

# CEREC Tessera™

## VITA SMART.FIRE® – Firing recommendations

	Pre-drying temp. Pre-drying time °C/min	Lifting plate position Pre-drying c 100 % b 62 % a 25 %	Pre-vacuum %/min	Heating rate °C/min	Main vacuum %/min	Firing temp. Holding time °C/min	Cooling temp. Holding time °C/min	Lifting plate position %
<b>Universal Stain &amp; Glaze</b>	<b>400/6</b>	c/2:00 b/2:00 a/2:00	<b>0/0:00</b>	<b>55</b> 6:43	<b>0</b> 7:43	<b>760/2:00</b>	<b>0/0</b>	<b>0</b>
<b>Universal Spray Glaze</b>	<b>400/3</b>	c/1:00 b/1:00 a/1:00	<b>0/0:00</b>	<b>55</b> 6:43	<b>0</b> 7:43	<b>760/2:00</b>	<b>0/0</b>	<b>0</b>

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REV 2021-02

# CEREC Tessera™

## VITA SMART.FIRE® – Firing recommendations

	Pre-drying temp. Pre-drying time °C/min	Lifting plate position Pre-drying c 100 % b 62 % a 25 %	Pre-vacuum %/min	Heating rate °C/min	Main vacuum %/min	Firing temp. Holding time °C/min	Cooling temp. Holding time °C/min	Lifting plate position %
<b>Universal Stain &amp; Glaze</b>	<b>400/6</b>	c/2:00 b/2:00 a/2:00	<b>0/0:00</b>	<b>55</b> 6:43	<b>0</b> 7:43	<b>760/2:00</b>	<b>0/0</b>	<b>0</b>
<b>Universal Spray Glaze</b>	<b>400/3</b>	c/1:00 b/1:00 a/1:00	<b>0/0:00</b>	<b>55</b> 6:43	<b>0</b> 7:43	<b>760/2:00</b>	<b>0/0</b>	<b>0</b>

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REV 2021-02

# CEREC Tessera™

## Programat EP 3000/5000, Programat CS/CS2 – Firing recommendations

	Closing time	Temperature gradient	Holding temp.	Holding time	Vacuum	Vacuum	One-step program	Pre-vacuum	Long-term cooling	Cooling gradient	Standby temp.
	min	°C	°C	min	on	off			min		min
	S	t ↑	T	H	V1	V2			L	t ↓	B
<b>Universal Stain &amp; Glaze</b>	6:00	55	760	2:00	0	0	yes	0	0	0	403
<b>Universal Spray Glaze</b>	2:00	55	760	2:00	0	0	yes	0	0	0	403

# CEREC Tessera™ & Celtra® Ceram

## Programat EP 3000/5000, Programat CS/CS2 – Firing program Cut-back Technique

	Closing time	Temperature gradient	Holding temp.	Holding time	Vacuum	Vacuum	One-step program	Pre-vacuum	Long-term cooling	Cooling gradient	Standby temp.	
	min	°C	°C	min	on	off			°C	t	°C	
	S	T ↑	T	H	V1	V2			L	L	B	
<b>Matrix firing</b>	2:00	55	760	2:00	0	0	yes	0	0	0	403	
<b>Cut back</b>	<b>Dentin 1</b>	6:00	55	770	2:00	400	769	yes	0	650	50	403
	<b>Dentin 2</b>	6:00	55	760	2:00	400	759	yes	0	650	50	403
<b>Glaze firing</b>	6:00	55	750	2:00	0	0	yes	0	650	50	403	
<b>Spray Glaze</b>	2:00	55	750	2:00	0	0	yes	0	650	50	403	
<b>Stain + Spray Glaze</b>	3:00	55	750	2:00	0	0	yes	0	650	50	403	
<b>Add-on</b>	6:00	55	750	2:00	400	749	yes	0	650	50	403	



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# CEREC Tessera™

## Cergo® Press – Firing recommendations

	Drying min	Closing min	Pre-heating		Heating rate °C/min	Vacuum			Final temp. °C	Holding		Temper- ing °C/min	Cooling min
			°C	min		on/ off/ cont	on/ °C	off/ °C		V min	min		
<b>Universal Stain &amp; Glaze</b>	2:00	2:00	400	2:00	55	off	0	0	760	0	2:00	0	0
<b>Universal Spray Glaze</b>	0:00	1:00	400	1:00	55	off	0	0	760	0	2:00	0	0

# CEREC Tessera™ & Celtra® Ceram

## Cergo® Press – Firing program Cut-back Technique

	Drying min	Closing min	Pre-heating		Heating rate °C/min	Vacuum			Final temp. °C	Holding		Temper- ing °C/min	Cooling min	
			°C	min		on/ off/ cont	on/ °C	off/ °C		V min	min			
<b>Matrix firing</b>	0:00	1:00	400	1:00	55	off	0	0	760	0:00	2:00	0	0	
<b>Cut back</b>	<b>Dentin 1</b>	2:00	2:00	400	2:00	55	cont	400	770	770	1:00	1:00	0	5:00
	<b>Dentin 2</b>	2:00	2:00	400	2:00	55	cont	400	760	760	1:00	1:00	0	5:00
<b>Glaze firing</b>	2:00	2:00	400	2:00	55	off	0	0	750	0:00	2:00	0	5:00	
<b>Spray Glaze</b>	0:00	1:00	400	1:00	55	off	0	0	750	0:00	2:00	0	5:00	
<b>Stain + Spray Glaze</b>	1:00	1:00	400	1:00	55	off	0	0	750	0:00	2:00	0	5:00	
<b>Add-on</b>	2:00	2:00	400	2:00	55	cont	400	750	750	1:00	1:00	0	5:00	

