

 	CGI PORCELAIN FIRING CHART					
	Opaque 1 st Firing	Opaque 2 nd Firing	Shoulder	Dentines/ Incisals	Add On	Stains and Glazes
Dry out	Powder 5 min Paste 10 min	Powder 5 min Paste 10 min	5 min.	5 min.	5 min.	3-5 min.
Insertion	593°C 1100°F	593°C 1100°F	593°C 1100°F	593°C 1100°F	515°C 960°F	300°C 572°F
Heat rate ° / min.	50°C 90°F	50°C 90°F	50°C 90°F	50°C 90°F	55°C 100°F	40°C 72°F
Vacuum start	593°C 1100°F	593°C 1100°F	593°C 1100°F	593°C 1100°F	Optional	None
Vacuum stop	982°C 1800°F	977°C 1791°F	941°C 1725°F	948°C 1740°F		None
Firing Temp.	982°C 1800°F	960°C 1791°F	946°C 1735°F	948°C 1740°F	800°C 1470°F	750°C - 850°C 1382°F - 1562°F
Hold Time	0	0	0	0	1 min	1 Minute
Cool Time	0	0	0	1-5 min	0	0
Texture	Semi-Gloss	Eggshell-Shiny	Eggshell	Grainy-Shiny	Glossy	Glossy
Thickness (approx.)	Thin Wash	0.1-0.3 mm	0.2 mm	0.5-1.0 mm		

* The above temperatures are recommended and can vary with individual furnaces. The crucial factors for the firing temperatures are the appearance and the surface condition of the restoration after the firing process.

Recommended NP alloy CTE range : **14.0-14.4** x 10⁻⁶ /°C @ 500°C