

# Celtra® Duo (ZLS) Firing Schedules – Ivoclar Ovens

PROGRAMAT / IVOCLAR VIVADENT	B [°C]	S [min.]	t $\nearrow$ [°C/min.]	T [°C]	H [min.]	VAC 1 [°C]/ VAC 2 [°C]	L [°C]	tL [°C/min.]
Celtra Paint-On Glaze (12:30 cycle time)	500	3:30	60	820	1:00	-	750	50
2nd & Subsequent Glaze Firing – if needed (10:00 cycle time)	500	3:00	60	770	1:00	-	750	50
Spray Glaze (Indenco) (11:00 cycle time)	500	2:00	60	820	1:00	-	750	50
Polish and Fire (10:00 cycle time)	500	1:00	60	820	1:00	-	750	50
Correction Porcelain	500	3:30	60	820	1:00	V1=500C V2=819C	750	50

## Explanation of the Ivoclar Programat parameters

B	Stand-by temperature [°C]
S	Closing time [min.]
t $\nearrow$	Temperature increase rate [°C/min.]
T	Holding temperature [°C]
H	Holding time [min.]
VAC 1	Vacuum on [°C]
VAC 2	Vacuum off [°C]
L	Long-term cooling [°C]
tL	Cooling temperature rate

