

# Firing Instructions for precious alloys

## Duceram® love – General firing recommendations



	Pre-heating	Drying			Heating	Firing	Holding		Vacuum
	°C	Pre-drying	Closing	Pre-heating			Vacuum	No Vacuum	
		min	min	min			min	min	
<b>Opaque 1+2</b>	550	6	2	1	100	910	2	2	50
<b>Shoulder 1</b>	500	1	3	2	100	880	0,5	0,5	50
<b>Shoulder 2</b>	500	1	3	2	100	860	0,5	0,5	50
<b>Dentine 1</b>	500	4	3	2	100	830	0,5	0,5	50
<b>Dentine 2</b>	500	4	2	2	100	820	0,5	0,5	50
<b>Glaze</b>	500	0	2	2	100	810		0,5	–
<b>Final Shoulder/ Add-On</b>	450	1	2	2	100	680	0,5	0,5	50
<b>Stains</b>	450	1	2	1	100	660	0	1	–

Ⓒ 0124 The firing temperature must be adjusted to the number of units fired. Five to ten units require an increase by 5°C to 10°C; more than ten units require an increase by 10°C to 20°C.

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

When Duceram love is fired onto Ducera press, the firing parameters for the Ducera press Add-On Cervical (see Ducera press Instructions for Use) must be applied.

# Firing Instructions for precious alloys



Duceram® love – General firing instructions Multimat Touch & Press / Touch & Press 2 / NT / NTpress / Easy

	Pre-heating °C	Drying min	Pre-heating min	Vacuum hPa	Heating °C/min.	Firing °C	Vacuum min	Firing min	Tempe- ring °C	Tempe- ring min	Cooling level
<b>PO opaque 1+2</b>	550	8:00	1:00	50	100	910	2:00	4:00	–	–	–
<b>Margin 1</b>	500	4:00	2:00	50	100	880	0:30	1:00	–	–	–
<b>Margin 2</b>	500	4:00	2:00	50	100	860	0:30	1:00	–	–	–
<b>Dentine 1</b>	500	7:00	2:00	50	100	830	0:30	1:30	–	–	–
<b>Dentine 2</b>	500	6:00	2:00	50	100	820	0:30	1:30	–	–	–
<b>Glaze</b>	500	2:00	2:00	–	100	810	–	0:30	–	–	–
<b>Final Shoulder/ Add-On</b>	450	3:00	2:00	50	100	680	0:30	1:00	–	–	–
<b>Stains</b>	450	3:00	1:00	–	100	660	–	1:00	–	–	–

CE<sup>0124</sup> The firing temperature must be adjusted to the number of units fired. Five to ten units require an increase by 5°C to 10°C; more than ten units require an increase by 10°C to 20°C.

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# Firing Instructions for precious alloys

## Duceram® love – General firing instructions Cergo Press



	Drying	Drying	Closing	Pre-heating	Pre-heating	Vacuum	Vacuum	Vacuum	Heating	Firing	Vacuum	Holding	Tempering	Tempering	Cooling
	°C	min	min	°C	min	cont. on off	on	off	°C/min	°C	min	min	min	°C	min
<b>Paste opaque 1+2</b>	135	6:00	2:00	550	1:00	cont	550	910	100	910	2:00	2:00	–	–	–
<b>Margin 1</b>	135	1:00	3:00	500	2:00	cont	500	880	100	880	0:30	0:30	–	–	–
<b>Margin 2</b>	135	1:00	3:00	500	2:00	cont	500	860	100	860	0:30	0:30	–	–	–
<b>Dentine 1</b>	135	4:00	3:00	500	2:00	cont	500	830	100	830	0:30	0:30	–	–	–
<b>Dentine 2</b>	135	4:00	2:00	500	2:00	cont	500	820	100	820	0:30	0:30	–	–	–
<b>Glaze</b>	135	0:00	2:00	500	2:00	off	–	–	100	810	–	0:30	–	–	–
<b>Final Shoulder/ Add-On</b>	135	1:00	2:00	450	2:00	cont	450	680	100	680	0:30	0:30	–	–	–
<b>Stains</b>	135	1:00	2:00	450	1:00	off	–	–	100	660	–	1:00	–	–	–

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# Firing Instructions for precious alloys

