

VITA LUMEX® UNIQUE – Firing parameters

VITA VACUMAT 6100 M/MP (VITA Zahnfabrik)

Characterization/glaze firing VITA LUMEX® UNIQUE*										
Programs	Lift position during pre-drying		Start temperature	Pre-drying time, closing time	Temperature rise	Final temperature	Holding time at end temperature	Vacuum 1	Vacuum 2	Long-term cooling
	[%]	[min]	B	S	t	T1	H1	V1	V2	L
			[°C]	[min]	[°C/min]	[°C]	[min]	[%] [min]	[%] [min] [°C]	[°C] [min] [%]
Single-tooth restorations and three-unit bridges	62	6:00	400	8:00	50	750	1:00	100 0:00	100 7:00 400	500*** 0:00 75
	44	2:00								
	25	0:00								
Wide-span bridges**	62	6:00	400	8:00	40	750	1:00	100 0:00	100 8:45 400	500*** 0:00 75
	44	2:00								
	25	0:00								
Full arch with gingival margin**	62	8:00	400	10:00	30	750	1:00	100 0:00	100 11:40 400	500*** 0:00 75
	44	2:00								
	25	0:00								

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

** Depending on the weight of the restoration, it may be advantageous to extend the pre-drying time and/or reduce the heating rate.

*** The lift position for VITA VACUMAT 6100 M/MP furnaces should be > 75%. The fired items must be protected from drafts after opening the furnace.

Recommended firing mixed technique with VITA LUMEX AC										
Programs	Lift position during pre-drying		Start temperature	Pre-drying time, closing time	Temperature rise	Final temperature	Holding time at end temperature	Vacuum 1	Vacuum 2	Long-term cooling
	[%]	[min]	B	S	t	T1	H1	V1	V2	L
		[°C]	[min]	[°C/min]	[°C]	[min]	[%] [min]	[%] [min] [°C]	[°C] [min] [%]	
WASHBAKE with zirconia	62	0:00	400	4:00	50	800	1:00	100 0:00	100 8:00 400	500*** 0:00 75
	44	4:00								
	25	0:00								
WASHBAKE with lithium disilicate	62	0:00	400	4:00	50	760	1:00	100 0:00	100 7:12 400	500*** 0:00 75
	44	4:00								
	25	0:00								
First dentine firing	62	2:00	400	6:00	50	760	1:00	100 0:00	100 7:12 400	500*** 0:00 75
	44	2:00								
	25	2:00								
Corrective firing with CORRECTIVE	62	2:00	400	4:00	50	725	01:00	100 0:00	100 6:30 400	500*** 0:00 75
	44	2:00								
	25	0:00								

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

*** Long-term cooling to 500°C is recommended for the respective last firing cycle. The lift position for VITA VACUMAT 6100 M/MP furnaces should be > 75%. The fired items must be protected from drafts after opening the furnace.

VITA LUMEX® UNIQUE – Firing parameters

VITA SMART.FIRE ADVANCED & VITA SMART.FIRE (VITA Zahnfabrik)

Characterization/glaze firing VITA LUMEX® UNIQUE*										
Programs	Lift position during pre-drying		Start temperature	Pre-drying time, closing time	Temperature rise	Final temperature	Holding time at end temperature	Vacuum 1	Vacuum 2	Long-term cooling
	[%]	[min]	B	S	t	T1	H1	V1	V2	L
			[°C]	[min]	[°C/min]	[°C]	[min]	[%] [min]	[%] [min] [°C]	[°C] [min] [%]
Single-tooth restorations and three-unit bridges	62	6:00	380	08:00	50	750	1:00	100 0:00	100 7:24 400	500*** 0:00 75
	35	2:00								
	25	0:00								
Wide-span bridges**	62	6:00	380	08:00	40	750	1:00	100 0:00	100 9:15 400	500*** 0:00 75
	35	2:00								
	25	0:00								
Full arch with gingival margin**	62	8:00	380	10:00	30	750	1:00	100 0:00	100 12:20 400	500*** 0:00 75
	35	2:00								
	25	0:00								

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

** Depending on the weight of the restoration, it may be advantageous to extend the pre-drying time and/or reduce the heating rate.

