

Duceram® Kiss – General firing recommendations



		Pre-heating	Drying time	Heating rate	Final	Holding time	Vacuum	Extended
		°C	Pre-heating time	°C/min	temperature	min	hPa	cooling
			min		°C			min
	Oxide	For details, please refer to the processing instructions for the respective non-precious alloys.						
Bio-alloy program	Neutral paste	575	7:00	55	900	3:00	50	–
	Paste opaque	575	7:00	55	900	3:00	50	–
	Powder opaque	575	5:00	55	900	3:00	50	–
Conventional alloys	Paste op. 1 + 2	575	7:00	55	930	2:00	50	–
	Powder op. 1 + 2	575	5:00	55	930	2:00	50	–
Example: Degudent Kiss	Shoulder 1	575	7:00	55	920	1:00	50	–
	Shoulder 2	575	7:00	55	920	1:00	50	–
	Dentine 1	575	6:00	55	910	1:00	50	–
	Dentine 2	575	4:00	55	900	1:00	50	–
	Glaze	575	3:00	55	890	1:00	–	–
	Correction	575	4:00	55	880	1:00	50	–
	Final Shoulder	575	4:00	55	660	1:00	50	–
Long-term cooling at a CTE of 14.5 µm/m·K and above	Dentine 1	575	6:00	55	910	1:00	50	3 min/850 °C
	Dentine 2	575	4:00	55	900	1:00	50	3 min/850 °C
	Glaze	575	3:00	55	890	1:00	–	3 min/850 °C

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Duceram® Kiss – Specific firing recommendations



Cergo compact/press conventional alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Drying 1		Clo- sing	Preheating		In- crease	Vacuum			Final tempe- rature	Holding		Tempering		Cooling	
	°C	min	min	°C	min	°C/ min	on/ off/ cont	On °C	Off °C	°C	V min	min	min	°C	min	
Paste opaque	135	4:00	2:00	575	1:00	55	cont	575	930	930	0:00	2:00	0:00	–	0:00	
Powder opaque	135	2:00	2:00	575	1:00	55	cont	575	930	930	0:00	2:00	0:00	–	0:00	
Shoulder 1 + 2	135	2:00	2:00	575	2:00	55	cont	575	920	920	0:00	1:00	0:00	–	0:00	
Dentine 1	135	1:00	3:00	575	2:00	55	cont	575	910	910	0:00	1:00	0:00	–	0:00	
Dentine 2	135	1:00	2:00	575	2:00	55	cont	575	900	900	0:00	1:00	0:00	–	0:00	
Glaze	135	1:00	2:00	575	1:00	55	off	–	–	890	–	1:00	0:00	–	0:00	
Correction (Final Kiss)	135	1:00	1:00	575	1:00	55	cont	575	880	880	0:00	1:00	0:00	–	0:00	
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	55	cont	450	660	660	0:00	1:00	0:00	–	0:00	

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Duceram® Kiss – Specific firing recommendations



Cergo compact/press conventional alloys CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Drying 1		Clo- sing	Preheating		In- crease	Vacuum			Final tempe- rature	Holding		Tempering		Cooling	
	°C	min	min	°C	min	°C/ min	on/ off/ cont	On °C	Off °C	°C	V min	min	min	°C	min	
Paste opaque	135	4:00	2:00	575	1:00	55	cont	575	930	930	0:00	2:00	0:00	–	0:00	
Powder opaque	135	2:00	2:00	575	1:00	55	cont	575	930	930	0:00	2:00	0:00	–	0:00	
Shoulder 1 + 2	135	2:00	2:00	575	2:00	55	cont	575	920	920	0:00	1:00	0:00	–	0:00	
Dentine 1	135	1:00	3:00	575	2:00	55	cont	575	910	910	0:00	1:00	3:00	850	0:00	
Dentine 2	135	1:00	2:00	575	2:00	55	cont	575	900	900	0:00	1:00	3:00	850	0:00	
Glaze	135	1:00	2:00	575	1:00	55	off	–	–	890	–	1:00	3:00	850	0:00	
Correction (Final Kiss)	135	1:00	1:00	575	1:00	55	cont	575	880	880	0:00	1:00	3:00	850	0:00	
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	55	cont	450	660	660	0:00	1:00	0:00	–	0:00	

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Duceram® Kiss – Specific firing recommendations



Cergo compact/press bio-alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Drying		Clo- sing		Preheating		In- crease		Vacuum		End tem- perature		Holding		Tempering		Cooling	
	°C	min	min	°C	min	°C/ min	on/ off/ cont	On °C	Off °C	°C	°C	V min	min	min	°C	min		
Neutral paste	135	4:00	2:00	575	1:00	55	cont	575	900	900	900	0:00	3:00	0:00	–	0:00		
Paste opaque	135	4:00	2:00	575	1:00	55	cont	575	900	900	900	0:00	3:00	0:00	–	0:00		
Powder opaque	135	2:00	2:00	575	1:00	55	cont	575	900	900	900	0:00	3:00	0:00	–	0:00		
Shoulder 1 +2	135	2:00	2:00	575	2:00	55	cont	575	920	920	920	0:00	1:00	0:00	–	0:00		
Dentine 1	135	1:00	3:00	575	2:00	55	cont	575	910	910	910	0:00	1:00	0:00	–	0:00		
Dentine 2	135	1:00	2:00	575	2:00	55	cont	575	900	900	900	0:00	1:00	0:00	–	0:00		
Glaze	135	1:00	2:00	575	1:00	55	off	–	–	890	890	–	1:00	0:00	–	0:00		
Correction (Final Kiss)	135	1:00	1:00	575	1:00	55	cont	575	880	880	880	0:00	1:00	0:00	–	0:00		
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	55	cont	450	660	660	660	0:00	1:00	0:00	–	0:00		

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Duceram® Kiss – Specific firing recommendations



Cergo compact/press bio-alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Drying		Clo- sing	Preheating		In- crease	Vacuum			Final tempe- rature	Holding		Tempering		Cooling	
	°C	min	min	°C	min	°C/ min	on/ off/ cont	On °C	Off °C	°C	V min	min	min	°C	min	
Neutral paste	135	4:00	2:00	575	1:00	55	cont	575	900	900	0:00	3:00	0:00	–	0:00	
Paste opaque	135	4:00	2:00	575	1:00	55	cont	575	900	900	0:00	3:00	0:00	–	0:00	
Powder opaque	135	2:00	2:00	575	1:00	55	cont	575	900	900	0:00	3:00	0:00	–	0:00	
Shoulder 1 + 2	135	2:00	2:00	575	2:00	55	cont	575	920	920	0:00	1:00	0:00	–	0:00	
Dentine 1	135	1:00	3:00	575	2:00	55	cont	575	910	910	0:00	1:00	3:00	850	0:00	
Dentine 2	135	1:00	2:00	575	2:00	55	cont	575	900	900	0:00	1:00	3:00	850	0:00	
Glaze	135	1:00	2:00	575	1:00	55	off	–	–	890	–	1:00	3:00	850	0:00	
Correction (Final Kiss)	135	1:00	1:00	575	1:00	55	cont	575	880	880	0:00	1:00	3:00	850	0:00	
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	55	cont	450	660	660	0:00	1:00	0:00	–	0:00	