## Duceram® love – General firing instructions ProFire



	Drying	Drying	Closing	Pre-heating	Pre-heating	Vacuum	Vacuum	Vacuum	Heating	Firing	Vacuum	Holding	Tempering	Tempering	Cooling
	°C	min	min	°C	min	cont. on off	ein	aus	°C/min	°C	min	min	min	°C	min
<b>Paste opaque 1+2</b>	135	6:00	2:00	550	1:00	cont	550	910	100	910	2:00	2:00	–	–	–
<b>Margin 1</b>	135	1:00	3:00	500	2:00	cont	500	880	100	880	0:30	0:30	–	–	–
<b>Margin 2</b>	135	1:00	3:00	500	2:00	cont	500	860	100	860	0:30	0:30	–	–	–
<b>Dentine 1</b>	135	4:00	3:00	500	2:00	cont	500	830	100	830	0:30	0:30	–	–	–
<b>Dentine 2</b>	135	4:00	2:00	500	2:00	cont	500	820	100	820	0:30	0:30	–	–	–
<b>Glaze</b>	135	0:00	2:00	500	2:00	off	–	–	100	810	–	0:30	–	–	–
<b>Final Shoulder/ Add-On</b>	135	1:00	2:00	450	2:00	cont	450	680	100	680	0:30	0:30	–	–	–
<b>Stains</b>	135	1:00	2:00	450	1:00	off	–	–	100	660	–	1:00	–	–	–

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# Firing Instructions for precious alloys

## Duceram® love – General firing instructions Dekema Austromat 3001



<b>Paste opaque 1+2</b>	C550 T360 T120 • L9 T60 V9 T099 • C910 T120 V0 T120 C0 L0 T2 C550
<b>Margin 1*</b>	C500 T60 T180 • L9 T120 V9 T099 • C880 T30 V0 T30 C0 L0 T2 C500
<b>Margin 2*</b>	C500 T60 T180 • L9 T120 V9 T099 • C860 T30 V0 T30 C0 L0 T2 C500
<b>Dentine 1</b>	C500 T240 T180 • L9 T120 V9 T0100 • C830 T30 V0 T30 C0 • L0 T2 C500
<b>Dentine 2</b>	C500 T240 T120 • L9 T120 V9 T0100 • C820 T30 V0 T30 C0 • L0 T2 C500
<b>Glaze</b>	C500 T120 • L9 T120 T0100 • C810 T30 C0 • L0 T2 C500
<b>Final Shoulder/Add-On</b>	C450 T60 T120 • L9 T120 V9 T0100 • C680 V0 T30 C0 L0 C450
<b>Stains</b>	C450 T60 T120 • L9 T120 T0100 • C660 T30 C0 L0 C450

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# Firing Instructions for precious alloys

## Duceram® love – Ivoclar Programat 5000



	Pre-Drying	Pre-Drying	Closing	Temperature Increase	hold-temperature	hold time	Temperature Increase 2. level	hold temperature 2. level	hold time 2. level	hold time Vacuum	Vakuum on Temp. 2. level	Vakuum off Temp. 2. level	long term Cooling	Cool down gradient
	°C	min.	min	°C	°C	min	°C	°C	min	min	°C	°C	°C	°C
			S	t1	T	H	t2↑	T2	H2	Hv	V1 2	V2 2	L	tL
<b>PO opaque 1+2</b>	450	6:00	2:00	100	550	1:00	100	910	2:00	2:00	550	910	-	-
<b>Margin 1</b>	450	1:00	3:00	100	500	2:00	100	880	0:30	0:30	500	880	-	-
<b>Margin 1</b>	450	1:00	3:00	100	500	2:00	100	860	0:30	0:30	500	860	-	-
<b>Dentin 1</b>	450	4:00	3:00	55	500	2:00	100	830	0:30	0:30	500	830	-	-
<b>Dentin 2</b>	450	4:00	2:00	55	500	2:00	100	820	0:30	0:30	500	820	-	-
<b>Glaze</b>	0	0	2:00	55	500	2:00	100	810	0:30	0	0	0	-	-
<b>Final Shoulder/ Add-On</b>	450	1:00	2:00	55	450	2:00	100	680	0:30	0:30	450	680	-	-
<b>Stains</b>	450	1:00	2:00	55	450	1:00	100	660	1:00	-	-	-	-	-

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# Firing Instructions for non-precious alloys



