

Working with AP-Efficiency Through Simplicity

Arbeiten mit AP - effizient und einfach

FIRING CHART / BRENNTABELLE

11

APVOLUTION M



| PRESS-PROGRAM - APVOLUTION M PELLETS | | | | | | | |
|--------------------------------------|--------------|------------------|----------|--------------|--------|--------------------|------------------------|
| Ring Size | Idle Temp | Rising °C/min | End Temp | Holding Time | Vac on | DEKEMA Press Level | Ivoclar Stop Speed - E |
| Muffelgröße | Bereitschaft | Steigrade °C/min | End Temp | Haltezeit | Vak an | | |
| 200 | 700°C | 65°C | 930°C | 20 min | 700°C | L5 | 100 |
| 300 | 700°C | 65°C | 930°C | 20 min | 700°C | L5 | 100 |
| 400 | 700°C | 65°C | 970°C | 40 min | 700°C | L7 | 100 |

| FIRING CHART - BUILD UP POWDER / BRENNTABELLE - SCHICHTKERAMIK | | | | | | |
|--|--------------|-------------|------------------|----------|--------------|--------|
| Build Up Powder | Idle Temp | Preheat | Rising °C/min | End Temp | Holding Time | Vac on |
| Schichtkeramik | Bereitschaft | Vortrocknen | Steigrade °C/min | End temp | Haltezeit | Vak an |
| High Fusing / Hochschmelzend | 400°C | 6 min | 45°C | 920°C | 1 min | 450°C |
| Low Fusing / Niederschmelzend | 400°C | 6 min | 45°C | 780°C | 1 min | 450°C |
| Glaze Bake / Glanzbrand HF | 400°C | 6 min | 60°C | 880°C | 1 min | - |
| Glaze Bake / Glanzbrand LF | 400°C | 6 min | 60°C | 780°C | 1 min | - |



FIRING CHART - BONDER / BRENNTABELLE - BONDER

| Idle Temp | Dry Time | Rising °C/min | End Temp | Hold Time | Vac on |
|--------------|-------------|------------------|----------|-----------|--------|
| Bereitschaft | Vortrocknen | Steigrade °C/min | End temp | Haltezeit | Vak an |
| 450°C | 6 min | 80°C | 980°C | 5 min | 450°C |

FIRING CHART - OPAQUE / BRENNTABELLE - OPAQUER

| | Idle Temp | Dry Time | Rising °C/min | End Temp | Hold Time | Vac on |
|---------------------|--------------|-------------|------------------|----------|-----------|--------|
| | Bereitschaft | Vortrocknen | Steigrade °C/min | End temp | Haltezeit | Vak an |
| 1st Fire / 1. Brand | 400°C | 7 min | 60°C | 970°C | 1 min | 450°C |
| 2nd Fire / 2. Brand | 400°C | 6 min | 60°C | 950°C | 1 min | 450°C |