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Duceram® Kiss – Specific firing recommendations



Cergo compact/press Non-precious alloys, Compartis

	Drying		Clo- sing	Preheating		In- crease	Vacuum			End tem- perature	Holding		Tempering		Cooling	
	°C	min	min	°C	min	°C/ min	on/ off/ cont	On °C	Off °C	°C	V min	min	min	°C	min	
NE-Bonder (paste)	135	4:00	2:00	575	1:00	55	cont	575	980	980	0:00	2:00	0:00	-	0:00	
NE-Bonder (powder)	135	2:00	2:00	575	1:00	55	cont	575	980	980	0:00	2:00	0:00	-	0:00	
Paste opaque	135	4:00	2:00	575	1:00	55	cont	575	950	950	0:00	2:00	0:00	-	0:00	
Powder opaque	135	2:00	2:00	575	1:00	55	cont	575	950	950	0:00	2:00	0:00	-	0:00	
Shoulder 1 + 2	135	2:00	2:00	575	2:00	55	cont	575	930	930	0:00	1:00	0:00	-	0:00	
Dentine 1	135	1:00	3:00	575	2:00	55	cont	575	920	920	0:00	1:00	3:00	850	6:00	
Dentine 2	135	1:00	2:00	575	2:00	55	cont	575	910	910	0:00	1:00	3:00	850	6:00	
Glaze	135	1:00	2:00	575	1:00	55	off	-	-	890	-	1:00	3:00	850	6:00	
Correction (Final Kiss)	135	1:00	1:00	575	1:00	55	cont	575	880	880	0:00	1:00	3:00	850	6:00	
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	55	cont	450	660	660	0:00	1:00	0:00	-	0:00	

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Duceram® Kiss – Specific firing recommendations



ProFire Press conventional alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Drying		Clo- sing		Preheating		Vacuum		Heating rate	End tem- perature	Va- cuum time	Hol- ding time	Tempering		Cooling
	°C	min	min	°C	min	on/ off/ cont	On °C	Off °C					°C/min	°C	
Paste opaque 1+2	135	4:00	2:00	575	1:00	cont	575	930	55	930	1:00	2:00	0	0:00	0:00
Powder opaque 1+2	135	2:00	2:00	575	1:00	cont	575	930	55	930	1:00	2:00	0	0:00	0:00
Shoulder 1+2	135	2:00	2:00	575	2:00	cont	575	920	55	920	1:00	1:00	0	0:00	0:00
Dentine 1	135	1:00	3:00	575	2:00	cont	575	910	55	910	1:00	1:00	0	0:00	0:00
Dentine 2	135	1:00	2:00	575	2:00	cont	575	900	55	900	1:00	1:00	0	0:00	0:00
Glaze	135	1:00	2:00	575	1:00	off	–	–	55	890	–	1:00	0	0:00	0:00
Correction (Final Kiss)	135	1:00	1:00	575	1:00	cont	575	880	55	880	1:00	1:00	0	0:00	0:00
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	cont	450	660	55	660	1:00	1:00	0	0:00	0:00

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Duceram® Kiss – Specific firing recommendations



ProFire Press conventional alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Drying		Clo- sing		Preheating		Vacuum			Heating rate	Final tempe- rature	Va- cuum time	Hol- ding time	Tempering		Cooling
	°C	min	min	°C	min	on/ off/ cont	On °C	Off °C	°C/min	°C	min	min	temp. °C	time min	min	
Paste opaque 1+2	135	4:00	2:00	575	1:00	cont	575	930	55	930	1:00	2:00	0	0:00	0:00	
Powder opaque 1+2	135	2:00	2:00	575	1:00	cont	575	930	55	930	1:00	2:00	0	0:00	0:00	
Shoulder 1+2	135	2:00	2:00	575	2:00	cont	575	920	55	920	1:00	1:00	0	0:00	0:00	
Dentine 1	135	1:00	3:00	575	2:00	cont	575	910	55	910	1:00	1:00	850	3:00	0:00	
Dentine 2	135	1:00	2:00	575	2:00	cont	575	900	55	900	1:00	1:00	850	3:00	0:00	
Glaze	135	1:00	2:00	575	1:00	off	–	–	55	890	–	1:00	850	3:00	0:00	
Correction (Final Kiss)	135	1:00	1:00	575	1:00	cont	575	880	55	880	1:00	1:00	850	3:00	0:00	
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	cont	450	660	55	660	1:00	1:00	0	0:00	0:00	

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Duceram® Kiss – Specific firing recommendations



ProFire Press bio-alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Drying		Clo- sing	Preheating		Vacuum		Heating rate		Final tempe- rature	Va- cuum time	Hol- ding time	Tempering		Cooling
	°C	min	min	°C	min	on/ off/ cont	On °C	Off °C	°C/min	°C	min	min	temp. °C	time min	min
Neutral paste	135	4:00	2:00	575	1:00	cont	575	900	55	900	1:00	3:00	0	0:00	0:00
Paste opaque	135	4:00	2:00	575	1:00	cont	575	900	55	900	1:00	3:00	0	0:00	0:00
Powder opaque	135	2:00	2:00	575	1:00	cont	575	900	55	900	1:00	3:00	0	0:00	0:00
Shoulder 1+ 2	135	2:00	2:00	575	2:00	cont	575	920	55	920	1:00	1:00	0	0:00	0:00
Dentine 1	135	1:00	3:00	575	2:00	cont	575	910	55	910	1:00	1:00	0	0:00	0:00
Dentine 2	135	1:00	2:00	575	2:00	cont	575	900	55	900	1:00	1:00	0	0:00	0:00
Glaze	135	1:00	2:00	575	1:00	off	–	–	55	890	–	1:00	0	0:00	0:00
Correction (Final Kiss)	135	1:00	1:00	575	1:00	cont	575	880	55	880	1:00	1:00	0	0:00	0:00
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	cont	450	660	55	660	1:00	1:00	0	0:00	0:00

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Duceram® Kiss – Specific firing recommendations



