



Firing Schedule For VINTAGE MP Porcelain System

Types of Firing	Pre-heating (Celsius)	Drying (min)	Vacuum	Heat Rate (C/min)	Vacuum Final Temp.	Final Temp.	Holding Time(min) Under Vacuum
Base Opaque	400°C	8 minutes	Full	45°C/min	960	965	2 minutes w/ vac
Shade Opaque	400°C	8 minutes	Full	45°C/min	955	955	1 minute w/ vac
Margin	400°C	6 minutes	Full	45°C/min	945	945	No Holding
First Body Bake	400°C	6 minutes	Full	45°C/min	920	920	No Holding
Second Body Bake	400°C	6 minutes	Full	45°C/min	915	915	No Holding
Glaze	400°C	3 minutes	None	45°C/min	None	910	No Holding
Correction Bake	400°C	5 minutes	Full	45°C/min	770	770	No Holding

* Vacuum begins at Starting Temperature



Vlad Marsh
National Technical Manager

SHOFU DENTAL CORPORATION
1225 Stone Drive
San Marcos, CA 92078-4059 USA

Cell: (760) 473-7400
Fax: (760) 736-3276
Voice Mail: 1-800-827-4638 x218
E-mail: vmarsh@shofu.com