

PRESSING TEMPERATURES

	100g Ring	200g Ring	300g Ring
Base Temp.	700°C	700°C	700°C
Rate of Climb	60° / min	60° / min	60° / min
Press End Temp.	920°C	930°C	940°C
Press Time	6 – 10 min.	7 - 12 min.	8 - 14 min.
Hold	20 – 25 min.	20 – 25 min.	20 - 25 min.
Vacuum Start	700°C (Full)	700°C (Full)	700°C (Full)
Vacuum End	920°C	930°C	940°C
Air Pressure	4.5 bars	4.5 bars	4.5 bars

FIRING TEMPERATURES

	Dry Time	Start Temp.	Finish Temp.	Heat Rate	Start Vacuum	Release Vacuum	Hold Time
	Min.	°C	°C	°C /min.	°C	°C	Min.
Opaque – Press	6	400	950	60	400	949	2
Opaque – 800°C	6	400	810	60	400	809	2
Staining Technique							
Stain Fixation	3	400	700	55	None	None	0
Glaze	5	400	740	55	400	739	1
Layering Technique							
1 st Margin	4	400	750	45	400	749	1
2 nd Margin	4	400	740	45	400	739	1
1 st Dentin / Incisal	5	400	735	45	400	734	1
2 nd Dentin / Incisal	5	400	725	50	400	724	1
Correction Bake	5	400	700	45	400	699	1
Stain & Glaze	5	400	705	50	400	704	1

* The given temperatures are approximate values. Depending on the furnace, corrections of the firing temperatures may be required. Also, these temperatures have only been tested with the metals listed in the **MoyleSelection** section of the SNF PressCeramTM Instruction Manual.



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