ProFire Press bio-alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Drying		Clo-sing		Preheating		Vacuum		Heating rate °C/min	Final tempe- rature °C	Va- cuum time min	Hol- ding time min	Tempering		Cooling min
	°C	min	min	°C	min	on/ off/ cont	On °C	Off °C					temp. °C	time min	
Neutral paste	135	4:00	2:00	575	1:00	cont	575	900	55	900	1:00	3:00	0	0:00	0:00
Paste opaque	135	4:00	2:00	575	1:00	cont	575	900	55	900	1:00	3:00	0	0:00	0:00
Powder opaque	135	2:00	2:00	575	1:00	cont	575	900	55	900	1:00	3:00	0	0:00	0:00
Shoulder 1+ 2	135	2:00	2:00	575	2:00	cont	575	920	55	920	1:00	1:00	0	0:00	0:00
Dentine 1	135	1:00	3:00	575	2:00	cont	575	910	55	910	1:00	1:00	850	3:00	0:00
Dentine 2	135	1:00	2:00	575	2:00	cont	575	900	55	900	1:00	1:00	850	3:00	0:00
Glaze	135	1:00	2:00	575	1:00	off	–	–	55	890	–	1:00	850	3:00	0:00
Correction (Final Kiss)	135	1:00	1:00	575	1:00	cont	575	880	55	880	1:00	1:00	850	3:00	0:00
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	cont	450	660	55	660	1:00	1:00	0	0:00	0:00

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Duceram® Kiss – Specific firing recommendations



ProFire Press Non-precious alloys, Compartis

	Drying		Clo- sing		Preheating		Vacuum		Heating rate	Final tempe- rature	Va- cuum time	Hol- ding time	Tempering		Cooling
	°C	min	min	°C	min	on/ off/ cont	On °C	Off °C					°C/min	°C	
NE-Bonder (paste)	135	4:00	2:00	575	1:00	cont	575	980	55	980	1:00	2:00	0	0:00	0:00
NE-Bonder (powder)	135	2:00	2:00	575	1:00	cont	575	980	55	980	1:00	1:00	0	0:00	0:00
Paste opaque 2	135	4:00	2:00	575	1:00	cont	575	950	55	950	1:00	2:00	0	0:00	0:00
Powder opaque 2	135	2:00	2:00	575	1:00	cont	575	950	55	950	1:00	2:00	0	0:00	0:00
Shoulder 1+2	135	2:00	2:00	575	2:00	cont	575	930	55	930	1:00	1:00	0	0:00	0:00
Dentine 1	135	1:00	3:00	575	2:00	cont	575	920	55	920	1:00	1:00	850	3:00	6:00
Dentine 2	135	1:00	2:00	575	2:00	cont	575	910	55	910	1:00	1:00	850	3:00	6:00
Glaze	135	1:00	2:00	575	1:00	off	–	–	55	890	–	1:00	850	3:00	6:00
Correction (Final Kiss)	135	1:00	1:00	575	1:00	cont	575	880	55	880	1:00	1:00	850	3:00	6:00
Final Shoulder (F SM)	135	1:00	2:00	450	1:00	cont	450	660	55	660	1:00	1:00	0	0:00	0:00

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Duceram® Kiss – Specific firing recommendations



Multimat NT/NTX conventional alloys, CTE from 13,8–14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Start-temp.	Pre-drying	Drying	Pre-heating temp.	Pre-heating time	Heating rate	Vacuum level	Final-temp.	Holding time	Vacuum time	Tempering temp.	Tempering time	Cooling level
	°C	min	min	°C	min	°C/min	hPa	°C	min	min	°C	min	
Paste opaque	575	0:00	7:00	575	1:00	55	50	930	3:00	1:00	0	0:00	0
Powder opaque	575	0:00	4:00	575	1:00	55	50	930	3:00	1:00	0	0:00	0
Shoulder 1 + 2	575	0:00	5:00	575	2:00	55	50	920	2:00	1:00	0	0:00	0
Dentine 1	575	0:00	5:00	575	2:00	55	50	910	2:00	1:00	0	0:00	0
Dentine 2	575	0:00	4:00	575	2:00	55	50	900	2:00	1:00	0	0:00	0
Glaze	575	0:00	3:00	575	1:00	55	0	890	1:00	0:00	0	0:00	0
Correction (Final Kiss)	575	0:00	3:00	575	1:00	55	50	880	2:00	1:00	0	0:00	0
Final Shoulder (F SM)	450	0:00	3:00	450	2:00	55	50	660	2:00	1:00	0	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

Please observe the instruction of Duceram Kiss. There you will find information on the intended use, contraindications, warnings, cautions and technical data.



Duceram® Kiss – Specific firing recommendations



Multimat NT/NTX conventional alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Start-temp.	Pre-drying	Drying	Pre-heating temp.	Pre-heating time	Heating rate	Vacuum level	Final-temp.	Holding time	Vacuum time	Tempering temp.	Tempering time	Cooling level
	°C	min	min	°C	min	°C/min	hPa	°C	min	min	°C	min	
Paste opaque	575	0:00	7:00	575	1:00	55	50	930	3:00	1:00	0	0:00	0
Powder opaque	575	0:00	4:00	575	1:00	55	50	930	3:00	1:00	0	0:00	0
Shoulder 1 + 2	575	0:00	5:00	575	2:00	55	50	920	2:00	1:00	0	0:00	0
Dentine 1	575	0:00	5:00	575	2:00	55	50	910	2:00	1:00	850	3:00	0
Dentine 2	575	0:00	4:00	575	2:00	55	50	900	2:00	1:00	850	3:00	0
Glaze	575	0:00	3:00	575	1:00	55	0	890	1:00	0:00	850	3:00	0
Correction (Final Kiss)	575	0:00	3:00	575	1:00	55	50	880	2:00	1:00	850	3:00	0
Final Shoulder (F SM)	450	0:00	3:00	450	2:00	55	50	660	2:00	1:00	0	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat NT/NTX bio-alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Start-temp.	Pre-drying	Drying	Pre-heating temp.	Pre-heating time	Heating rate	Vacuum level	Final-temp.	Holding time	Vacuum time	Tempering temp	Tempering time	Cooling level
	°C	min	min	°C	min	°C/min	hPa	°C	min	min	°C	min	
Neutral paste	575	0:00	7:00	575	1:00	55	50	900	4:00	1:00	0	0:00	0
Paste opaque	575	0:00	7:00	575	1:00	55	50	900	4:00	1:00	0	0:00	0
Powder opaque	575	0:00	4:00	575	1:00	55	50	900	4:00	1:00	0	0:00	0
Shoulder 1 + 2	575	0:00	5:00	575	2:00	55	50	920	2:00	1:00	0	0:00	0
Dentine 1	575	0:00	5:00	575	2:00	55	50	910	2:00	1:00	0	0:00	0
Dentine 2	575	0:00	4:00	575	2:00	55	50	900	2:00	1:00	0	0:00	0
Glaze	575	0:00	3:00	575	1:00	55	0	890	1:00	0:00	0	0:00	0
Correction (Final Kiss)	575	0:00	3:00	575	1:00	55	50	880	2:00	1:00	0	0:00	0
Final Shoulder (F SM)	450	0:00	3:00	450	2:00	55	50	660	2:00	1:00	0	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat NT/NTX bio-alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Start-temp.	Pre-drying	Drying	Pre-heating time	Pre-heating time	Heating rate	Vacuum level	Final temp.	Holding time	Vacuum time	Tempering temp.	Tempering time	Cooling level
	°C	min	min	°C	min	°C/min	hPa	°C	min	min	°C	min	
Neutral paste	575	0:00	7:00	575	1:00	55	50	900	4:00	1:00	0:00	0:00	0
Paste opaque	575	0:00	7:00	575	1:00	55	50	900	4:00	1:00	0:00	0:00	0
Powder opaque	575	0:00	4:00	575	1:00	55	50	900	4:00	1:00	0:00	0:00	0
Shoulder 1 + 2	575	0:00	5:00	575	2:00	55	50	920	2:00	1:00	0:00	0:00	0
Dentine 1	575	0:00	5:00	575	2:00	55	50	910	2:00	1:00	850	3:00	0
Dentine 2	575	0:00	4:00	575	2:00	55	50	900	2:00	1:00	850	3:00	0
Glaze	575	0:00	3:00	575	1:00	55	0	890	1:00	0:00	850	3:00	0
Correction (Final Kiss)	575	0:00	3:00	575	1:00	55	50	880	2:00	1:00	850	3:00	0
Final Shoulder (F SM)	450	0:00	3:00	450	2:00	55	50	660	2:00	1:00	0:00	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat NT/NTX non-precious alloys, Compartis

