MiYO Firing Parameters - for Teeth

The following firing temperatures are standard values and may vary depending on the type of furnace. The larger the mass of zirconia or lithium disilicate, the slower the rate of temperature increase is required to allow the large mass to heat up the same internally and externally. Firing parameters represent standard values and may need to be adjusted. Final results should be the determining factor in furnace adjustments. If higher sheen is desired, increase high temperature.

	ZIRCONIA SMALL CASES SINGLE UNITS TO 3 UNIT BRIDGES			ZIRCONIA MEDIUM CASES 4-8+ UNIT BRIDGES			ZIRCONIA LARGE CASES FULL ARCH/ALL-ON-4			LITHIUM DISILICATE SINGLE UNITS TO 3 UNIT BRIDGES		
	MiYO Color & InSync Glaze	MiYO Structure	MiYO Structure High Fusing	MiYO Color & InSync Glaze	MiYO Structure	MiYO Structure High Fusing	MiYO Color & InSync Glaze	MiYO Structure	MiYO Structure High Fusing	MiYO Color & InSync Glaze	MiYO Structure	MiYO Structure High Fusing
Dry Time (Min)	5	5	5	6-8	6-8	6-8	8-10	8-10	8-10	5	5	5
Entry Time (Min)	6	6	6	6-8	6-8	6-8	8-10	8-10	8-10	5	5	5
Low Temp (°C)	450°C	450°C	450°C	450°C	450°C	450°C	430°C	430°C	430°C	550°C	550°C	550°C
Vacuum Start (°C)	510°C	510°C	510°C	510°C	510°C	510°C	510°C	510°C	510°C	550°C	550°C	550°C
Heat Rate (°C/Min)	45°C	45°C	45°C	40°C	40°C	40°C	35°C	35°C	35°C	45°C	45°C	50°C
High Temp (°C)	745°C	710°C	760°C	745°C	705°C	755°C	735°C	700°C	750°C	770°C	710°C	765°C
Vacuum Stop (°C)	745°C	710°C	760°C	745°C	705°C	755°C	735°C	700°C	750°C	770°C	710°C	765°C
Hold Time in Air (Min)	1	40 Sec	1	1	40 Sec	1	1	20 Sec	1	2	40 Sec	1
Cool Time (Min)	~5	~5	~5	~12	~12	~12	~20	~20	~20	~5	~5	~5

CTE (25-500°C) [*10^{-6} K^{-1}] ± 1.0: MiYO Colors & Structure 7.4 (2x)
CTE (25-500°C) [*10^{-6} K^{-1}] ± 0.5: MiYO and InSync Glaze 7.3 (1x)
CTE (25-500°C) [*10^{-6} K^{-1}] ± 0.5: High Fusing Structure 8.2 (1x)
Storage: Store under dry conditions, +12°C to +38°C

NOTE: Clamshell type furnaces typically need to have 10°C added to temps to fire the same as the vertical furnace temps shown in the chart. Early model clamshell-type ovens are not able to maintain a 'standby' temperature when open, requiring different dry/closing parameters and procedures. It is up to the technician to verify temps, no matter which furnace type is used.

MiYO Firing Parameters - for Gingiva

The following firing temperatures are standard values and may vary depending on the type of furnace. The larger the mass of zirconia or lithium disilicate, the slower the rate of temperature increase is required to allow the large mass to heat up the same internally and externally. Firing parameters represent standard values and may need to be adjusted. Final results should be the determining factor in furnace adjustments. If higher sheen is desired, increase high temperature.

	ZIRCONIA SMALL CASES SINGLE UNITS TO 3 UNIT BRIDGES		ZIRCONIA MEDIUM CASES 4-8+ UNIT BRIDGES		ZIRCONIA LARGE CASES FULL ARCH/ALL-ON-4		LITHIUM DISILICATE SINGLE UNITS TO 3 UNIT BRIDGES	
	MiYO Color & MiYO/InSync Glaze	MiYO Structure	MiYO Color & MiYO/InSync Glaze	MiYO Structure	MiYO Color & MiYO/InSync Glaze	MiYO Structure	MiYO Color & MiYO/InSync Glaze	MiYO Structure
Dry Time (Min)	5	5	6-8	6-8	8-10	8-10	5	5
Entry Time (Min)	6	6	6-8	6-8	8-10	8-10	5	5
Low Temp (°C)	450°C	450°C	450°C	450°C	430°C	430°C	550°C	550°C
Vacuum Start (°C)	510°C	510°C	510°C	510°C	510°C	510°C	550°C	550°C
Heat Rate (°C/Min)	45°C	45°C	40°C	40°C	35°C	35°C	45°C	45°C
High Temp (°C)	745°C	710°C	745°C	705°C	735°C	700°C	770°C	710°C
Vacuum Stop (°C)	745°C	710°C	745°C	705°C	735°C	700°C	770°C	710°C
Hold Time in Air (Min)	1	40 Sec	1	40 Sec	1	20 Sec	2	40 Sec
Cool Time (Min)	~5	~5	~12	~12	~20	~20	~5	~5

CTE (25-500°C) [*10^{-6} K^{-1}] ± 1.0: MiYO Colors & Structure 7.4 (2x)
CTE (25-500°C) [*10^{-6} K^{-1}] ± 0.5: MiYO and InSync Glaze 7.3 (1x)
Storage: Store under dry conditions, +12°C to +38°C

NOTE: Clamshell type furnaces typically need to have 10°C added to temps to fire the same as the vertical furnace temps shown in the chart. Early model clamshell-type ovens are not able to maintain a 'standby' temperature when open, requiring different dry/closing parameters and procedures. It is up to the technician to verify temps, no matter which furnace type is used.

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