## Duceram® love – General firing recommendations

	Pre-heating	Drying			Heating	Firing	Holding		Vacuum	Tempering	Cooling
		Pre-heating	Closing	Pre-heating			Vacuum	No Vacuum			
	°C	min	min	min	°C/Min.	°C	min	min	hPa	min	min
<b>NE Bonder Powder/Paste</b>	575	4/6	2	1	55	980	0	2/3	50	–	–
<b>Opaque</b>	550	6	2	1	100	910	2	2	50	–	–
<b>Shoulder 1</b>	500	1	3	2	100	880	0,5	0,5	50	*3 min/ 850 °C	6*
<b>Shoulder 2</b>	500	1	3	2	100	860	0,5	0,5	50	*3 min/ 850 °C	6*
<b>Dentine 1</b>	500	4	3	2	55	820	0,5	0,5	50	–	6
<b>Dentine 2</b>	500	4	2	2	55	810	0,5	0,5	50	–	6
<b>Glaze</b>	500	0	2	2	55	800	0	0,5	–	–	6
<b>Final Shoulder/ Add-On</b>	450	1	2	2	55	680	0,5	0,5	50	–	–
<b>Stains</b>	450	1	2	1	55	660	0	1	–	–	–

CE 0124 \* For alloys with a CTE  $\geq 14.6 \mu\text{m/m} \cdot \text{K}$  (25–500°C), shoulder firing must be extended by a tempering phase (3 min/850°C) and a cooling phase (6 min).

The firing temperature must be adjusted to the number of units fired. Five to ten units require an increase by 5°C to 10°C; more than ten units require an increase by 10°C to 20°C.

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# Firing Instructions for non-precious alloys



Duceram® love – General firing instructions Multimat Touch & Press / Touch & Press 2 / NT / NTpress / Easy

	Pre-heating °C	Drying min	Pre-heating min	Vacuum hPa	Heating °C/min.	Firing °C	Vacuum min	Firing min	Tempering °C	Tempering min	Cooling level
<b>NE-Bond Powder</b>	575	6:00	1:00	50	55	980	0:10	2:00			
<b>NE-Bond Paste</b>	575	8:00	1:00	50	55	980	0:10	3:00			
<b>PO opaque 1+2</b>	550	8:00	1:00	50	100	910	2:00	4:00			
<b>Margin 1</b>	500	4:00	2:00	50	100	880	0:30	1:00	850*	3*	1*
<b>Margin 2</b>	500	4:00	2:00	50	100	860	0:30	1:00	850*	3*	1*
<b>Dentine 1</b>	500	7:00	2:00	50	55	820	0:30	1:30			1
<b>Dentine 2</b>	500	6:00	2:00	50	55	810	0:30	1:30			1
<b>Glaze</b>	500	2:00	2:00	–	55	800	–	0:30			1
<b>Final Shoulder/ Add-On</b>	450	3:00	2:00	50	55	680	0:30	1:00			
<b>Stains</b>	450	3:00	1:00	–	55	660	–	1:00			

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# Firing Instructions for non-precious alloys



## Duceram® love – General firing instructions Cergo Press

	Drying	Drying	Closing	Pre-heating	Pre-heating	Vacuum	Vacuum	Vacuum	Heating	Firing	Vacuum	Holding	Tempe- ring	Tempe- ring	Cooling
	°C	min	min	°C	min	cont. on off	on	off	°C/min	°C	min	min	min	°C	min
NE-Bonder	135	4:00	2:00	575	1:00	cont	575	980	55	980	0:00	2:00	–	–	–
NE-Bond Paste	135	6:00	2:00	575	1:00	cont	575	980	55	980	0:00	3:00	–	–	–
Paste opaque 1+2	135	6:00	2:00	550	1:00	cont	550	910	100	910	2:00	2:00	–	–	–
Margin 1	135	1:00	3:00	500	2:00	cont	500	880	100	880	0:30	0:30	3*	850*	6*
Margin 2	135	1:00	3:00	500	2:00	cont	500	860	100	860	0:30	0:30	3*	850*	6*
Dentine 1	135	4:00	3:00	500	2:00	cont	500	820	55	820	0:30	0:30	–	–	6
Dentine 2	135	4:00	2:00	500	2:00	cont	500	810	55	810	0:30	0:30	–	–	6
Glaze	135	0:00	2:00	500	2:00	off	–	–	55	800	–	0:30	–	–	6
Final Shoulder/ Add-On	135	1:00	2:00	450	2:00	cont	450	680	55	680	0:30	0:30	–	–	–
Stains	135	1:00	2:00	450	1:00	off	–	–	55	660	–	1:00	–	–	–