	Start temp.	Pre-drying	Drying	Pre-heating temp.	Pre-heating time	Heating rate	Vacuum level	Final temp.	Holding time	Vacuum time	Tempering temp.	Tempering time	Cooling level
	°C	min	min	°C	min	°C/min	hPa	°C	min	min	°C	min	
NE-Bonder Paste	575	0:00	7:00	575	1:00	55	50	980	3:00	1:00	0:00	0:00	0
NE-Bonder Pulver	575	0:00	4:00	575	1:00	55	50	980	3:00	1:00	0:00	0:00	0
Paste opaque 2	575	0:00	7:00	575	1:00	55	50	950	3:00	1:00	0:00	0:00	0
Powder opaque 2	575	0:00	4:00	575	1:00	55	50	950	3:00	1:00	0:00	0:00	0
Shoulder 1 + 2	575	0:00	5:00	575	2:00	55	50	930	2:00	1:00	0:00	0:00	0
Dentine 1	575	0:00	5:00	575	2:00	55	50	920	2:00	1:00	850	3:00	1
Dentine 2	575	0:00	4:00	575	2:00	55	50	910	2:00	1:00	850	3:00	1
Glaze	575	0:00	3:00	575	1:00	55	0	890	1:00	0:00	850	3:00	1
Correction (Final Kiss)	575	0:00	3:00	575	1:00	55	50	880	2:00	1:00	850	3:00	1
Final Shoulder (F SM)	450	0:00	3:00	450	2:00	55	50	660	2:00	1:00	0	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat Touch&Press conventional alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Pre-heating temperature	Pre-drying	Drying	Pre-heating	Vacuum-level	Heating-rate	Firing temperatures	Va-cuum time	Firing time	Tempering temp.	Tem-pering time	Cooling level
	°C	min	min	min	hPa	°C/min	°C	min	min	°C	min	
Paste opaque 1 + 2	575	0:00	7:00	1:00	50	55	930	1:00	3:00	0:00	0:00	0
Powder opaque 1 + 2	575	0:00	4:00	1:00	50	55	930	1:00	3:00	0:00	0:00	0
Shoulder 1+2	575	0:00	5:00	2:00	50	55	920	1:00	2:00	0:00	0:00	0
Dentine 1	575	0:00	5:00	2:00	50	55	910	1:00	2:00	0:00	0:00	0
Dentine 2	575	0:00	4:00	2:00	50	55	900	1:00	2:00	0:00	0:00	0
Glaze	575	0:00	3:00	1:00	0	55	890	0:00	1:00	0:00	0:00	0
Correction (Final Kiss)	575	0:00	3:00	1:00	50	55	880	1:00	2:00	0:00	0:00	0
Final Shoulder (F SM)	450	0:00	3:00	2:00	50	55	660	1:00	2:00	0:00	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat Touch&Press conventional alloys, CTE $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Pre-heating temperature	Pre-drying	Drying	Pre-heating	Vacuum level	Heating rate	Firing temperatures	Vacuum time	Firing time	Tempering temp	Tempering time	Cooling level
	°C	min	min	min	hPa	°C/min	°C	min	min	°C	min	
Paste opaque 1 + 2	575	0:00	7:00	1:00	50	55	930	1:00	3:00	0:00	0:00	0
Powder opaque 1 + 2	575	0:00	4:00	1:00	50	55	930	1:00	3:00	0:00	0:00	0
Shoulder 1+2	575	0:00	5:00	2:00	50	55	920	1:00	2:00	0:00	0:00	0
Dentine 1	575	0:00	5:00	2:00	50	55	910	1:00	2:00	850	3:00	0
Dentine 2	575	0:00	4:00	2:00	50	55	900	1:00	2:00	850	3:00	0
Glaze	575	0:00	3:00	1:00	0	55	890	0:00	1:00	850	3:00	0
Correction (Final Kiss)	575	0:00	3:00	1:00	50	55	880	1:00	2:00	850	3:00	0
Final Shoulder (F SM)	450	0:00	3:00	2:00	50	55	660	1:00	2:00	0:00	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat Touch&Press bio-alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Pre-heating temperature	Pre-drying	Drying	Pre-heating	Vacuum level	Heating rate	Firing temperature	Vacuum time	Firing time	Tempering temp.	Tempering time	Cooling level
	°C	min	min	min	hPa	°C/min	°C	min	min	°C	min	
Neutral paste	575	0:00	7:00	1:00	50	55	900	1:00	4:00	0:00	0:00	0
Paste opaque 2	575	0:00	7:00	1:00	50	55	900	1:00	4:00	0:00	0:00	0
Powder opaque 2	575	0:00	4:00	1:00	50	55	900	1:00	4:00	0:00	0:00	0
Shoulder 1+ 2	575	0:00	5:00	2:00	50	55	920	1:00	2:00	0:00	0:00	0
Dentine 1	575	0:00	5:00	2:00	50	55	910	1:00	2:00	0:00	0:00	0
Dentine 2	575	0:00	4:00	2:00	50	55	900	1:00	2:00	0:00	0:00	0
Glaze	575	0:00	3:00	1:00	0	55	890	0:00	1:00	0:00	0:00	0
Correction (Final Kiss)	575	0:00	3:00	1:00	50	55	880	1:00	2:00	0:00	0:00	0
Final Shoulder (F SM)	450	0:00	3:00	2:00	50	55	660	1:00	2:00	0:00	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat Touch&Press bio-alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Pre-heating temperature	Pre-drying	Drying	Pre-heating	Vacuum level	Heating rate	Firing temperatures	Vacuum time	Firing time	Tempering temp.	Tempering time	Cooling level
	°C	min	min	min	hPa	°C/min	°C	min	min	°C	min	
Neutral paste	575	0:00	7:00	1:00	50	55	900	1:00	4:00	0	0:00	0
Paste opaque 2	575	0:00	7:00	1:00	50	55	900	1:00	4:00	0	0:00	0
Powder opaque 2	575	0:00	4:00	1:00	50	55	900	1:00	4:00	0	0:00	0
Shoulder 1+ 2	575	0:00	5:00	2:00	50	55	920	1:00	2:00	0	0:00	0
Dentine 1	575	0:00	5:00	2:00	50	55	910	1:00	2:00	3:00	850	0
Dentine 2	575	0:00	4:00	2:00	50	55	900	1:00	2:00	3:00	850	0
Glaze	575	0:00	3:00	1:00	0	55	890	0:00	1:00	3:00	850	0
Correction (Final Kiss)	575	0:00	3:00	1:00	50	55	880	1:00	2:00	3:00	850	0
Final Shoulder (F SM)	450	0:00	3:00	2:00	50	55	660	1:00	2:00	0:00	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat Touch&Press non-precious alloys, Compartis

