

CM Soprano® Surface Firing Parameters

Optimized for full-arch zirconia restorations

For furnace brand/model-specific settings, contact anax USA customer service at 877.897.6598

Soprano Surface Gingiva Stains and Pastes											
Starting Temp	Pre-Drying Protocol	Closing Time	Temp Rise	Vacuum Start	High Temp			Vacuum End	Hold Time	Temp Decline	Open Temp
400° to 450° C	Dry material manually by placing the arch on the furnace platform and raising/closing the oven no more than half way. Allow to dry until ceramic appears chalky and completely dry. Stains = 15 min avg. Surface pastes = 12 min avg.	8 min.	20° C	670° C	775° C	770° C	765° C	Match High Temp	1 minute <small>(increase to 1.5 minutes for high temp lower than 770)</small>	25° C	400° C to 450° C
					1st Bake	2nd Bake	3rd Bake (if needed)				

Soprano Surface Tooth Shade Stains and Pastes											
Starting Temp	Pre-Drying Protocol	Closing Time	Temp Rise	Vacuum Start	High Temp			Vacuum End	Hold Time	Temp Decline	Open Temp
400° to 450° C	Dry material manually by placing the arch on the furnace platform and raising/closing the oven no more than half way. Allow to dry until ceramic appears chalky and completely dry. Stains = 10 min avg. Surface pastes = 12 min avg.	8 min.	20° C	670° C	775° C	770° C	765° C	Match High Temp	1 minute <small>(increase to 1.5 minutes for high temp lower than 770)</small>	25° C	400° C to 450° C
					1st Bake	2nd Bake	3rd Bake (if needed)				

Soprano Surface Glaze											
Starting Temp	Pre-Drying Protocol	Closing Time	Temp Rise	Vacuum Start	High Temp	Vacuum End	Hold Time	Vacuum End	Temp Decline	Open Temp	
400° to 450° C	Set pre-dry time to 10 minutes.	8 min.	30° C	No Vacuum	750° C	No Vacuum	1 minute	No Vacuum	30° C	400° C to 450° C	