*** The lift position for VITA SMART.FIRE and SMART.FIRE ADVANCED furnaces should be > 75%. The fired items must be protected from drafts after opening the furnace.

Recommended firing mixed technique with VITA LUMEX AC										
Programs	Lift position during pre-drying		Start temperature	Pre-drying time, closing time	Temperature rise	Final temperature	Holding time at end temperature	Vacuum 1	Vacuum 2	Long-term cooling
	[%]	[min]	B	S	t	T1	H1	V1	V2	L
			[°C]	[min]	[°C/min]	[°C]	[min]	[%] [min]	[%] [min] [°C]	[°C] [min] [%]
WASHBAKE with zirconia	62	0:00	380	4:00	50	800	01:00	100 0:00	100 8:24 400	500*** 0:00 75
	35	4:00								
	25	0:00								
WASHBAKE with lithium disilicate	62	0:00	380	4:00	50	760	01:00	100 0:00	100 7:36 400	500*** 0:00 75
	35	4:00								
	25	0:00								
First dentine firing	62	2:00	380	6:00	50	760	01:00	100 0:00	100 7:36 400	500*** 0:00 75
	35	2:00								
	25	2:00								
Corrective firing with CORRECTIVE	62	2:00	380	4:00	50	725	01:00	100 0:00	100 6:54 400	500*** 0:00 75
	35	2:00								
	25	0:00								

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

*** Long-term cooling to 500°C is recommended for the respective last firing cycle. The lift position for VITA SMART.FIRE and SMART.FIRE ADVANCED furnaces should be > 75%. The fired items must be protected from drafts after opening the furnace.

VITA LUMEX® UNIQUE – Firing parameters

Austromat 624i (DEKEMA)

Characterization/glaze firing VITA LUMEX® UNIQUE*																	
Programs	Dry	Closing	Pre-heating		VAC (on/level)		Temperature 1			Temperature 2			Temperature 3			VAC (off/hold)	
	B	S					T1			T2			T3				
	[min]	[min]	[°C]	[min]	[°C]	[%]	[°C]	[°C/ min]	[min]	[°C]	[°C/ min]	[min]	[°C]	[°C/ min]	[min]	[°C]	[min]
Single-tooth restorations and three-unit bridges	1:00	7:00	400	___:___	400	100	760	50	1:00	—	—	___:___	500***	50	___:___	760	___:___
Wide-span bridges**	1:00	7:00	400	___:___	400	100	760	40	1:00	—	—	___:___	500***	50	___:___	760	___:___
Full arch with gingival margin**	2:00	8:00	400	___:___	400	100	760	30	1:00	—	—	___:___	500***	50	___:___	760	___:___

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

** Depending on the weight of the restoration, it may be advantageous to extend the pre-drying time and/or reduce the heating rate.

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

Recommended firing mixed technique with VITA LUMEX AC																	
Programs	Dry	Closing	Pre-heating		VAC (on/level)		Temperature 1			Temperature 2			Temperature 3			VAC (off/hold)	
	B	S					T1			T2			T3				
	[min]	[min]	[°C]	[min]	[°C]	[%]	[°C]	[°C/ min]	[min]	[°C]	[°C/ min]	[min]	[°C]	[°C/ min]	[min]	[°C]	[min]
WASHBAKE with zirconia	2:00	2:00	400	___:___	400	100	800	50	1:00	—	—	___:___	500***	50	___:___	800	___:___
WASHBAKE with lithium disilicate	2:00	2:00	400	___:___	400	100	760	50	1:00	—	—	___:___	500***	50	___:___	760	___:___
First dentine firing	2:00	2:00	400	2:00	400	100	760	50	1:00	—	—	___:___	500***	50	___:___	760	___:___
Corrective firing with CORRECTIVE	2:00	2:00	400	___:___	400	100	725	50	1:00	—	—	___:___	500***	50	___:___	725	___:___

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

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

VITA LUMEX® UNIQUE – Firing parameters

Vario Press 300 (Zubler)

