

Duceram® Kiss – Firing recommendations



Austromat D4 Conventional alloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Program type	Standby temp.	Drying	Closing	Pre-heating		Firing temp. 1 st Temperature			2 nd tempera- ture	3 rd tempera- ture	VAC off / level / hold		
					°C	min	min	°C	min	°C	°C / min	min	°C min	°C min
Paste opaque	Professional	575	4:00	2:00	575	1:00	930	55	2:00	0	0	930	100	0
Powder opaque		575	2:00	2:00	575	1:00	930	55	2:00	0	0	930	100	0
Shoulder 1 + 2		575	2:00	2:00	575	2:00	920	55	1:00	0	0	920	100	0
Dentine 1		575	1:00	3:00	575	2:00	910	55	1:00	850 3:00	0	910	100	0
Dentine 2		575	1:00	2:00	575	2:00	900	55	1:00	850 3:00	0	900	100	0
Glaze		575	1:00	2:00	575	1:00	890	55	1:00	850 3:00	0	0	0	0
Correction (Final Kiss)		575	1:00	1:00	575	1:00	880	55	1:00	850 3:00	0	880	100	0
Final Shoulder (F SM)		450	1:00	2:00	450	1:00	660	55	1:00	0	0	660	100	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.

Make sure to follow the Instructions for Use for Duceram® Kiss, where you will find information on indications, contraindications, warnings, precautions and technical specifications.



www.kiss-keramik.de

DeguDent GmbH - Rodenbacher Chaussee 4 - 63457 Hanau

DeguDent
A Dentsply Company

Duceram® Kiss – Firing recommendations



Austromat D4 Conventional alloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Program type	Standby temp.	Drying	Closing	Pre-heating	Firing temp.			Cooling	Stress relief	VAC		
		°C	min	min	°C	min	°C	°C / min	min	°C min	°C min	level	hold
												%	min
Paste opaque	Standard	575	4:00	2:00	575	1:00	930	55	2:00	0	0	100	0
Powder opaque		575	2:00	2:00	575	1:00	930	55	2:00	0	0	100	0
Shoulder 1 + 2		575	2:00	2:00	575	2:00	920	55	1:00	0	0	100	0
Dentine 1		575	1:00	3:00	575	2:00	910	55	1:00	0	0	100	0
Dentine 2		575	1:00	2:00	575	2:00	900	55	1:00	0	6	100	0
Glaze		575	1:00	2:00	575	1:00	890	55	1:00	0	6	0	0
Correction (Final Kiss)		575	1:00	1:00	575	1:00	880	55	1:00	0	0	100	0
Final Shoulder (F SM)		450	1:00	2:00	450	1:00	660	55	1:00	0	0	100	0

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Austromat D4 Non-precious alloys, Crypton, Compartis

	Program type	Standby temp.	Drying	Closing	Pre-heating		Firing temp.			Cooling	Stress relief	VAC	
					°C	min	°C	min	°C			°C / min	min
		°C	min	min	°C	min	°C	°C / min	min	°C min	°C min	%	min
NE-Bonder (paste)	Standard	575	4:00	2:00	575	1:00	980	55	2:00	0	0	100	0
NE-Bonder (powder)		575	2:00	2:00	575	1:00	980	55	1:00	0	0	100	0
Paste opaque		575	4:00	2:00	575	1:00	950	55	2:00	0	0	100	0
Powder opaque		575	2:00	2:00	575	1:00	950	55	2:00	0	0	100	0
Shoulder 1 + 2		575	2:00	2:00	575	2:00	930	55	1:00	0	0	100	0
Dentine 1		575	1:00	3:00	575	2:00	920	55	1:00	3	6	100	0
Dentine 2		575	1:00	2:00	575	2:00	910	55	1:00	3	6	100	0
Glaze		575	1:00	2:00	575	1:00	890	55	1:00	3	6	0	0
Correction (Final Kiss)		575	1:00	1:00	575	1:00	880	55	1:00	3	6	100	0
Final Shoulder (F SM)		450	1:00	2:00	450	1:00	660	55	1:00	0	0	100	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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Austromat D4 Bioalloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600°C)

