

SHOFU VINTAGE MP PORCELAIN FIRING SCHEDULE

LAYERS	START TEMP °C	DRYING & PREHEATING (min)	HEAT RATE °C/min	VACUUM START °C	VACUUM OFF °C	VACUUM LEVEL mm/Hg	FINAL TEMP °C	HOLDING TIME	COOLING TIME
BASE OPAQUE	500	7 min	50	500	950	720mm	950	2 min	-
PASTE OPAQUE	500	7 min	50	500	940	720mm	940	1 min	-
MARGIN	650	5 min	50	650	940	720 mm	940	-	-
CERVICAL	650	5 min	55	650	890	720mm	890	-	-
OPAQUE DENTIN, BODY, OPAL, OPAL EFFECT, ENAMEL EFFECT INCISAL, CERVICAL TRANS	650	5-7 min	50	680	900	720mm	920	0-1 min	0-1 min
BODY (Second firing)	650	5-7 min	55-60	680	890	720mm	900	0-1 min	0-1 min
SELF-GLAZE	650	5-7 min	50	-	-	-	890-910	0-1 min	0-1 min
GUM (First)	650	5-7 min	50-60	650	880	720mm	880-900	-	-
GUM - GLAZE	650	5-7 min	50-60	-	-	-	860-880	-	-
CORRECTION (First)	450	5-7 min	50-60	450	750	720 mm	750-770	-	-
CORRECTION-Glaze	450	5-7 min	50-60	-	-	-	750-770	-	-

Note: The firing schedule mentioned is only a guideline for the use of Shofu Vintage MP Porcelain System.

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