



# Quick Start Instructions



Clean Substructure



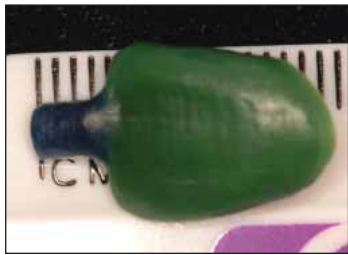
Coping with Liner



Wax Full Contour



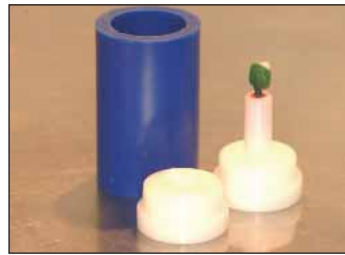
Minimum Wax Thickness of 0.8mm



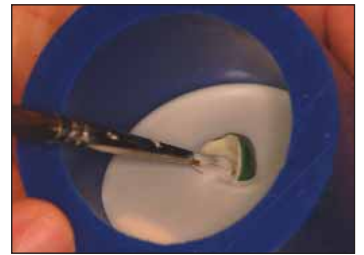
Proper Sprue Length



Crown Placed on Sprue Base



100g Sprue Set



Paint the Crown and Fill the Ring



Burning Out



Insert the Ingots and Plunger\*



Completed Pressing



Divested Crown



Cutting Back for the Enamel Porcelain



Cutting Back for the Enamel Porcelain



Cutting Back for the Enamel Porcelain



Porcelain Application



Stain & Glaze



Shade Verification

\* Preheat the plungers only. Do not preheat the ingots.

# Ceramco® PFZ Press Firing Temperatures

FIRING PROGRAMS IN °C	Time (min)			Time (min)		Vacuum	Set Temp		Temperature			
	Dry	Pre Heat	Vac Hold	Hi Temp Hold	Cool	Set Point (in. Hg)	Idle	Hi Temp	Vac Start	Vac Stop	Heat Rate °C/min	Night
Margin/Margin Modifier	5	5	0	15 sec	0	29	450	970	450	970	60	100
Pressable Liner, 1st Bake	5	5	0	1 min	0	29	450	930	450	900	60	100
Pressable Liner, 2nd Bake	5	5	0	0	0	29	450	920	450	900	60	100
Op Dentin/Dentin/Mod/Enamels, 1st Bake	5	5	0	15 sec	0	29	450	900	450	900	60	100
Op Dentin/Dentin/Mod/Enamels, 2nd Bake	5	5	0	0	0	29	450	890	450	890	60	100
Natural Glaze/Stains	5	5	0	30 sec	0	0	450	870			60	100
Overglaze/Stains	5	5	0	30 sec	0	0	450	850			60	100
Add-On	5	5	0	0	0	29	450	860	450	860	60	100

FIRING PROGRAMS IN °F	Time (min)			Time (min)		Vacuum	Set Temp		Temperature			
	Dry	Pre Heat	Vac Hold	Hi Temp Hold	Cool	Set Point (in. Hg)	Idle	Hi Temp	Vac Start	Vac Stop	Heat Rate °F/min	Night
Margin/Margin Modifier	5	5	0	15 sec	0	29	842	1778	842	1778	108	212
Pressable Liner, 1st Bake	5	5	0	1 min	0	29	842	1706	842	1652	108	212
Pressable Liner, 2nd Bake	5	5	0	0	0	29	842	1688	842	1652	108	212
Op Dentin/Dentin/Mod/Enamels, 1st Bake	5	5	0	15 sec	0	29	842	1652	842	1652	108	212
Op Dentin/Dentin/Mod/Enamels, 2nd Bake	5	5	0	0	0	29	842	1634	842	1634	108	212
Natural Glaze/Stains	5	5	0	30 sec	0	0	842	1598			108	212
Overglaze/Stains	5	5	0	30 sec	0	0	842	1562			108	212
Add-On	5	5	0	0	0	29	842	1580	842	1580	108	212

## Ceramco® PFZ Press Pressing Chart

Preheat the plungers only. Do not preheat the ingots.

PRESSING PROGRAMS IN °C	Low Temp °C	*High Temp °C	Heat Rate °C	High Hold Temp	Pressing Time 100g Ring Bench Cool	Pressing Time 200g Ring Bench Cool	Re-Press Time	Pressure	Vacuum
Finesse Press	700	940	60	20 min	10	20	na	4.25 bars	Full
Multimat Touch & Press	700	940	60	20 min	10	20	na	2.7 bars	Full
Empress EP 500	700	940	60	20 min	na	na	3	5.0 bars	Full
QEX CeramPress	700	940	60	20 min	10	20	na	4.25 bars	Full
Pro-Press 100	700	940	60	20 min	10	20	na	4.25 bars	Full

\*Due to variance in furnaces, high temperatures may need to be adjusted slightly.

## Ceramco® PFZ Pressable Technique Table 1

Shade	Natural Enamel	Opal Effect Enamel	Margin Porcelain	Mamelon	Dentin Modifier	Shade
A1	Extra Light	Opal Light	A1	Yellow-Orange	A1	A1
A2	Light	Opal Light	A1	Yellow-Orange	A1	A2
A3	Light	Opal Light	A3	Red-Orange	A1	A3
A3.5	Light	Opal Medium	A3	Red-Orange	A3.5	A3.5
A4	Medium	Opal Medium	A4	Red-Orange	A3.5	A4
B1	Extra Light	Opal White	B2	Yellow-Orange	B1	B1
B2	Light	Opal Light	B2	Yellow-Orange	B1	B2
B3	Medium	Opal Light	A3	Red-Orange	B3	B3
B4	Medium	Opal Light	A4	Red-Orange	B3	B4
C1	Light	Opal Light	C1	Yellow-Orange	C1	C1
C2	Medium	Opal Light	C1	Yellow-Orange	C1	C2
C3	Medium	Opal Medium	C3	Red-Orange	C3	C3
C4	Medium	Opal Medium	C3	Red-Orange	C3	C4
D2	Extra Light	Opal Light	C1	Yellow-Orange	A1	D2
D3	Medium	Opal Light	A3	Yellow-Orange	B1	D3
D4	Medium	Opal Light	A3	Red-Orange	C3	D4