	Program type	Standby temp.	Drying	Closing	Pre-heating		Firing temp. 1 st Temperature			2 nd temperature	3 rd temperature	VAC off / level / hold		
		°C	min	min	°C	min	°C	°C / min	min	°C min	°C min	°C	%	min
Neutral paste	Professional	575	4:00	2:00	575	1:00	900	55	3:00	0	0	900	100	0
Paste opaque		575	4:00	2:00	575	1:00	900	55	3:00	0	0	900	100	0
Powder opaque		575	2:00	2:00	575	1:00	900	55	3:00	0	0	900	100	0
Shoulder 1+2		575	2:00	2:00	575	2:00	920	55	1:00	0	0	920	100	0
Dentine 1		575	1:00	3:00	575	2:00	910	55	1:00	850 3:00	0	910	100	0
Dentine 2		575	1:00	2:00	575	2:00	900	55	1:00	850 3:00	0	900	100	0
Glaze		575	1:00	2:00	575	1:00	890	55	1:00	850 3:00	0	0	0	0
Correction (Final Kiss)		575	1:00	1:00	575	1:00	880	55	1:00	850 3:00	0	880	100	0
Final Shoulder (F SM)		450	1:00	2:00	450	1:00	660	55	1:00	0	0	660	100	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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Austromat D4 Bioalloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Program type	Standby temp.	Drying	Closing	Pre-heating		Firing temp.			Cooling	Stress relief	VAC	
					°C	min	°C	min	°C			°C / min	min
		°C	min	min	°C	min	°C	°C / min	min	°C min	°C min	%	min
Neutral paste	Standard	575	4:00	2:00	575	1:00	900	55	3:00	0	0	100	0
Paste opaque		575	4:00	2:00	575	1:00	900	55	3:00	0	0	100	0
Powder opaque		575	2:00	2:00	575	1:00	900	55	3:00	0	0	100	0
Shoulder 1 + 2		575	2:00	2:00	575	2:00	920	55	1:00	0	0	100	0
Dentine 1		575	1:00	3:00	575	2:00	910	55	1:00	0	0	100	0
Dentine 2		575	1:00	2:00	575	2:00	900	55	1:00	0	0	100	0
Glaze		575	1:00	2:00	575	1:00	890	55	1:00	0	0	0	0
Correction (Final Kiss)		575	1:00	1:00	575	1:00	880	55	1:00	0	0	100	0
Final Shoulder (F SM)		450	1:00	2:00	450	1:00	660	55	1:00	0	0	100	0

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Programat EP5000 Conventional alloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Closing time min:s	Temperature gradient °C	Holding temp. °C	Holding time min:s	Vacuum On	Vacuum Off	One-step program	Pre-vacuum	Long-term cooling °C	Cooling gradient	Standby temp. °C
	S	t↑	T	H	V1	V2		-	L	t↓	B
Paste opaque	7:00	55	930	2:00	450	929	Yes	-	0	0	450
Powder opaque	5:00	55	930	2:00	450	929	Yes	-	0	0	450
Shoulder 1+2	6:00	55	920	1:00	450	919	Yes	-	0	0	400
Dentine 1	6:00	55	910	1:00	450	909	Yes	-	680	30	400
Dentine 2	5:00	55	900	1:00	450	899	Yes	-	680	30	400
Glaze	4:00	55	890	1:00	0	0	Yes	-	680	30	400
Correction (Final Kiss)	3:00	55	880	1:00	450	879	Yes	-	680	30	400
Final Shoulder (F SM)	4:00	55	660	1:00	450	659	Yes	-	0	0	400

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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	Closing time min:s	Temperature gradient °C	Holding temp. °C	Holding time min:s	Vacuum On	Vacuum Off	One-step program	Pre-vacuum	Long-term cooling °C	Cooling gradient	Standby temp. °C
	S	t↑	T	H	V1	V2		-	L	t↓	B
Paste opaque	7:00	55	930	2:00	450	929	Yes	-	0	0	450
Powder opaque	5:00	55	930	2:00	450	929	Yes	-	0	0	450
Shoulder 1+2	6:00	55	920	1:00	450	919	Yes	-	0	0	400
Dentine 1	6:00	55	910	1:00	450	909	Yes	-	0	0	400
Dentine 2	5:00	55	900	1:00	450	899	Yes	-	0	0	400
Glaze	4:00	55	890	1:00	0	0	Yes	-	0	0	400
Correction (Final Kiss)	3:00	55	880	1:00	450	879	Yes	-	0	0	400
Final Shoulder (F SM)	4:00	55	660	1:00	450	659	Yes	-	0	0	400

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	Closing time min:s	Temperature gradient °C	Holding temp. °C	Holding time min:s	Vacuum On	Vacuum Off	One-step program	Pre-vacuum	Long-term cooling °C	Cooling gradient	Standby temp. °C
	S	t↑	T	H	V1	V2			L	t↓	B
Neutral paste	7:00	55	900	3:00	450	899	Yes	–	0	0	450
Paste opaque	7:00	55	900	3:00	450	899	Yes	–	0	0	450
Powder opaque	5:00	55	900	3:00	450	899	Yes	–	0	0	450
Shoulder 1+2	6:00	55	920	1:00	450	919	Yes	–	0	0	400
Dentine 1	6:00	55	910	1:00	450	909	Yes	–	680	30	400
Dentine 2	5:00	55	900	1:00	450	899	Yes	–	680	30	400
Glaze	4:00	55	890	1:00	0	0	Yes	–	680	30	400
Correction (Final Kiss)	3:00	55	880	1:00	450	879	Yes	–	680	30	400
Final Shoulder (F SM)	4:00	55	660	1:00	450	659	Yes	–	0	0	400