	Pre-heating temperature	Pre-drying	Drying	Pre-heating	Vacuum level	Heating rate	Firing temperatures	Vacuum time	Firing time	Tempering temp	Tempering time	Cooling level
	°C	min	min	min	hPa	°C/min	°C	min	min	°C	min	
NE-Bonder Paste	575	0:00	7:00	1:00	50	55	980	1:00	3:00	0:00	0:00	0
NE-Bonder Powder	575	0:00	4:00	1:00	50	55	980	1:00	2:00	0:00	0:00	0
Paste opaque 2	575	0:00	7:00	1:00	50	55	950	1:00	3:00	0:00	0:00	0
Powder opaque 2	575	0:00	4:00	1:00	50	55	950	1:00	3:00	0:00	0:00	0
Shoulder 1+2	575	0:00	5:00	2:00	50	55	930	1:00	2:00	0:00	0:00	0
Dentine 1	575	0:00	5:00	2:00	50	55	920	1:00	2:00	850	3:00	1
Dentine 2	575	0:00	4:00	2:00	50	55	910	1:00	2:00	850	3:00	1
Glaze	575	0:00	3:00	1:00	–	55	890	–	1:00	850	3:00	1
Correction (Final Kiss)	575	0:00	3:00	1:00	50	55	880	1:00	2:00	850	3:00	1
Final Shoulder (F SM)	450	0:00	3:00	2:00	50	55	660	1:00	2:00	0:00	0:00	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat MC II conventional alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Pre-heating	Drying	Pre-heating	Vacuum	Firing	Tempering	Cooling	Firing	Heating	Vacuum
	°C	min	min	min/temp.	min	min		°C	°C/min	hPa
Paste opaque 1 + 2	575	7:00	1:00	1:00	3:00	0:00	0	930	55	50
Powder opaque 1 + 2	575	4:00	1:00	1:00	3:00	0:00	0	930	55	50
Shoulder 1 + 2	575	5:00	2:00	1:00	2:00	0:00	0	920	55	50
Dentine 1	575	5:00	2:00	1:00	2:00	0:00	0	910	55	50
Dentine 2	575	4:00	2:00	1:00	2:00	0:00	0	900	55	50
Glaze	575	3:00	1:00	0:00	1:00	0:00	0	890	55	–
Correction (Final Kiss)	575	3:00	1:00	1:00	2:00	0:00	0	880	55	50
Final Shoulder (F SM)	450	3:00	2:00	1:00	2:00	0:00	0	660	55	50

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat MC II conventional alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Pre-heating	Drying	Pre-heating	Vacuum	Firing	Tempering	Cooling	Firing	Heating	Vacuum
	°C	min	min	min/temp.	min	min		°C	°C/min	hPa
Paste opaque 1 + 2	575	7:00	1:00	1:00	3:00	0:00	0	930	55	50
Powder opaque 1 + 2	575	4:00	1:00	1:00	3:00	0:00	0	930	55	50
Shoulder 1 + 2	575	5:00	2:00	1:00	2:00	0:00	0	920	55	50
Dentine 1	575	5:00	2:00	1:00	2:00	3:00	0	910	55	50
Dentine 2	575	4:00	2:00	1:00	2:00	3:00	0	900	55	50
Glaze	575	3:00	1:00	0:00	1:00	3:00	0	890	55	–
Correction (Final Kiss)	575	3:00	1:00	1:00	2:00	3:00	0	880	55	50
Final Shoulder (F SM)	450	3:00	2:00	1:00	2:00	0:00	0	660	55	50

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat MC II bio-alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Pre-heating	Drying	Pre-heating	Vacuum	Firing	Tempering	Cooling	Firing	Heating	Vacuum
	°C	min	min	min/temp.	min	min		°C	°C/min	hPa
Neutral paste	575	7:00	1:00	1:00	4:00	0:00	0	900	55	50
Paste opaque	575	7:00	1:00	1:00	4:00	0:00	0	900	55	50
Powder opaque	575	4:00	1:00	1:00	4:00	0:00	0	900	55	50
Shoulder 1 + 2	575	5:00	2:00	1:00	2:00	0:00	0	920	55	50
Dentine 1	575	5:00	2:00	1:00	2:00	0:00	0	910	55	50
Dentine 2	575	4:00	2:00	1:00	2:00	0:00	0	900	55	50
Glaze	575	3:00	1:00	0:00	1:00	0:00	0	890	55	–
Correction (Final Kiss)	575	3:00	1:00	1:00	2:00	0:00	0	880	55	50
Final Shoulder (F SM)	450	3:00	2:00	1:00	2:00	0:00	0	660	55	50

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Duceram® Kiss – Specific firing recommendations



Multimat MC II bio-alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Pre-heating	Drying	Pre-heating	Vacuum	Firing	Tempering	Cooling	Firing	Pre-heating	Vacuum
	°C	min	min	min/temp.	min	min		°C	°C/min	hPa
Neutral paste	575	7:00	1:00	1:00	4:00	0:00	0	900	55	50
Paste opaque	575	7:00	1:00	1:00	4:00	0:00	0	900	55	50
Powder opaque	575	4:00	1:00	1:00	4:00	0:00	0	900	55	50
Shoulder 1 + 2	575	5:00	2:00	1:00	2:00	0:00	0	920	55	50
Dentine 1	575	5:00	2:00	1:00	2:00	3:00	0	910	55	50
Dentine 2	575	4:00	2:00	1:00	2:00	3:00	0	900	55	50
Glaze	575	3:00	1:00	0:00	1:00	3:00	0	890	55	–
Correction (Final Kiss)	575	3:00	1:00	1:00	2:00	3:00	0	880	55	50
Final Shoulder (F SM)	450	3:00	2:00	1:00	2:00	0:00	0	660	55	50

