

Firing charts MiYO I MiYO pink

! The following firing temperatures are standard values and may vary depending on the type of furnace and the size (volume) of the restoration.
Please note the information on MiYO firing graphs in chapter 1.8!

COLOR | STRUCTURE | GLAZE

Firing paramter*	start temperature [°C]	dry time [min]	closing time [min]	heat rate [°C / min]	holding time 1 [s]	vacuum start [°C]	end temperature [°C]	vacuum end [°C]	holding time 2 [s]*	opening time [min]
ZrO ₂	400 - 450	3	4	45	30 - 45	580	720	720	30 - 60	1
InSync ZR	400 - 450	3	4	45	30 - 45	580	720	720	30 - 60	1
InSync MC	400 - 450	3	4	45	30 - 45	580	720	720	30 - 60	1
Press to Zirconia	400 - 450	3	4	45	30 - 45	580	720	720	30 - 60	1
Lithium Disilicate	400 - 450	3	4	45	30 - 45	580	710	710	30 - 60	1

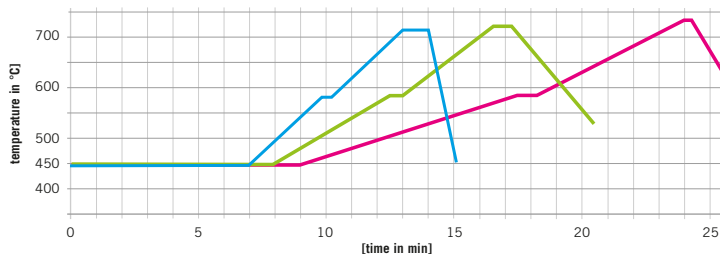
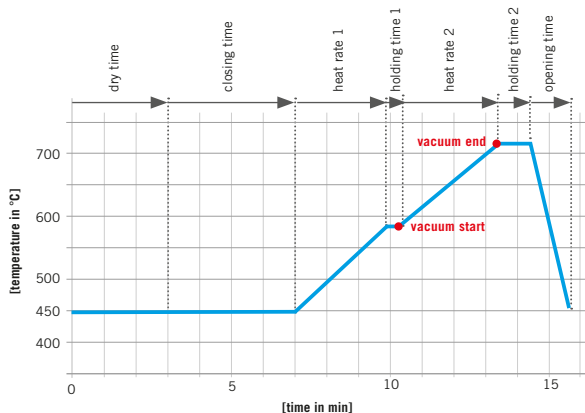
* Valid for all Color- Structure- and Glaze firings. | ** Depending on the desired shine, holding time should be 30 - 60 seconds.

HT STRUCTURE

Firing paramter*	start temperature [°C]	dry time [min]	closing time [min]	heat rate [°C / min]	holding time 1 [s]	vacuum start [°C]	end temperature [°C]	vacuum end [°C]	holding time 2 [s]*	opening time [min]
ZrO ₂	400 - 450	3	4	45	30 - 45	600	775	775	60	1
InSync ZR	400 - 450	3	4	45	30 - 45	600	775	775	60	1

* Valid for HT structure firing. | ** Depending on the desired shine, holding time should be 30 - 60 seconds.

1.8 Notes to MiYO firing graphs



Single crowns /
bridges up to 4 units
5 - 8 pontic units
9 - 14 pontic units

DRY TIME

- Only MiYO Color / Glaze Paste: 3 min
- With MiYO Structure: 4 min

CLOSING TIME

- Single crowns and bridges up to 4 units: 4 min
- Restorations with large volumes / bridges with more than 4 units: 5 - 6 min

HEAT RATE 1

- Single crowns and bridges up to 4 units: 45°/ min
- 5 - 8 units: 35°- 40°/ min
- 9 - 14 units: 20°- 25°/ min

HEAT RATE 2

- Bridges with more than 5 units: max 40°/ min

HOLDING TIME 2

- Single crowns and bridges up to 4 units: 1 min
- Reduce holding time 2 for large restorations, since the slow opening phase creates an „afterburning effect“.

OPENING TIME

- Opening phase according to the manufacturer's instructions for the framework material.