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	Closing time min:s	Temperature gradient °C	Holding temp. °C	Holding time min:s	Vacuum On	Vacuum Off	One-step program	Pre-vacuum	Long-term cooling °C	Cooling gradient	Standby temp. °C
	S	t↑	T	H	V1	V2			L	t↓	B
Neutral paste	7:00	55	900	3:00	450	899	Yes	–	0	0	450
Paste opaque	7:00	55	900	3:00	450	899	Yes	–	0	0	450
Powder opaque	5:00	55	900	3:00	450	899	Yes	–	0	0	450
Shoulder 1+2	6:00	55	920	1:00	450	919	Yes	–	0	0	400
Dentine 1	6:00	55	910	1:00	450	909	Yes	–	0	0	400
Dentine 2	5:00	55	900	1:00	450	899	Yes	–	0	0	400
Glaze	4:00	55	890	1:00	0	0	Yes	–	0	0	400
Correction (Final Kiss)	3:00	55	880	1:00	450	879	Yes	–	0	0	400
Final Shoulder (F SM)	4:00	55	660	1:00	450	659	Yes	–	0	0	400

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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Programat EP5000 Non-precious alloys, Crypton, Compartis

	Closing time min:s	Temperature gradient °C	Holding temp. °C	Holding time min:s	Vacuum On	Vacuum Off	One-step program	Pre-vacuum	Long-term cooling °C	Cooling gradient	Standby temp. °C
	S	t↑	T	H	V1	V2			L	t↓	B
NE-Bonder (paste)	7:00	55	980	2:00	450	979	Yes	–	0	0	450
NE-Bonder (powder)	5:00	55	980	1:00	450	979	Yes	–	0	0	450
Paste opaque	7:00	55	950	2:00	450	949	Yes	–	0	0	450
Powder opaque	5:00	55	950	2:00	450	949	Yes	–	0	0	450
Shoulder 1 + 2	6:00	55	930	1:00	450	929	Yes	–	0	0	400
Dentine 1	6:00	55	920	1:00	450	919	Yes	–	575	30	400
Dentine 2	5:00	55	910	1:00	450	909	Yes	–	575	30	400
Glaze	4:00	55	890	1:00	0	0	Yes	–	575	30	400
Correction (Final Kiss)	3:00	55	880	1:00	450	879	Yes	–	575	30	400
Final Shoulder (F SM)	4:00	55	660	1:00	450	659	Yes	–	0	0	400

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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Austromat M Non-precious alloys, Crypton, Compartis

	Start		↑	→	VAC Level		END	→	1 ↘	2 ↘
	Starting temp.	Drying time	Closing time	Pre-heating	Vacuum level	Increase Linear	Final temp.	Holding time (V)	1 st cooling stage	2 nd cooling stage
	°C	min	min	min		°C / min	°C	min		
NE-Bonder (paste)	575	4:00	2:00	1:00	9	55	980	2:00	0	0
NE-Bonder (powder)	575	2:00	2:00	1:00	9	55	980	1:00	0	0
Paste opaque	575	4:00	2:00	1:00	9	55	950	2:00	0	0
Powder opaque	575	2:00	2:00	1:00	9	55	950	2:00	0	0
Shoulder 1+2	575	2:00	2:00	2:00	9	55	930	1:00	0	0
Dentine 1	575	1:00	3:00	2:00	9	55	920	1:00	3	6
Dentine 2	575	1:00	2:00	2:00	9	55	910	1:00	3	6
Glaze	575	1:00	2:00	1:00	0	55	890	1:00	3	6
Correction (Final Kiss)	575	1:00	1:00	1:00	9	55	880	1:00	3	6
Final Shoulder (F SM)	450	1:00	2:00	1:00	9	55	660	1:00	0	0

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	Start		↑	→	VAC Level		END	→	1 ↘	2 ↘
	Starting temp.	Drying time	Closing time	Pre-heating	Vacuum level	Increase Linear	Final temp.	Holding time (V)	1 st cooling stage	2 nd cooling stage
	°C	min	min	min		°C / min	°C	min		
Paste opaque	575	4:00	2:00	1:00	9	55	930	2:00	0	0
Powder opaque	575	2:00	2:00	1:00	9	55	930	2:00	0	0
Shoulder 1+2	575	2:00	2:00	2:00	9	55	920	1:00	0	0
Dentine 1	575	1:00	3:00	2:00	9	55	910	1:00	3	0
Dentine 2	575	1:00	2:00	2:00	9	55	900	1:00	3	0
Glaze	575	1:00	2:00	1:00	0	55	890	1:00	3	0
Correction (Final Kiss)	575	1:00	1:00	1:00	9	55	880	1:00	3	0
Final Shoulder (F SM)	450	1:00	2:00	1:00	9	55	660	1:00	0	0

