

VITA VMK 95

	Progr. No.	Pre-drying °C	→ min.	↗ min.	↗ °C/min	Temp. approx . °C	→ min.	VAC min.
Oxidation firing	25	Follow manufacturer instructions!						
Wash Opaque firing (powder)	26	600	2.00	4.00	88	950	1.00	4.00
Wash Opaque firing (paste)	27	500	6.00	6.00	75	950	1.00	6.00
Opaque firing (powder)	28	600	2.00	4.00	83	930	1.00	4.00
Opaque firing (paste)	29	500	6.00	6.00	72	930	1.00	6.00
Margin porcelain firing	30	600	6.00	6.00	55	930	1.00	6.00
1 st dentine firing	34	600	6.00	6.00	55	930	1.00	6.00
2 nd dentine firing	32	600	6.00	6.00	55	930	1.00	6.00
3 rd dentine firing	33	600	6.00	6.00	53	920	1.00	6.00
Correction firing with COR	34	600	4.00	6.00	50	900	1.00	-
Glaze firing	35	600	0.00	4.00	83	930	1.00	-
Glaze firing with VITA AKZENT Fluid	36	600	4.00	4.00	83	930	1.00	-
Glaze firing with Glaze Akz25	38	600	4.00	4.00	75	900	1.00	-

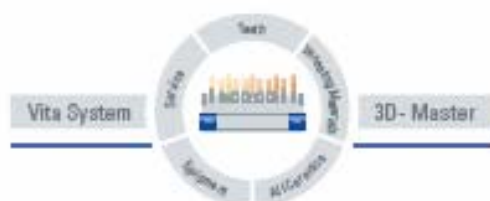
In the case of dental ceramics the end result of firing depends to a great extent on how the individual user carries out the firing, i.e. on the type of furnace, the position of the temperature sensor and the firing supports as well as the size of the metal-ceramic construction to be fired.

Our user recommendations for firing temperatures (regardless of whether these are given orally, in writing or by means of practical demonstration) are based on our own wide experience and on many tests. Nevertheless, this information can only be seen as a guideline for the user. Should the surface structure, the transparency or the degree of lustre not correspond to the desired result despite optimum conditions, the firing cycle must be adjusted accordingly. The decisive factor for the firing procedure is not the firing temperature displayed by the furnace, but the appearance and surface quality of the restoration after firing.

To obtain an optimum metal/ceramic bond, the ceramic should be under slight compressive strain. A good end result also depends on the size of the restoration to be fired, the type, hardness and thermal conductivity of the alloy used, and particularly on the way in which each individual technician carries out the firing.

Very good results have been achieved for many years when the thermal expansion coefficient of the alloy – measured from 25 °C – 600 °C – has been between 14.0 and $14.4 \times 10^{-6} \times K^{-1}$ and that of the VITA VMK 95 Metal Ceramics measured from 25 °C – 500 °C between $13.3 - 13.7 \times 10^{-6} \times K^{-1}$.

If the TEC value of the alloy is higher, the temperature range between 900°C to 700°C must not be passed in less than three minutes during the cooling phase.



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