

Firing Tables for ICE Veneer Porcelain

Wash / Single Crown:

Start Temp	350° C
Dry Time	5 min
Final Temp	920° C
Hold Time	2 min
Temp. Rise	55° C/min
Cool Time	1 min
Vacuum	Continuous trough entire cycle

Wash / Small Bridge:

Start Temp	350° C
Dry Time	7 min
Final Temp	920° C
Hold Time	2 min
Temp. Rise	40° C/min
Cool Time	2 min
Vacuum	Continuous trough entire cycle

Wash/ Large Bridge:

Start Temp	350° C
Dry Time	7 min
Final Temp	920° C
Hold Time	2 min
Temp. Rise	30° C/min
Cool Time	3 min
Vacuum	Continuous trough entire cycle

Repair Fire prior to first Build Up Bake:

Start Temp	350° C
Dry Time	5 min
Final Temp	840° C
Hold Time	1 min
Temp. Rise	40° C/min
Cool Time	2 min
Vacuum	Continuous trough entire cycle

Glaze / Single Crown:

Start Temp	350° C
Dry Time	5 min
Final Temp	820° C
Hold Time	2 min
Temp. Rise	55° C/min
Cool Time	1 min
Vacuum	Continuous trought entire cycle

Glaze / Small Bridge:

Start Temp	350° C
Dry Time	5 min
Final Temp	820° C
Hold Time	2 min
Temp. Rise	40° C/min
Cool Time	2 min
Vacuum	Continuous trought entire cycle

Glaze / Large Bridge:

Start Temp	350° C
Dry Time	7 min
Final Temp	820° C
Hold Time	2 min
Temp. Rise	30° C/min
Cool Time	3 min
Vacuum	Continuous trought entire cycle