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Austromat M Conventional alloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Start		↑	→	VAC Level		END	→	1 ↘	2 ↘
	Starting temp.	Drying time	Closing time	Pre-heating	Vacuum level	Increase Linear	Final temp.	Holding time (V)	1 st cooling stage	2 nd cooling stage
	°C	min	min	min		°C / min	°C	min		
Paste opaque	575	4:00	2:00	1:00	9	55	930	2:00	0	0
Powder opaque	575	2:00	2:00	1:00	9	55	930	2:00	0	0
Shoulder 1+2	575	2:00	2:00	2:00	9	55	920	1:00	0	0
Dentine 1	575	1:00	3:00	2:00	9	55	910	1:00	0	0
Dentine 2	575	1:00	2:00	2:00	9	55	900	1:00	0	0
Glaze	575	1:00	2:00	1:00	0	55	890	1:00	0	0
Correction (Final Kiss)	575	1:00	1:00	1:00	9	55	880	1:00	0	0
Final Shoulder (F SM)	450	1:00	2:00	1:00	9	55	660	1:00	0	0

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Make sure to follow the Instructions for Use for Duceram® Kiss, where you will find information on indications, contraindications, warnings, precautions and technical specifications.



www.kiss-keramik.de

DeguDent GmbH - Rodenbacher Chaussee 4 - 63457 Hanau

DeguDent
A Dentsply Company

Duceram® Kiss – Firing recommendations



Austromat M Bioalloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Start		↑	→	VAC Level		END	→	1 ↘	2 ↘
	Starting temp.	Drying time	Closing time	Pre-heating	Vacuum level	Increase Linear	Final temp.	Holding time (V)	1 st cooling stage	2 nd cooling stage
	°C	min	min	min		°C / min	°C	min		
Neutral paste	575	4:00	2:00	1:00	9	55	900	3:00	0	0
Paste opaque	575	4:00	2:00	1:00	9	55	900	3:00	0	0
Powder opaque	575	2:00	2:00	1:00	9	55	900	3:00	0	0
Shoulder 1+2	575	2:00	2:00	2:00	9	55	920	1:00	0	0
Dentine 1	575	1:00	3:00	2:00	9	55	910	1:00	3	0
Dentine 2	575	1:00	2:00	2:00	9	55	900	1:00	3	0
Glaze	575	1:00	2:00	1:00	0	55	890	1:00	3	0
Correction (Final Kiss)	575	1:00	1:00	1:00	9	55	880	1:00	3	0
Final Shoulder (F SM)	450	1:00	2:00	1:00	9	55	660	1:00	0	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 – Firing recommendations



Austromat M Bialloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Start		↑	→	VAC Level		END	→	1 ↘	2 ↘
	Starting temp.	Drying time	Closing time	Pre-heating	Vacuum level	Increase Linear	Final temp.	Holding time (V)	1 st cooling stage	2 nd cooling stage
	°C	min	min	min		°C / min	°C	min		
Neutral paste	575	4:00	2:00	1:00	9	55	900	3:00	0	0
Paste opaque	575	4:00	2:00	1:00	9	55	900	3:00	0	0
Powder opaque	575	2:00	2:00	1:00	9	55	900	3:00	0	0
Shoulder 1 + 2	575	2:00	2:00	2:00	9	55	920	1:00	0	0
Dentine 1	575	1:00	3:00	2:00	9	55	910	1:00	0	0
Dentine 2	575	1:00	2:00	2:00	9	55	900	1:00	0	0
Glaze	575	1:00	2:00	1:00	0	55	890	1:00	0	0
Correction (Final Kiss)	575	1:00	1:00	1:00	9	55	880	1:00	0	0
Final Shoulder (F SM)	450	1:00	2:00	1:00	9	55	660	1:00	0	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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Zubler Vario Press 300 Non-precious alloys, Crypton, Compartis

	Program type	Starting temp.	Pre-drying	Pre-drying time	Closing time	Homogenizing temp.	Homogenizing time	Heating rate	Final temp.	Holding time	Tempering °C / min	Opening temp.	Opening time	Vacuum	Vacuum release	Vacuum end	
	Professional	NE-Bonder (paste)	575	Yes	4:00	3:00	575	0:30	55	980	2:00	No	980	0:00	Yes	Heating	980
		NE-Bonder (powder)	575	Yes	2:00	3:00	575	0:30	55	980	1:00	No	980	0:00	Yes	Heating	980
		Paste opaque	575	Yes	4:00	3:00	575	0:30	55	950	2:00	No	950	0:00	Yes	Heating	950
		Powder opaque	575	Yes	2:00	3:00	575	0:30	55	950	2:00	No	950	0:00	Yes	Heating	950
		Shoulder 1+2	575	Yes	2:00	4:00	575	0:30	55	930	1:00	No	930	0:00	Yes	Heating	930
		Dentine 1	575	Yes	1:00	5:00	575	0:30	55	920	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	575	6:00	Yes	Heating	920
		Dentine 2	575	Yes	1:00	4:00	575	0:30	55	910	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	575	6:00	Yes	Heating	910
		Glaze	575	Yes	1:00	3:00	575	0:30	55	890	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	575	6:00	No	Heating	0
		Correction (Final Kiss)	575	Yes	1:00	2:00	575	0:30	55	880	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	575	6:00	Yes	Heating	880
		Final Shoulder (F SM)	450	Yes	1:00	3:00	575	0:30	55	660	1:00	No	660	0:00	Yes	Heating	660