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Multimat MC II non-precious alloys, Compartis

	Pre-heating	Drying	Pre-heating	Vacuum	Firing	Tempering	Cooling	Firing	Heating	Vacuum
	°C	min	min	min/temp.	min	min		°C	°C/min	hPa
NE-Bonder Paste	575	7:00	1:00	1:00	3:00	0:00	0	980	55	50
NE-Bonder Powder	575	4:00	1:00	1:00	3:00	0:00	0	980	55	50
Paste opaque 2	575	7:00	1:00	1:00	3:00	0:00	0	950	55	50
Powder opaque 2	575	4:00	1:00	1:00	3:00	0:00	0	950	55	50
Shoulder 1 + 2	575	5:00	2:00	1:00	2:00	0:00	0	930	55	50
Dentine 1	575	5:00	2:00	1:00	2:00	3:00	1	920	55	50
Dentine 2	575	4:00	2:00	1:00	2:00	3:00	1	910	55	50
Glaze	575	3:00	1:00	0:00	1:00	3:00	1	890	55	-
Correction (Final Kiss)	575	3:00	1:00	1:00	2:00	3:00	1	880	55	50
Final Shoulder (F SM)	450	3:00	2:00	1:00	2:00	0:00	0	660	55	50

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



StratoPress conventional alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Dry Pos	Dry	Close	Lo Temp	Heat	Rate	Hi Temp	Vac 0 %	Vac Off	Hold + V	Hold V	Temper	Cool	
	0 – 9	min	min	°C	min	°C/min	°C	%	°C	min	min	min	°C	min
Paste opaque 2	9	4:00	2:00	575	1:00	55	930	100	930	0:00	3:00	0:00	0	0:00
Powder opaque 2	9	2:00	2:00	575	1:00	55	930	100	930	0:00	3:00	0:00	0	0:00
Shoulder 1 + 2	9	2:00	2:00	575	2:00	55	920	100	920	0:00	1:00	0:00	0	0:00
Dentine 1	9	1:00	3:00	575	2:00	55	910	100	910	0:00	1:00	0:00	0	0:00
Dentine 2	9	1:00	2:00	575	2:00	55	900	100	900	0:00	1:00	0:00	0	0:00
Glaze	9	1:00	2:00	575	1:00	55	890	0	0	0:00	1:00	0:00	0	0:00
Correction (Final Kiss)	9	1:00	1:00	575	1:00	55	880	100	880	0:00	1:00	0:00	0	0:00
Final Shoulder (F SM)	9	1:00	2:00	450	1:00	55	660	100	660	0:00	1:00	0:00	0	0:00

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Duceram® Kiss – Specific firing recommendations



StratoPress conventional alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Dry Pos	Dry	Close	Lo Temp	Heat	Rate	Hi Temp	Vac 0 %	Vac Off	Hold + V	Hold V	Temper	Cool	
	0 – 9	min	min	°C	min	°C/min	°C	%	°C	min	min	min	°C	min
Paste opaque 2	9	4:00	2:00	575	1:00	55	930	100	930	0:00	3:00	0:00	0	0:00
Powder opaque 2	9	2:00	2:00	575	1:00	55	930	100	930	0:00	3:00	0:00	0	0:00
Shoulder 1 + 2	9	2:00	2:00	575	2:00	55	920	100	920	0:00	1:00	0:00	0	0:00
Dentine 1	9	1:00	3:00	575	2:00	55	910	100	910	0:00	1:00	3:00	850	0:00
Dentine 2	9	1:00	2:00	575	2:00	55	900	100	900	0:00	1:00	3:00	850	0:00
Glaze	9	1:00	2:00	575	1:00	55	890	0	0	0:00	1:00	3:00	850	0:00
Correction (Final Kiss)	9	1:00	1:00	575	1:00	55	880	100	880	0:00	1:00	3:00	850	0:00
Final Shoulder (F SM)	9	1:00	2:00	450	1:00	55	660	100	660	0:00	1:00	0:00	0	0:00

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Duceram® Kiss – Specific firing recommendations



StratoPress bio-alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Dry Pos	Dry	Close	Lo Temp	Heat	Rate	Hi Temp	Vac 0 %	Vac Off	Hold + V	Hold V	Temper	Cool	
	0 – 9	min	min	°C	min	°C/min	°C	%	°C	min	min	min	°C	min
Neutral paste	9	4:00	2:00	575	1:00	55	900	100	900	0:00	3:00	0:00	0	0:00
Paste opaque 2	9	4:00	2:00	575	1:00	55	900	100	900	0:00	3:00	0:00	0	0:00
Powder opaque 2	9	2:00	2:00	575	1:00	55	900	100	900	0:00	3:00	0:00	0	0:00
Shoulder 1 + 2	9	2:00	2:00	575	2:00	55	920	100	920	0:00	1:00	0:00	0	0:00
Dentine 1	9	1:00	3:00	575	2:00	55	910	100	910	0:00	1:00	0:00	0	0:00
Dentine 2	9	1:00	2:00	575	2:00	55	900	100	900	0:00	1:00	0:00	0	0:00
Glaze	9	1:00	2:00	575	1:00	55	890	0	0	0:00	1:00	0:00	0	0:00
Correction (Final Kiss)	9	1:00	1:00	575	1:00	55	880	100	880	0:00	1:00	0:00	0	0:00
Final Shoulder (F SM)	9	1:00	2:00	450	1:00	55	660	100	660	0:00	1:00	0:00	0	0:00

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Duceram® Kiss – Specific firing recommendations



StratoPress bio-alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Dry Pos	Dry	Close	Lo Temp	Heat	Rate	Hi Temp	Vac 0 %	Vac Off	Hold + V	Hold V	Temper	Cool	
	0 – 9	min	min	°C	min	°C/min	°C	%	°C	min	min	min	°C	min
Neutral paste	9	4:00	2:00	575	1:00	55	900	100	900	0:00	3:00	0:00	0	0:00
Paste opaque 2	9	4:00	2:00	575	1:00	55	900	100	900	0:00	3:00	0:00	0	0:00
Powder opaque 2	9	2:00	2:00	575	1:00	55	900	100	900	0:00	3:00	0:00	0	0:00
Shoulder 1 + 2	9	2:00	2:00	575	2:00	55	920	100	920	0:00	1:00	0:00	0	0:00
Dentine 1	9	1:00	3:00	575	2:00	55	910	100	910	0:00	1:00	3:00	850	0:00
Dentine 2	9	1:00	2:00	575	2:00	55	900	100	900	0:00	1:00	3:00	850	0:00
Glaze	9	1:00	2:00	575	1:00	55	890	0	0	0:00	1:00	3:00	850	0:00
Correction (Final Kiss)	9	1:00	1:00	575	1:00	55	880	100	880	0:00	1:00	3:00	850	0:00
Final Shoulder (F SM)	9	1:00	2:00	450	1:00	55	660	100	660	0:00	1:00	0:00	0	0:00

