Authentic® SHOULDER PORCELAIN TECHNIQUE GUIDE

SHADE	SHOULDER PORCELAIN	RATIO
A1	M2 +M1	3 to 1
A2	M2	100%
A3	M3+ M5	2 to 1
A3.5	M4+ M5	1 to 1
A4	M4 + M5	2 to 1
B1	M1+ M2	4 to 1
B2	M1+ M2	2 to 1
B3	M3	100%
B4	M4+ M3	3 to 1
C1	M2+ M6	1 to 1
C2	M6+ M2	2 to 1
C3	M6+ M5	3 to 1
C4	M6+ M5	4 to 1
D2	M2+ M5	4 to 1
D3	M2+ M5+M6	3 to 2 to 1
D4	M2 M5	3 to 1

Firing Guide for Authentic Shoulder Porcelain

	Dry Time	Start Temp	Start Vacuum	Rate of Time	First Firing	Second Firing	Hold Time
Shoulder Material	4 min	450° C	450°C	45°C/ min	780°C	770°C	1 min

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