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 – Firing recommendations



Zubler Vario Press 300 Bioalloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Program type	Starting temp.	Pre-drying	Pre-drying time	Closing time	Homogenizing temp.	Homogenizing temp.	Heating rate	Final temp.	Holding time	Tempering °C / min	Opening temp.	Opening time	Vacuum	Vacuum release	Vacuum end
	Professional	Neutral paste	Yes	4:00	3:00	575	0:30	55	900	3:00	No	900	0:00	Yes	Heating	900
		Paste opaque	Yes	4:00	3:00	575	0:30	55	900	3:00	No	900	0:00	Yes	Heating	900
		Powder opaque	Yes	2:00	3:00	575	0:30	55	900	3:00	No	900	0:00	Yes	Heating	900
		Shoulder 1 + 2	Yes	2:00	4:00	575	0:30	55	920	1:00	No	920	0:00	Yes	Heating	920
		Dentine 1	Yes	1:00	5:00	575	0:30	55	910	1:00	No	910	0:00	Yes	Heating	910
		Dentine 2	Yes	1:00	4:00	575	0:30	55	900	1:00	No	900	0:00	Yes	Heating	900
		Glaze	Yes	1:00	3:00	575	0:30	55	890	1:00	No	890	0:00	No	Heating	0
		Correction (Final Kiss)	Yes	1:00	2:00	575	0:30	55	880	1:00	No	880	0:00	Yes	Heating	880
		Final Shoulder (F SM)	Yes	1:00	3:00	575	0:30	55	660	1:00	No	660	0:00	Yes	Heating	660

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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Zubler Vario Press 300 Conventional alloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

	Program type	Starting temp.	Pre-drying	Pre-drying time	Closing time	Homogenizing temp.	Homogenizing time	Heating rate	Final temp.	Holding time	Tempering °C / min	Opening temp.	Opening time	Vacuum	Vacuum release	Vacuum end
Paste opaque	Professional	575	Yes	4:00	3:00	575	0:30	55	930	2:00	No	930	0:00	Yes	Heating	930
Powder opaque		575	Yes	2:00	3:00	575	0:30	55	930	2:00	No	930	0:00	Yes	Heating	930
Shoulder 1 + 2		575	Yes	2:00	4:00	575	0:30	55	920	1:00	No	920	0:00	Yes	Heating	920
Dentine 1		575	Yes	1:00	5:00	575	0:30	55	910	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	850	0:00	Yes	Heating	910
Dentine 2		575	Yes	1:00	4:00	575	0:30	55	900	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	850	0:00	Yes	Heating	900
Glaze		575	Yes	1:00	3:00	575	0:30	55	890	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	850	0:00	No	Heating	0
Correction (Final Kiss)		575	Yes	1:00	2:00	575	0:30	55	880	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	850	0:00	Yes	Heating	880
Final Shoulder (F SM)		450	Yes	1:00	3:00	575	0:30	55	660	1:00	No	660	0:00	Yes	Heating	660

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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Zubler Vario Press 300 Bioalloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600°C)

	Program type	Starting temp.	Pre-drying	Pre-drying time	Closing time	Homogenizing temp.	Homogenizing time	Heating rate	Final temp.	Holding time	Tempering °C / min	Opening temp.	Opening time	Vacuum	Vacuum release	Vacuum end
Neutral paste		575	Yes	4:00	3:00	575	0:30	55	900	3:00	No	900	0:00	Yes	Heating	900
Paste opaque		575	Yes	4:00	3:00	575	0:30	55	900	3:00	No	900	0:00	Yes	Heating	900
Powder opaque		575	Yes	2:00	3:00	575	0:30	55	900	3:00	No	900	0:00	Yes	Heating	900
Shoulder 1 + 2		575	Yes	2:00	4:00	575	0:30	55	920	1:00	No	920	0:00	Yes	Heating	920
Dentine 1	Professional	575	Yes	1:00	5:00	575	0:30	55	910	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	850	0:00	Yes	Heating	910
Dentine 2		575	Yes	1:00	4:00	575	0:30	55	900	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	850	0:00	Yes	Heating	900
Glaze		575	Yes	1:00	3:00	575	0:30	55	890	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	850	0:00	No	Heating	0
Correction (Final Kiss)		575	Yes	1:00	2:00	575	0:30	55	880	1:00	-Tempering: Yes -Tempering temp.: 850 -Tempering time 3:00	850	0:00	Yes	Heating	880
Final Shoulder (F SM)		450	Yes	1:00	3:00	575	0:30	55	660	1:00	No	660	0:00	Yes	Heating	660

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Zubler Vario Press 300 Conventional alloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600°C)

