

# Amber Mill Firing Schedule – Rapid Mode

[Programat CS, Ivoclar vivadent]

	Stand-by temperature B [°C]	Closing time S [min]	Heating rate t <sub>1</sub> [°C/min]	Firing temperature T <sub>1</sub> [°C]	Holding time H <sub>1</sub> [min]	Heating rate t <sub>2</sub> [°C/min]	Firing temperature T <sub>2</sub> [°C]	Holding time H <sub>2</sub> [min]	Vacuum 1 V <sub>11</sub> /V <sub>12</sub> [°C]	Vacuum 2 V <sub>21</sub> /V <sub>22</sub> [°C]	Long-term cooling L [°C]	Cooling rate t <sub>i</sub> [°C/mic]
HT (16:00)	400	1:00	90	780	0:00	30	815	5:00	690/780	780/815	690	40
MT (14:30)	400	1:00	90	780	0:00	30	830	3:00	690/780	780/830	690	40
LT (15:30)	400	1:00	90	780	0:00	30	845	3:00	690/780	780/845	690	40
MO (16:00)	400	1:00	90	780	0:00	30	865	3:00	690/780	780/865	690	40

## NOTE:

- Standard Mode for crowns more than two-unit bridge with glaze made by paste or powder.
- Rapid Mode for veneer or crowns with only spray type glaze.