

General Firing Recommendation & VACUMAT/VITA	Pre-drying [°C]	→ min. Pre-drying	↗ °C/min.	T °C End temp.	→ min. Holding time	↘ min. Long-term cooling	VAC min.
Celtra Paint-on Glaze	500	4:00	60	820	1:00	3:00	-
2nd & subsequent Glaze Firing (if needed)	500	4:00	60	770	1:00	3:00	-
Spray Glaze (Indenco)	500	3:00	60	820	1:00	3:00	-
Polish & Fire	500	2:00	60	820	1:00	3:00	-
Correction Porcelain	500	4:00	60	820	1:30	3:00	1:30

Explanation of the General Recommendation and VACUMAT/VITA Firing Parameters

- Pre-drying °C Start temperature
- Pre-drying time in minutes, closing time
- ↗ Heating time in minutes
- ↗ Temperature rise rate in degrees Celsius per minute
- T °C End temperature
- Holding time for end temperature in minutes
- VAC min. Vacuum holding time in minutes
- ↘ Long-term cooling in degrees Celsius

- Firing times range from 11-14 minutes, depending on VITA model