	Program type	Starting temp.	Pre-drying	Pre-drying time	Closing time	Homogenizing temp.	Homogenizing time	Heating rate	Final temp.	Holding time	Tempering °C / min	Opening temp.	Opening time	Vacuum	Vacuum release	Vacuum end	
	Professional	Paste opaque	575	Yes	4:00	3:00	575	0:30	55	930	2:00	No	930	0:00	Yes	Heating	930
		Powder opaque	575	Yes	2:00	3:00	575	0:30	55	930	2:00	No	930	0:00	Yes	Heating	930
		Shoulder 1+2	575	Yes	2:00	4:00	575	0:30	55	920	1:00	No	920	0:00	Yes	Heating	920
		Dentine 1	575	Yes	1:00	5:00	575	0:30	55	910	1:00	No	910	0:00	Yes	Heating	910
		Dentine 2	575	Yes	1:00	4:00	575	0:30	55	900	1:00	No	900	0:00	Yes	Heating	900
		Glaze	575	Yes	1:00	3:00	575	0:30	55	890	1:00	No	890	0:00	No	Heating	0
		Correction (Final Kiss)	575	Yes	1:00	2:00	575	0:30	55	880	1:00	No	880	0:00	Yes	Heating	880
		Final Shoulder (F SM)	450	Yes	1:00	3:00	575	0:30	55	660	1:00	No	660	0:00	Yes	Heating	660

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VITA Vacumat 6000 MP Non-precious alloys, Crypton, Compartis

	Pre-drying temp.	Lifting plate positions	Pre-vacuum	Heating rate	Main vacuum	Firing temp.	Cooling temperature	Lifting plate position
	Pre-drying time	Pre-drying				Holding time	Holding time	
	°C / min	c 100% b 62% a 44%	% / min	°C / min	%	°C / min	°C / min	%
NE-Bonder (paste)	575 / 7:00	c 1:00 b 2:00 a 4:00	100 / 0:00	55 7:21	100 7:21	980 / 2:00	0	0
NE-Bonder (powder)	575 / 5:00	c 1:00 b 2:00 a 2:00	100 / 0:00	55 7:21	100 7:21	980 / 1:00	0	0
Paste opaque 1+2	575 / 7:00	c 1:00 b 2:00 a 4:00	100 / 0:00	55 6:49	100 6:49	950 / 2:00	0	0
Powder opaque 1+2	575 / 5:00	c 1:00 b 2:00 a 2:00	100 / 0:00	55 6:49	100 6:49	950 / 2:00	0	0
Shoulder 1+2	575 / 6:00	c 2:00 b 2:00 a 2:00	100 / 0:00	55 6:27	100 6:27	930 / 1:00	0	0
Dentine 1	575 / 6:00	c 2:00 b 3:00 a 1:00	100 / 0:00	55 6:16	100 6:16	920 / 1:00	575 / 0:00	100
Dentine 2	575 / 5:00	c 2:00 b 2:00 a 1:00	100 / 0:00	55 6:05	100 6:05	910 / 1:00	575 / 0:00	100
Glaze	575 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 6:05	0	890 / 1:00	575 / 0:00	100
Correction (Final Kiss)	575 / 3:00	c 1:00 b 1:00 a 1:00	100 / 0:00	55 5:32	100 5:32	880 / 1:00	575 / 0:00	100
Final Shoulder (F-SM)	450 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 1:32	100 1:32	660 / 1:00	0	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 – Firing recommendations



VITA Vacumat 6000 MP Conventional alloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600°C)

	Pre-drying temp.	Lifting plate positions	Pre-vacuum	Heating rate	Main vacuum	Firing temp.	Cooling temperature	Lifting plate position
	Pre-drying time	Pre-drying				Holding time	Holding time	
	°C / min	c 100% b 62% a 44%	% / min	°C / min	%	°C / min	°C / min	%
Paste opaque	575 / 7:00	c 1:00 b 2:00 a 4:00	100 / 0:00	55 5:54	100 5:54	930 / 2:00	0	0
Powder opaque	575 / 5:00	c 1:00 b 2:00 a 2:00	100 / 0:00	55 5:54	100 5:54	930 / 2:00	0	0
Shoulder 1 + 2	575 / 6:00	c 2:00 b 2:00 a 2:00	100 / 0:00	55 6:16	100 6:16	920 / 1:00	0	0
Dentine 1	575 / 6:00	c 2:00 b 3:00 a 1:00	100 / 0:00	55 6:05	100 6:05	910 / 1:00	850 / 3:00	100
Dentine 2	575 / 5:00	c 2:00 b 2:00 a 1:00	100 / 0:00	55 5:54	100 5:54	900 / 1:00	850 / 3:00	100
Glaze	575 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 5:54	0	890 / 1:00	850 / 3:00	100
Correction (Final Kiss)	575 / 3:00	c 1:00 b 1:00 a 1:00	100 / 0:00	55 5:32	100 5:32	880 / 1:00	850 / 3:00	100
Final Shoulder (F-SM)	450 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 1:32	100 1:32	660 / 1:00	0	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 – Firing recommendations



VITA Vacumat 6000 MP Conventional alloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600 °C)