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Duceram® Kiss – Specific firing recommendations



StratoPress Non-precious alloys, Compartis

	Dry Pos	Dry	Close	Lo Temp	Heat	Rate	Hi Temp	Vac 0 %	Vac Off	Hold + V	Hold V	Temper	Cool	
	0 – 9	min	min	°C	min	°C/min	°C	%	°C	min	min	min	°C	min
NE-Bonder (paste)	9	4:00	2:00	575	1:00	55	980	100	980	0:00	2:00	0:00	0	0:00
NE-Bonder (powder)	9	2:00	2:00	575	1:00	55	980	100	980	0:00	2:00	0:00	0	0:00
Paste opaque 2	9	4:00	2:00	575	1:00	55	950	100	950	0:00	3:00	0:00	0	0:00
Powder opaque 2	9	2:00	2:00	575	1:00	55	950	100	950	0:00	3:00	0:00	0	0:00
Shoulder 1 + 2	9	2:00	2:00	575	2:00	55	930	100	930	0:00	1:00	0:00	0	0:00
Dentine 1	9	1:00	3:00	575	2:00	55	920	100	920	0:00	1:00	3:00	850	6:00
Dentine 2	9	1:00	2:00	575	2:00	55	910	100	910	0:00	1:00	3:00	850	6:00
Glaze	9	1:00	2:00	575	1:00	55	890	0	0	0:00	1:00	3:00	850	6:00
Correction (Final Kiss)	9	1:00	1:00	575	1:00	55	880	100	880	0:00	1:00	3:00	850	6:00
Final Shoulder (F SM)	9	1:00	2:00	450	1:00	55	660	100	660	0:00	1:00	0:00	0	0:00

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Duceram® Kiss – Specific firing recommendations



Austromat 3001 conventional alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

Paste opaque 1+2	C575 T360 T120 · L9 V9 T055 · C930 V0 T120 C0 L0 T2 C575
Powder opaque 1+2	C575 T120 T180 · L9 V9 T055 · C930 V0 T120 C0 L0 T2 C575
Shoulder 1+2	C575 T180 T180 · L9 T120 V9 T055 · C920 V0 T60 C0 L0 T2 C575
Dentine 1	C575 T120 T180 · L9 T120 V9 T055 · C910 V0 T60 C0 L0 T2 C575
Dentine 2	C575 T120 T180 · L9 T60 V9 T055 · C900 V0 T60 C0 L0 T2 C575
Glaze	C575 T120 T120 · L9 T055 · C890 T60 C0 L0 T2 C575
Correction (Final Kiss)	C575 T60 T120 · L9 T120 V9 T055 · C880 V0 T60 C0 L0 T2 C575
Final Shoulder (F SM)	C450 T60 T120 · L9 T120 V9 T055 · C660 V0 T60 C0 L0 T2 C450

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Duceram® Kiss – Specific firing recommendations



Austromat 3001 conventional alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

Paste opaque 1+2	C575 T360 T120 · L9 V9 T055 · C930 V0 T120 C0 L0 T2 C575
Powder opaque 1+2	C575 T120 T180 · L9 V9 T055 · C930 V0 T120 C0 L0 T2 C575
Shoulder 1+2	C575 T180 T180 · L9 T120 V9 T055 · C920 V0 T60 C0 L0 T2 C575
Dentine 1	C575 T120 T180 · L9 T120 V9 T055 · C910 V0 T60 C0 L7 C850 L9 T180 L0 T2 C575
Dentine 2	C575 T120 T180 · L9 T60 V9 T055 · C900 V0 T60 C0 L7 C850 L9 T180 L0 T2 C575
Glaze	C575 T120 T120 · L9 T055 · C890 T60 C0 L7 C850 L9 T180 L0 T2 C575
Correction (Final Kiss)	C575 T60 T120 · L9 T120 V9 T055 · C880 V0 T60 C0 L7 C850 L9 T180 L0 T2 C575
Final Shoulder (F SM)	C450 T60 T120 · L9 T120 V9 T055 · C660 V0 T60 C0 L0 T2 C450

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Duceram® Kiss – Specific firing recommendations



Austramat 3001 bio-alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

Neutral paste	C575 T360 T120 · L9 V9 T055 · C900 V0 T180 C0 L0 T2 C575
Paste opaque	C575 T360 T120 · L9 V9 T055 · C900 V0 T180 C0 L0 T2 C575
Powder opaque	C575 T120 T180 · L9 V9 T055 · C900 V0 T180 C0 L0 T2 C575
Shoulder 1+2	C575 T180 T180 · L9 T120 V9 T055 · C920 V0 T60 C0 L0 T2 C575
Dentine 1	C575 T120 T180 · L9 T120 V9 T055 · C910 V0 T60 C0 L0 T2 C575
Dentine 2	C575 T120 T180 · L9 T60 V9 T055 · C900 V0 T60 C0 L0 T2 C575
Glaze	C575 T120 T120 · L9 T055 · C890 T60 C0 L0 T2 C575
Correction (Final Kiss)	C575 T60 T120 · L9 T120 V9 T055 · C880 V0 T60 C0 L0 T2 C575
Final Shoulder (F SM)	C450 T60 T120 · L9 T120 V9 T055 · C660 V0 T60 C0 L0 T2 C450

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Duceram® Kiss – Specific firing recommendations



Austramat 3001 bio-alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

Neutral paste	C575 T360 T120 · L9 V9 T055 · C900 V0 T180 C0 L0 T2 C575
Paste opaque	C575 T360 T120 · L9 V9 T055 · C900 V0 T180 C0 L0 T2 C575
Powder opaque	C575 T120 T180 · L9 V9 T055 · C900 V0 T180 C0 L0 T2 C575
Shoulder 1+2	C575 T180 T180 · L9 T120 V9 T055 · C920 V0 T60 C0 L0 T2 C575
Dentine 1	C575 T120 T180 · L9 T120 V9 T055 · C910 V0 T60 C0 L7 C850 L9 T180 L0 T2 C575
Dentine 2	C575 T120 T180 · L9 T60 V9 T055 · C900 V0 T60 C0 L7 C850 L9 T180 L0 T2 C575
Glaze	C575 T120 T120 · L9 T055 · C890 T60 C0 L7 C850 L9 T180 L0 T2 C575
Correction (Final Kiss)	C575 T60 T120 · L9 T120 V9 T055 · C880 V0 T60 C0 L7 C850 L9 T180 L0 T2 C575
Final Shoulder (F SM)	C450 T60 T120 · L9 T120 V9 T055 · C660 V0 T60 C0 L0 T2 C450

