Glaze firing recommendations

Glaze firing of Celtra Duo should be performed using the following firing parameters:

› Starting temperature 500 °C.
› Place the object in the furnace on a firing support or a firing tray with firing pad.
› Sufficiently pre-dry the object in the furnace.

General firing recommendations

	First glaze firing	Second and subsequent glaze firings
Pre-drying	2:00 min plus 2:00 min when using SuperPeg II	2:00 min plus 2:00 min when using SuperPeg II
Drying (depending on the type of furnace)	2:00 min	2:00 min
Preheating	2:00 min	2:00 min
Start temperature	500°C	500°C
Heating rate	60°C / min	60°C / min
Final temperature	820°C	770°C
Vacuum	Off	Off
Holding time	1:30 min	1:30 min
Cooling*	3:00 min	3:00 min

** This cooling period of three minutes is only required for objects placed on firing pins or when using an auxiliary firing paste. If the object is placed directly on firing cotton with a firing support, no cooling phase is required.*

Recommendation:
Celtra Duo is very stable when fired and can be processed in a ceramic furnace without the use of firing paste.

* **Always use long-term cooling when using firing paste/firing pins:**

› When using a refractory material/firing paste (Superpeg II), the pre-drying time should be extended by 2–3 min.
› Only thin, scale-free metal pins or thin ceramic pins should be used for anchoring the objects in the firing paste. Make sure that the pins do not touch the restoration.
Apply only small quantities of firing paste, just enough to secure the restoration, on the pin.
Avoid filling the restoration completely with firing paste.

The final temperature of 820 °C must not be exceeded, not even briefly as a result of heating unit hysteresis.

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The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Glaze firing recommendations

Glaze firing of Celtra Duo should be performed using the following firing parameters:

› Starting temperature 500 °C.
› Place the object in the furnace supported on firing cotton or firing pad.
› Sufficiently pre-dry the object in the furnace.

Firing recommendations for the Programat P 500, EP 3000/5000

	Standby temperature	Closing time	Heating rate	Firing temperature	Holding time	Vacuum on/off	Longterm cooling L
First stain/ glaze firing	500 °C	3:30 min.	60 °C	820 °C	1:00 min.	–	* 750 °C
Second stain/ glaze firing	500 °C	3:30 min.	60 °C	770 °C	1:00 min.	–	* 750 °C

* This cooling period of three minutes is only required for objects placed on firing pins or when using an auxiliary firing paste.
If the object is placed directly on firing cotton with a firing support, no cooling phase is required.

Recommended firing parameters for the Programat CS/CS2

Standby temperature		500 °C
Closing time	S	3:30 min.
Heating rate	t ↑	60 °C
Holding temperature	T	820 °C (First stain) / 770 °C (Second stain)
Holding time	H	1:00 min.
Cooling temperature	t L	50 °C
Longterm cooling	L	750 °C (First stain) / 750 °C (Second stain)

Recommendation:
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* **Always use long-term cooling when using firing paste/firing pins:**

› When using a refractory material/firing paste (Superpeg II), the pre-drying time should be extended by 2–3 min.
› Only thin, scale-free metal pins or thin ceramic pins should be used for anchoring the objects in the firing paste. Make sure that the pins do not touch the restoration.
Apply only small quantities of firing paste, just enough to secure the restoration, on the pin.
Avoid filling the restoration completely with firing paste.

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Celtra® Duo

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	55	820	1:30	3:00	1:30

Recommendation:
Celtra Duo is very stable when fired and can be processed in a ceramic furnace without the use of firing paste.

* **Always use long-term cooling when using firing paste/firing pins:**

- When using a refractory material/firing paste (Superpeg II), the pre-drying time should be extended by 2–3 min.
- Only thin, scale-free metal pins or thin ceramic pins should be used for anchoring the objects in the firing paste. Make sure that the pins do not touch the restoration. Apply only small quantities of firing paste, just enough to secure the restoration, on the pin. Avoid filling the restoration completely with firing paste.

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