	Pre-drying temp.	Lifting plate positions	Pre-vacuum	Heating rate	Main vacuum	Firing temp.	Cooling temperature	Lifting plate position
	Pre-drying time	Pre-drying				Holding time	Holding time	
	°C / min	c 100% b 62% a 44%	% / min	°C / min	%	°C / min	°C / min	%
Paste opaque	575 / 7:00	c 1:00 b 2:00 a 4:00	100 / 0:00	55 6:27	100 6:27	930 / 2:00	0	0
Powder opaque	575 / 5:00	c 1:00 b 2:00 a 2:00	100 / 0:00	55 6:27	100 6:27	930 / 2:00	0	0
Shoulder 1 + 2	575 / 6:00	c 2:00 b 2:00 a 2:00	100 / 0:00	55 6:16	100 6:16	920 / 1:00	0	0
Dentine 1	575 / 6:00	c 2:00 b 3:00 a 1:00	100 / 0:00	55 6:05	100 6:05	910 / 1:00	0	0
Dentine 2	575 / 5:00	c 2:00 b 2:00 a 1:00	100 / 0:00	55 5:54	100 5:54	900 / 1:00	0	0
Glaze	575 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 5:54	0	890 / 1:00	0	0
Correction (Final Kiss)	575 / 3:00	c 1:00 b 1:00 a 1:00	100 / 0:00	55 5:32	100 5:32	880 / 1:00	0	0
Final Shoulder (F-SM)	450 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 1:32	100 1:32	660 / 1:00	0	0

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Duceram® Kiss – Firing recommendations



VITA Vacumat 6000 MP Bioalloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600°C)

	Pre-drying temp.	Lifting plate positions	Pre-vacuum	Heating rate	Main vacuum	Firing temp.	Cooling temperature	Lifting plate position
	Pre-drying time	Pre-drying				Holding time	Holding time	
	°C / min	c 100% b 62% a 44%	% / min	°C / min	%	°C / min	°C / min	%
Neutral paste	575 / 7:00	c 1:00 b 2:00 a 4:00	100 / 0:00	55 5:54	100 5:54	900 / 3:00	0	0
Paste opaque	575 / 7:00	c 1:00 b 2:00 a 4:00	100 / 0:00	55 5:54	100 5:54	900 / 3:00	0	0
Powder opaque 1+2	575 / 5:00	c 1:00 b 2:00 a 2:00	100 / 0:00	55 5:54	100 5:54	900 / 3:00	0	0
Shoulder 1+2	575 / 6:00	c 2:00 b 2:00 a 2:00	100 / 0:00	55 6:16	100 6:16	920 / 1:00	0	0
Dentine 1	575 / 6:00	c 2:00 b 3:00 a 1:00	100 / 0:00	55 6:05	100 6:05	910 / 1:00	850 / 3:00	100
Dentine 2	575 / 5:00	c 2:00 b 2:00 a 1:00	100 / 0:00	55 5:54	100 5:54	900 / 1:00	850 / 3:00	100
Glaze	575 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 5:54	0	890 / 1:00	850 / 3:00	100
Correction (Final Kiss)	575 / 3:00	c 1:00 b 1:00 a 1:00	100 / 0:00	55 5:32	100 5:32	880 / 1:00	850 / 3:00	100
Final Shoulder (F-SM)	450 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 1:32	100 1:32	660 / 1:00	0	0

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VITA Vacumat 6000 MP Bioalloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600°C)

	Pre-drying temp.	Lifting plate positions	Pre-vacuum	Heating rate	Main vacuum	Firing temp.	Cooling temperature	Lifting plate position
	Pre-drying time	Pre-drying				Holding time	Holding time	
	°C / min	c 100% b 62% a 44%	% / min	°C / min	%	°C / min	°C / min	%
Neutral paste	575 / 7:00	c 1:00 b 2:00 a 4:00	100 / 0:00	55 5:54	100 5:54	900 / 3:00	0	0
Paste opaque	575 / 7:00	c 1:00 b 2:00 a 4:00	100 / 0:00	55 5:54	100 5:54	900 / 3:00	0	0
Powder opaque 1+2	575 / 5:00	c 1:00 b 2:00 a 2:00	100 / 0:00	55 5:54	100 5:54	900 / 3:00	0	0
Shoulder 1+2	575 / 6:00	c 2:00 b 2:00 a 2:00	100 / 0:00	55 6:16	100 6:16	920 / 1:00	0	0
Dentine 1	575 / 6:00	c 2:00 b 3:00 a 1:00	100 / 0:00	55 6:05	100 6:05	910 / 1:00	0	0
Dentine 2	575 / 5:00	c 2:00 b 2:00 a 1:00	100 / 0:00	55 5:54	100 5:54	900 / 1:00	0	0
Glaze	575 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 5:54	0	890 / 1:00	0	0
Correction (Final Kiss)	575 / 3:00	c 1:00 b 1:00 a 1:00	100 / 0:00	55 5:32	100 5:32	880 / 1:00	0	0
Final Shoulder (F-SM)	450 / 4:00	c 1:00 b 2:00 a 1:00	100 / 0:00	55 1:32	100 1:32	660 / 1:00	0	0

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Duceram® Kiss – Firing recommendations