Characterization/glaze firing VITA LUMEX® UNIQUE*																		
Programs	Start temperature	Pre-drying	Pre-drying time	Closing time	Soak temp	Soak time	Heating rate	Final temperature	Holding time	Pre-drying	Pre-drying time	Soak temp	Soak time	Heating rate	Final temperature	Holding time	Vacuum	Opening time
	[°C]	–	[min]	[min]	[°C]	[min]	[°C/min]	[°C]	[min]	–	–	[°C]	[min]	–	–	[°C]	–	[min]
Single-tooth restorations and three-unit bridges	400	Yes	1:00	7:00	400	0:00	50	750	1:00	–	–	750	–	Yes	Heat up	750	On	1:00
Wide-span bridges**	400	Yes	1:00	7:00	400	0:00	40	750	1:00	–	–	750	–	Yes	Heat up	750	On	1:00
Full arch with gingival margin**	400	Yes	1:00	9:00	400	0:00	30	750	1:00	–	–	750	–	Yes	Heat up	750	On	1:00

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

** Depending on the weight of the restoration, it may be advantageous to extend the pre-drying time and/or reduce the heating rate.

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

Recommended firing mixed technique with VITA LUMEX AC																		
Programs	Start temperature	Pre-drying	Pre-drying time	Closing time	Soak temp	Soak time	Heating rate	Final temperature	Holding time	Pre-drying	Pre-drying time	Soak temp	Soak time	Heating rate	Final temperature	Holding time	Vacuum	Opening time
	[°C]	–	[min]	[min]	[°C]	[min]	[°C/min]	[°C]	[min]	–	–	[°C]	[min]	–	–	[°C]	–	[min]
WASHBAKE with zirconia	400	Yes	2:00	2:00	400	1:30	50	800	1:00	–	–	800	–	Yes	Heat up	800	On	0:00
WASHBAKE with lithium disilicate	400	Yes	2:00	2:00	400	1:30	50	760	1:00	–	–	760	–	Yes	Heat up	760	On	0:00
First dentine firing	400	Yes	4:00	2:00	400	1:00	50	760	1:00	–	–	760	–	Yes	Heat up	760	On	1:00
Corrective firing with CORRECTIVE	400	Yes	2:00	2:00	400	1:00	50	725	1:00	–	–	725	2	Yes	Heat up	725	On	1:00

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

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

VITA LUMEX® UNIQUE – Firing parameters

Programat EP 5010 (Ivoclar)

Characterization/glaze firing VITA LUMEX® UNIQUE*										
Programs	Standby temperature	Dry	Closing time	Heating rate	Firing temperature	Holding time	Vacuum 1	Vacuum 2	Long-term cooling	Cooling rate
	B [°C]	Options [min]	S [min]	t [°C/min]	T1 [°C]	H1 [min]	V1 [°C]	V2 [°C]	L [°C]	tl [°C/min]
Single-tooth restorations and three-unit bridges	400	Off	8:00	50	760	1:00	400	759	500***	Off
Wide-span bridges**	400	Off	8:00	40	760	1:00	400	759	500***	Off
Full arch with gingival margin**	400	Off	10:00	30	760	1:00	400	759	500***	Off

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

** Depending on the weight of the restoration, it may be advantageous to extend the pre-drying time and/or reduce the heating rate.

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

Recommended firing mixed technique with VITA LUMEX AC										
Programs	Standby temperature	Dry	Closing time	Heating rate	Firing temperature	Holding time	Vacuum 1	Vacuum 2	Long-term cooling	Cooling rate
	B [°C]	Options [min]	S [min]	t [°C/min]	T1 [°C]	H1 [min]	V1 [°C]	V2 [°C]	L [°C]	tl [°C/min]
WASHBAKE with zirconia	400	Off	4:00	50	800	1:00	400	799	500***	Off
WASHBAKE with lithium disilicate	400	Off	4:00	50	760	1:00	400	759	500***	Off
First dentine firing	400	Off	6:00	50	760	1:00	400	759	500***	Off
Corrective firing with CORRECTIVE	400	Off	4:00	50	725	1:00	400	724	500***	Off

* The firing temperatures given are guidelines only. The firing results are influenced by several variables such as the brand, performance efficiency and age of the firing unit used.

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

