1688 F°)	0
0	50 C° (90 F°)	870-880 C° (1598-1616 F°)	870-880 C° (1598-1616 F°)	0
full	50 C° (90 F°)	870 C° (1598 F°)	870 C° (1598 F°)	0
full	50 C° (90 F°)	870 C° (1598 F°)	870 C° (1598 F°)	0