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Pressing Schedule	Whip Mix Pro Press 100
Initial Temp (B)	700°C 1292°F
Heat Rate (t↑)	60°C/min 108°F/min
Final Temp (T)	870°C 1598°F
Hold Time (H)	10 mins
Press Time	12 mins

Pressing Schedule	Ivoclar EP500
Initial Temp (B)	700°C 1292°F
Heat Rate (t↑)	60°C/min 108°F/min
Final Temp (T)	870°C 1598°F
Hold Time (H)	12 mins

Pressing Schedule	Ivoclar EP600
Initial Temp (B)	700°C 1292°F
Heat Rate (t↑)	60°C/min 108°F/min
Hold Time (H)	10 mins
Press Time	12 mins
Stop Speed (E)	100 µm/min
Final Temp (T)	870°C 1598°F
Pressure	5.0 bars

* Pressing parameters were established at 900°C (1652°F) ring burn-out temperature

Coordination Chart

Refer to this chart when matching Prismatic CZ Press stains to Ingots.

CZ Press Stain	PS1	PS2	PS3	PS4	PS5	PS6	PS7
CZ Press Pellet	A1 B1	B2 C1	A2 A3	A3.5 A4	B3 B4	C2 C3 C4	D2 D3 D4

	Press Stain (PS1-7)	Stain & Glaze	Add-On	Stain (After Add-On)
Low Temp	480°C 896°F	480°C 896°F	425°C 797°F	480°C 896°F
Pre-Dry Time	6 mins	6 mins	6 mins	6 mins
Heat Rate	50°C/min 90°F/min	70°C/min 126°F/min	45°C/min 81°F/min	70°C/min 126°F/min
Vac Level	Full	Full	Full	Full
Vac Start	540°C 1004°F	540°C 1004°F	480°C 896°F	540°C 1004°F
Vac Release	1000°C 1832°F	775°C 1427°F	815°C 1499°F	675°C 1247°F
Hi Temp	1000°C 1832°F	830°C 1526°F	815°C 1499°F	730°C 1346°F
Hold Time	0	0	0	0
Cool Time	0	0	0	0