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# CEREC Tessera™

## VITA VACUMAT® 6000 MP – Firing recommendations

	Pre-drying temp. Pre-drying time °C/min	Lifting plate Pre-drying position c 100% b 62% a 44%	Pre-vacuum %/min	Heating rate °C/min	Main vacuum %/min	Firing temp. Firing time °C/min	Cooling temp. Holding time °C/min	Lifting plate position %
<b>Universal Stain &amp; Glaze</b>	400/6:00	c/2 min b/2 min a/2 min	0:00	55	0:00	760/2:00	0/0	0
<b>Universal Spray Glaze</b>	400/3:00	c/1 min b/1 min a/1 min	0:00	55	0:00	760/2:00	0/0	0

# CEREC Tessera™ & Celtra® Ceram

## VITA VACUMAT® 6000 MP – Firing program Cut-back Technique

	Pre-drying temp. Pre-drying time °C/min	Lifting plate Pre-drying position c 100% b 62% a 44%	Pre-vacuum %/min	Heating rate °C/min 100%/min	Firing temp. Firing time °C/min	Cooling temp. Holding time °C/min	Lifting plate position %
<b>Matrix firing</b>	400/3:00	c/1 min b/1 min a/1 min	0:00	55 0:00	760/2:00	0/0	0
<b>Cut back</b>	<b>Dentin 1</b>	c/2 min b/2 min a/2 min	0:00	55/6:43 100%/7:43	770/2:00	500/0:10	75
	<b>Dentin 2</b>	c/2 min b/2 min a/2 min	0:00	55/6:32 100%/7:32	760/2:00	500/0:10	75
<b>Glaze firing</b>	400/6:00	c/2 min b/2 min a/2 min	0:00	55 0:00	750/2:00	500/0:10	75
<b>Spray Glaze</b>	400/3:00	c/1 min b/1 min a/1 min	0:00	55 0:00	750/2:00	500/0:10	75
<b>Stain + Spray Glaze</b>	400/3:00	c/1 min b/1 min a/1 min	0:00	55 0:00	750/2:00	500/0:10	75
<b>Add-on</b>	400/6:00	c/2 min b/2 min a/2 min	0:00	55/6:21 100%/7:21	750/2:00	500/0:10	75



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## Multimat® NT/NTX – Firing program

	Pre-drying	Drying	Pre-heating temp.	Pre-heating time	Heating rate	Final temp.	Holding time	Vacuum time	Tempering temp.	Tempering time	Cooling
	min	min	°C	min	°C/min	°C	min	min	°C	min	min
<b>Universal Stain &amp; Glaze</b>	2:00	2:00	400	2:00	55	760	2:00	0	0	0	0
<b>Universal Spray Glaze</b>	0:00	1:00	400	1:00	55	760	2:00	0	0	0	0

# CEREC Tessera™ & Celtra® Ceram

## Multimat® NT/NTX – Firing program Cut-back Technique

	Pre-drying	Drying	Pre-heating temp.	Pre-heating time	Heating rate	Final temp.	Holding time	Vacuum time	Tempering temp.	Tempering time	Cooling	
	min	min	°C	min	°C/min	°C	min	min	°C	min	min	
<b>Matrix firing</b>	0:00	1:00	400	1:00	55	760	2:00	0:00	0	0:00	0:00	
<b>Cut-back</b>	<b>Dentin 1</b>	2:00	2:00	400	2:00	55	770	2:00	1:00	0	0:00	5:00
	<b>Dentin 2</b>	2:00	2:00	400	2:00	55	760	2:00	1:00	0	0:00	5:00
<b>Glaze firing</b>	2:00	2:00	400	2:00	55	750	2:00	0:00	0	0:00	5:00	
<b>Spray Glaze</b>	0:00	1:00	400	1:00	55	750	2:00	0:00	0	0:00	5:00	
<b>Stain + Spray Glaze</b>	1:00	1:00	400	1:00	55	750	2:00	0:00	0	0:00	5:00	
<b>Add-on</b>	2:00	2:00	400	2:00	55	750	2:00	1:00	0	0:00	5:00	

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## Multimat® Cube/Cube press – Firing program

	Starting temp. °C	Pre-drying time min	Closing time min	Pre-heating time min	Vacuum on/off	Firing stages	Heating rate °C/min	Final temp. °C	Holding time min	Tempering temp. °C	Cooling min
<b>Universal Stain &amp; Glaze</b>	400	2:00	2:00	2:00	off	1	55	760	2:00	0	0
<b>Universal Spray Glaze</b>	400	0:00	1:00	1:00	off	1	55	760	2:00	0	0

# CEREC Tessera™ & Celtra® Ceram

## Multimat® Cube/Cube press – Firing program Cut-back Technique

	Starting temp. °C	Pre-drying time min	Closing time min	Pre-heating time min	Vacuum on/off	Firing stages	Heating rate °C/min	Final temp. °C	Vacuum Holding time min	Holding time min	Tempering temp. °C	Cooling min	
<b>Matrix firing</b>	400	0:00	1:00	1:00	off	1	55	760	0:00	2:00	0	0:00	
<b>Cut-back</b>	<b>Dentin 1</b>	400	2:00	2:00	2:00	on	1	55	770	1:00	1:00	0	5:00
	<b>Dentin 2</b>	400	2:00	2:00	2:00	on	1	55	760	1:00	1:00	0	5:00
<b>Glaze firing</b>	400	2:00	2:00	2:00	off	1	55	750	0:00	2:00	0	5:00	
<b>Spray Glaze</b>	400	0:00	1:00	1:00	off	1	55	750	0:00	2:00	0	5:00	
<b>Add-on</b>	400	2:00	2:00	2:00	on	1	55	750	1:00	1:00	0	5:00	

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