



Firing Parameters for Will-Ceram® Z Layered Restorations						
Firing Parameter	Will-Ceram® Z Stain	Body/Incisal 1 st Bake	Body/Incisal 2 nd Bake	Natural Glaze	Will-Ceram® U/P Stains & Will-Ceram® Z Glaze	Will-Ceram® Z Repair Powders
Pre-Dry	6 min	6 min	6 min	6 min	6 min	6 min
Low Temp	425 °C (800 °F)	425 °C (800 °F)	425 °C (800 °F)	425 °C (800 °F)	425 °C (800 °F)	425 °C (800 °F)
Heat Rate	55 °C/min (100 °F/min)	55 °C/min (100 °F/min)	55 °C/min (100 °F/min)	55 °C/min (100 °F/min)	70 °C/min (125 °F/min)	40 °C/min (70 °F/min)
Vac	Full	Full	Full	N/A	Full	Full
Vac Start	480 °C (900 °F)	480 °C (900 °F)	480 °C (900 °F)	N/A	480 °C (900 °F)	480 °C (900 °F)
Vac Stop	1000 °C (1830 °F)	800 °C (1470 °F)	785 °C (1445 °F)	N/A	765 °C (1410 °F)	770 °C (1420 °F)
Hi Temp	1000 °C (1830 °F)	855 °C (1570 °F)	840 °C (1545 °F)	820 °C (1510 °F)	765 °C (1410 °F)	770 °C (1420 °F)
Hold	0	0	0	0	0	0
Cool	0	0	0	0	0	0

