Authentic®

FIRING GUIDE

Layering Technique for Authentic Porcelain

	Dry Time	Start Temp	Start Vacuum	Rate of Time	First Firing	Second Firing	Hold Time
Shoulder Material	4 min	400° C	400° C	45°C/ min	780°C	770°C	1 min
Dentin / Incisal	5 min	400° C	400° C	45°C/ min	760°C	750°C	1 min
Stain / Glaze	5 min	400° C	400° C	45°C/ min	740°C	730°C	1 min
Correction Material	4 min	400°C	400°C	45°C/ min	710°C		1 min

Staining Technique for Authentic Porcelain

	Dry Time	Start Temp	Start Vacuum	Rate of Time	First Firing	Second Firing	Hold Time
Stain Shade	5 min	400° C	400°C	45°C/ min	740°C	740°C	1 min
Glaze	5 min	400° C	400°C	45°C/min	740°C	730°C	1 min

Low Fusing Ceramic Calibration

Because most ceramic furnaces fluctuate in the lower fusing range (800 C,) it is imperative that test tabs be fired using Transparent Clear ceramic to determine the correct high temperature specific to your furnace which fully matures the ceramic. To perform this test, the technician must follow these four easy steps:

- Create tabs of Transparent Clear about 8 mm square and approximately .5mm thick.
- Replicate first dentin firing conditions. Place ceramic tab on an ultra-thin piece of fiber-tray or platinum foil, on top of a firing peg (Master Ceramist Micro Color coded w/ metal pins,) then place on top of a honeycomb tray at the same height position in the furnace as a crown would be fired.
- Work with one variable (high temperature) only. Keep all other parameters constant, including hold time.
- Insure the tab is fired to full maturity with no granularity or chalkiness. Additionally, the print on the cap of a bottle of Authentic should be readable through the tab. The surface gloss should be relatively high, while still maintaining the edges of the tab.