

VITA AMBRIA® pressing parameters

VITA VACUMAT 6000 MP (VITA Zahnfabrik)

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
Pressing programs VITA AMBRIA ST, HT, T										
100 g investment ring	700	3:36	50	890	25:00	3:00	3.0	1:00	3.0	–
200 g investment ring	700	3:48	50	900	30:00	3:00	3.0	1:00	3.0	–
Pressing programs VITA AMBRIA MO										
100 g investment ring	700	3:36	50	865	25:00	3:00	3.0	1:00	3.0	–
200 g investment ring	700	3:48	50	875	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	Temperature gradient	Firing temperature	Firing time	Vacuum holding time	Long-term cooling	
	°C	min	°C/min	min	°C	min	min	°C	
Power Glaze*	400	4:00	55	7:16	800	2:00	–	500**	
Stains fixation	400	4:00	80	3:45	700	1:00	–	–	
1. Dentin	400	6:00	50	7:12	760	1:00	7:12	500**	
2. Dentin	400	6:00	50	7:06	755	1:00	7:06	500**	
glazing	400	00:00	80	4:23	750	1:00	–	500**	
Glaze material GLAZE LT, FLUOGLAZE LT Spray/Powder	400	4:00	50	7:00	750	1:00	–	500**	
Glaze material GLAZE LT Paste	400	8:00	50	7:00	750	1:00	–	500**	
Correction	400	4:00	50	6:30	725	1:00	6:30	500**	

*) Optional: Power Glaze is a firing program which can be carried out before the respective first firing cycle.

Power Glaze increases the flexural strength of the VITA AMBRIA restoration to > 550 MPa.

***) Long-term cooling to 500 °C is recommended for the respective last firing cycle. The lift position for VITA VACUMAT 6000 M 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)

Programs	Standby	Heating rate	End temperature	Holding time	Stop speed
	B (°C)	t↗ (°C/min)	T (°C)	H (min)	E (µm/min)
Pressing programs VITA AMBRIA ST, HT, T					
100 g investment ring	700	50	890	25:00	300
200 g investment ring	700	50	900	30:00	300
Pressing programs VITA AMBRIA MO					
100 g investment ring	700	50	865	25:00	300
200 g investment ring	700	50	875	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)
Power Glaze*	403	4:00	55	800	2:00	–	–	500	0
Stains fixation	403	4:00	80	700	1:00	–	–	–	–
1. Dentin	403	6:00	50	760	1:00	400	759	500**	0
2. Dentin	403	6:00	50	755	1:00	400	754	500**	0
glazing	403	00:00	80	750	1:00	–	–	500**	0
Glaze material GLAZE LT, FLUOGLAZE LT Spray/Powder	403	4:00	50	750	1:00	–	–	500**	0
Glaze material GLAZE LT Paste	403	8:00	80	750	1:00	–	–	500**	0
Correction	403	4:00	50	725	1:00	400	724	500**	0

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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 AMBRIA® pressing parameters

Vario Press 300 (Zubler GmbH)

Programs	Start temperature	Heating rate	Holding temperature	Holding time	Extra pressing time	Maximum pressing time	Pressure	Vacuum level	Opening time
	°C	°C/min	°C	min	min	min	low	mm	min
Pressing programs VITA AMBRIA ST, HT, T; Program type: i-Press									
100 g investment ring	700	50	890	20:00	00:00	5:00	Low	720	00:00
200 g investment ring	700	50	900	25:00	00:00	5:00	Low	720	00:00
Pressing programs VITA AMBRIA MO; Program type: i-Press									
100 g investment ring	700	50	865	20:00	00:00	5:00	Low	720	00:00
200 g investment ring	700	50	875	25:00	00:00	5:00	Low	720	00:00

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	Start temperature	Pre-drying	Pre-drying time	Closing time	Homogenization temperature	Homogenization time	Heating rate	Final temperature	Holding time	Pre-drying	Pre-drying time	Homogenization temperature	Homogenization time	Heating rate	Final temperature	Holding time
	°C	-	min	min	°C	min	°C/min	°C	min	/	/	°C	min	-	-	°C
Power Glaze*	400	No	/	4	400	0.00	55	800	2	/	/	800	/	No	/	/
Stains fixation	400	Yes	2	2	400	0.30	80	700	1	/	/	700	/	No	/	/
1. Dentin	400	Yes	4	2	400	0.30	50	760	1	/	/	760	/	Yes	Heat.	760
2. Dentin	400	Yes	3	3	400	0.30	50	755	1	/	/	755	/	Yes	Heat.	755
glazing	400	No	/	4	400	0.00	80	750	1	/	/	750	2	No	/	/
Glaze material GLAZE LT, FLUOGLAZE LT Spray/Powder	400	Yes	4	2	400	0.00	50	750	1	/	/	750	2	No	/	/
Glazing with GLAZE LT Paste	400	Yes	8	2	400	0.00	50	750	1	/	/	750	2	No	/	/
Correction	400	Yes	2	2	400	0.30	50	725	1	/	/	725	2	Yes	Heat.	725

*) Optional: Power Glaze is a firing program which can be carried out before the respective first firing cycle.

Power Glaze increases the flexural strength of the VITA AMBRIA restoration to > 550 MPa.

***) Long-term cooling to 500 °C is recommended for the respective last firing cycle.

The values specified here are guide values and are provided solely as a point of reference. Variations in the firing result can occur. Due to this, the guide values must be individually adapted to the corresponding furnace. This information has been carefully prepared and verified. However, it is provided without guarantee. Special advanced pressing programs for various furnace types are provided free of charge by Zubler GmbH, Ulm.