Programat P90/95 Non-precious alloys, Crypton, Compartis

Cycle	Program number	Standby temp.	Heating rate	Firing temp.	Closing time	Holding time	Long-term cooling	Vacuum on	Vacuum off
		°C	min	°C	min	min	°C	°C	°C
	Prg	B	t↑	T	S	H	L	V1	V2
NE-Bonder (paste)	Freely selectable	450	55	980	7:00	2:00	0	450	979
NE-Bonder (powder)		450	55	980	5:00	1:00	0	450	979
Paste opaque 1+2		450	55	950	7:00	2:00	0	450	949
Powder opaque 1+2		450	55	950	5:00	2:00	0	450	949
Shoulder 1+2		400	55	930	6:00	1:00	0	450	929
Dentine 1		400	55	920	6:00	1:00	600	450	919
Dentine 2		400	55	910	5:00	1:00	600	450	909
Glaze		400	55	890	4:00	1:00	600	0	0
Correction (Final Kiss)		400	55	880	3:00	1:00	600	450	879
Final Shoulder (F-SM)		400	55	660	4:00	1:00	0	450	659

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 – Firing recommendations



Programat P90/95 Conventional alloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

Cycle	Program number	Standby temp. °C	Heating rate min	Firing temp. °C	Closing time min	Holding time min	Long-term cooling °C	Vacuum on °C	Vacuum off °C
	Prg	B	t↑	T	S	H	L	V1	V2
Paste opaque 1 + 2	Freely selectable	450	55	930	7:00	2:00	0	450	929
Powder opaque 1 + 2		450	55	930	5:00	2:00	0	450	929
Shoulder 1 + 2		400	55	920	6:00	1:00	0	450	919
Dentine 1		400	55	910	6:00	1:00	600	450	909
Dentine 2		400	55	900	5:00	1:00	600	450	899
Glaze		400	55	890	4:00	1:00	600	0	0
Correction (Final Kiss)		400	55	880	3:00	1:00	600	450	879
Final Shoulder (F-SM)		400	55	660	4:00	1:00	0	450	659

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 – Firing recommendations



Programat P90/95 Conventional alloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600°C)

Cycle	Program number	Standby temp. °C	Heating rate min	Firing temp. °C	Closing time min	Holding time min	Long-term cooling °C	Vacuum on °C	Vacuum off °C
	Prg	B	t↑	T	S	H	L	V1	V2
Paste opaque 1 + 2	Freely selectable	450	55	930	7:00	2:00	0	450	929
Powder opaque 1 + 2		450	55	930	5:00	2:00	0	450	929
Shoulder 1 + 2		400	55	920	6:00	1:00	0	450	919
Dentine 1		400	55	910	6:00	1:00	0	450	909
Dentine 2		400	55	900	5:00	1:00	0	450	899
Glaze		400	55	890	4:00	1:00	0	0	0
Correction (Final Kiss)		400	55	880	3:00	1:00	0	450	879
Final Shoulder (F-SM)		400	55	660	4:00	1:00	0	450	659

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Duceram® Kiss – Firing recommendations



Programat P90/95 Bioalloys, CTE from $14.5 \times 10^{-6} \text{ K}^{-1}$ (25–600 °C)

Cycle	Program number	Standby temp. °C	Heating rate min	Firing temp. °C	Closing time min	Holding time min	Long-term cooling °C	Vacuum on °C	Vacuum off °C
	Prg	B	t↑	T	S	H	L	V1	V2
Neutral paste	Freely selectable	450	55	900	7:00	3:00	0	450	899
Paste opaque 1+2		450	55	900	7:00	3:00	0	450	899
Powder opaque 1+2		450	55	900	5:00	3:00	0	450	899
Shoulder 1+2		400	55	920	6:00	1:00	0	450	919
Dentine 1		400	55	910	6:00	1:00	600	450	909
Dentine 2		400	55	900	5:00	1:00	600	450	899
Glaze		400	55	890	4:00	1:00	600	0	0
Correction (Final Kiss)		400	55	880	3:00	1:00	600	450	879
Final Shoulder (F-SM)		400	55	660	4:00	1:00	0	450	659

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Duceram® Kiss – Firing recommendations



Programat P90/95 Bioalloys, CTE 13.8–14.4 x 10⁻⁶ K⁻¹ (25–600 °C)

Cycle	Program number	Standby temp. °C	Heating rate min	Firing temp. °C	Closing time min	Holding time min	Long-term cooling °C	Vacuum on °C	Vacuum off °C
	Prg	B	t↑	T	S	H	L	V1	V2
Neutral paste	Freely selectable	450	55	900	7:00	3:00	0	450	899
Paste opaque 1+2		450	55	900	7:00	3:00	0	450	899
Powder opaque 1+2		450	55	900	5:00	3:00	0	450	899
Shoulder 1+2		400	55	920	6:00	1:00	0	450	919
Dentine 1		400	55	910	6:00	1:00	0	450	909
Dentine 2		400	55	900	5:00	1:00	0	450	899
Glaze		400	55	890	4:00	1:00	0	0	0
Correction (Final Kiss)		400	55	880	3:00	1:00	0	450	879
Final Shoulder (F-SM)		400	55	660	4:00	1:00	0	450	659

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