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Duceram® Kiss – Specific firing recommendations



Austramat 3001 non-precious alloys, Compartis

NE- Bonder	
Paste	C575 T360 T120 · L9 T60 V9 T055 · C980 V0 T180 C0 L0 T2 C575
Powder	C575 T120 T180 · L9 T60 V9 T055 · C980 V0 T120 C0 L0 T2 C575
Paste opaque	C575 T360 T120 · L9 T60 V9 T055 · C950 V0 T120 C0 L0 T2 C575
Powder opaque	C575 T240 T120 · L9 T60 V9 T055 · C950 V0 T120 C0 L0 T2 C575
Shoulder 1+2	C575 T180 T180 · L9 T120 V9 T055 · C930 V0 T60 C0 L0 T2 C575
Dentine 1	C575 T120 T180 · L9 T120 V9 T055 · C920 V0 T60 C0 L7 C850 L9 T180 C0 T360 · L0 T2 C575
Dentine 2	C575 T120 T180 · L9 T60 V9 T055 · C910 V0 T60 C0 L7 C850 L9 T180 C0 T360 · L0 T2 C575
Glaze	C575 T120 T120 · L9 T055 · C890 T60 C0 L7 C850 L9 T180 C0 T360 · L0 T2 C575
Correction (Final Kiss)	C575 T60 T120 · L9 T120 V9 T055 · C880 V0 T60 C0 L7 C850 L9 T180 C0 T360 · L0 T2 C575
Final Shoulder (F SM)	C450 T60 T120 · L9 T120 V9 T055 · C660 V0 T60 C0 L0 T2 C450

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Duceram® Kiss – Specific firing recommendations



Programat P300 conventional alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

Program number	Standby temperature	Closing time min:s	Temperature gradient t†	Holding temperature	Holding time min:s	Vacuum on	Vacuum off	Long-term cooling
P	B	S	min	T	H	V1	V2	L
Paste opaque	400	9:00	55	930	2:00	500	929	0
Powder opaque	400	7:00	55	930	2:00	500	929	0
Shoulder 1 + 2	400	6:00	55	920	1:00	500	919	0
Dentine 1	400	7:00	55	910	1:00	500	909	0
Dentine 2	400	6:00	55	900	1:00	500	899	0
Glaze	400	4:00	55	890	1:00	0	0	0
Correction (Final Kiss)	400	4:00	55	880	1:00	500	879	0
Final Shoulder (F SM)	400	4:00	55	660	1:00	450	659	0

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Duceram® Kiss – Specific firing recommendations



Programat P300 conventional alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

Program number	Standby temperature	Closing time min:s	Temperature gradient t†	Holding temperature	Holding time min:s	Vacuum on	Vacuum off	Long-term cooling
P	B	S	min	T	H	V1	V2	L
Paste opaque 1 + 2	400	9:00	55	930	2:00	500	929	0
Powder opaque 1 + 2	400	7:00	55	930	2:00	500	929	0
Shoulder 1 + 2	400	6:00	55	920	1:00	500	919	0
Dentine 1	400	7:00	55	910	1:00	500	909	600
Dentine 2	400	6:00	55	900	1:00	500	899	600
Glaze	400	4:00	55	890	1:00	0	0	600
Correction (Final Kiss)	400	4:00	55	880	1:00	500	879	600
Final Shoulder (F SM)	400	4:00	55	660	1:00	450	659	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

Please observe the instruction of Duceram Kiss. There you will find information on the intended use, contraindications, warnings, cautions and technical data.



Duceram® Kiss – Specific firing recommendations



Programat P300 bio-alloys, CTE 13,8 to 14,4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Program number	Standby temperature	Closing time min:s	Temperature gradient t†	Holding temperature	Holding time min:s	Vacuum on	Vacuum off	Long-term cooling
	P	B	S	min	T	H	V1	V2	L
Neutral paste		400	9:00	55	900	3:00	500	899	0
Paste opaque		400	9:00	55	900	3:00	500	899	0
Powder opaque		400	7:00	55	900	3:00	500	899	0
Shoulder 1+ 2		400	6:00	55	920	1:00	500	919	0
Dentine 1		400	7:00	55	910	1:00	500	909	0
Dentine 2		400	6:00	55	900	1:00	500	899	0
Glaze		400	4:00	55	890	1:00	0	0	0
Correction (Final Kiss)		400	4:00	55	880	1:00	500	879	0
Final Shoulder (F SM)		400	4:00	55	660	1:00	450	659	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Programat P300 bio-alloys, CTE from $14,5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Program number	Standby temperature	Closing time min:s	Temperature gradient t†	Holding temperature	Holding time min:s	Vacuum on	Vacuum off	Long-term cooling
	P	B	S	min	T	H	V1	V2	L
Neutral paste		400	9:00	55	900	3:00	500	899	0
Paste opaque		400	9:00	55	900	3:00	500	899	0
Powder opaque		400	7:00	55	900	3:00	500	899	0
Shoulder 1+ 2		400	6:00	55	920	1:00	500	919	0
Dentine 1		400	7:00	55	910	1:00	500	909	600
Dentine 2		400	6:00	55	900	1:00	500	899	600
Glaze		400	4:00	55	890	1:00	0	0	600
Correction (Final Kiss)		400	4:00	55	880	1:00	500	879	600
Final Shoulder (F SM)		400	4:00	55	660	1:00	450	659	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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Duceram® Kiss – Specific firing recommendations



Programat P300 non-precious alloys, Compartis

Program number	Standby temperature	Closing time min:s	Temperature gradient t† min	Holding temperature T	Holding time min:s H	Vacuum on V1	Vacuum off V2	Long-term cooling L
P	B	S	min	T	H	V1	V2	L
NE-Bonder Paste	400	9:00	55	980	2:00	500	979	0
NE-Bonder Powder	400	7:00	55	980	2:00	500	979	0
Paste opaque 2	400	9:00	55	950	2:00	500	949	0
Powder opaque 2	400	7:00	55	950	2:00	500	949	0
Shoulder 1 + 2	400	6:00	55	930	1:00	500	929	0
Dentine 1	400	7:00	55	920	1:00	500	919	600
Dentine 2	400	6:00	55	910	1:00	500	909	600
Glaze	400	4:00	55	890	1:00	0	0	600
Correction (Final Kiss)	400	4:00	55	880	1:00	500	879	600
Final Shoulder (F SM)	400	4:00	55	660	1:00	450	659	0

The values listed here are intended for orientation only and should be regarded only as guidelines. Actual firing results may vary. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. The guideline values therefore need to be adapted individually for each firing. We recommend a test firing cycle to check the performance of the furnace. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

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