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# Firing Instructions for non-precious alloys



## Duceram® love – General firing instructions ProFire

	Drying	Drying	Closing	Pre-heating	Pre-heating	Vacuum	Vacuum	Vacuum	Heating	Firing	Vacuum	Holding	Tempe- ring	Tempe- ring	Cooling
	°C	min	min	°C	min	cont. on off	ein	aus	°C/min	°C	min	min	min	°C	min
<b>NE-Bonder</b>	135	4:00	2:00	575	1:00	cont	575	980	55	980	0:00	2:00	–	–	–
<b>NE-Bond Paste</b>	135	6:00	2:00	575	1:00	cont	575	980	55	980	0:00	3:00	–	–	–
<b>Paste opaque 1+2</b>	135	6:00	2:00	550	1:00	cont	550	910	100	910	2:00	2:00	–	–	–
<b>Margin 1</b>	135	1:00	3:00	500	2:00	cont	500	880	100	880	0:30	0:30	3*	850*	6*
<b>Margin 2</b>	135	1:00	3:00	500	2:00	cont	500	860	100	860	0:30	0:30	3*	850*	6*
<b>Dentine 1</b>	135	4:00	3:00	500	2:00	cont	500	820	55	820	0:30	0:30	–	–	6
<b>Dentine 2</b>	135	4:00	2:00	500	2:00	cont	500	810	55	810	0:30	0:30	–	–	6
<b>Glaze</b>	135	0:00	2:00	500	2:00	off	–	–	55	800	–	0:30	–	–	6
<b>Final Shoulder/ Add-On</b>	135	1:00	2:00	450	2:00	cont	450	680	55	680	0:30	0:30	–	–	–
<b>Stains</b>	135	1:00	2:00	450	1:00	off	–	–	55	660	–	1:00	–	–	–

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# Firing Instructions for non-precious alloys



## Duceram® love – General firing instructions Dekema Austromat 3001

<b>NE-Bond Paste</b>	C575 T360 T120 • L9 T60 V9 T055 • C980 V0 T180 C0 L0 T2 C575
<b>NE-Bonder</b>	C575 T240 T120 • L9 T60 V9 T055 • C980 V0 T120 C0 L0 T2 C575
<b>Paste opaque 1+2</b>	C550 T360 T120 • L9 T60 V9 T099 • C910 T120 V0 T120 C0 L0 T2 C550
<b>Margin 1*</b>	C500 T60 T180 • L9 T120 V9 T099 • C880 T30 V0 T30 C0 L0 T2 C500
<b>Margin 2*</b>	C500 T60 T180 • L9 T120 V9 T099 • C860 T30 V0 T30 C0 L0 T2 C500
<b>Dentine 1</b>	C500 T240 T180 • L9 T120 V9 T055 • C820 T30 V0 T30 C0 T360 • L0 T2 C500
<b>Dentine 2</b>	C500 T240 T120 • L9 T120 V9 T055 • C810 T30 V0 T30 C0 T360 • L0 T2 C500
<b>Glaze</b>	C500 T120 • L9 T120 T055 • C800 T30 C0 T360 • L0 T2 C500
<b>Final Shoulder/Add-On</b>	C450 T60 T120 • L9 T120 V9 T055 • C680 V0 T30 C0 L0 C450
<b>Stains</b>	C450 T60 T120 • L9 T120 T055 • C660 T30 C0 L0 C450

**CE** 0124 \* For alloys with a CTE above  $14.6 \mu\text{m} / \text{m} \cdot \text{K}$  (25–500 °C), shoulder firing must be extended by a tempering phase (3 min / 850 °C) and a cooling phase (6 min).

The firing temperature must be adjusted to the number of units fired. Five to ten units require an increase by 5°C to 10°C; more than ten units require an increase by 10°C to 20°C.

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

When Duceram love is fired onto Ducera press, the firing parameters for the Ducera press Add-On Cervical (see Ducera press Instructions for Use) must be applied.

[www.love-ceramic.com](http://www.love-ceramic.com)

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A Dentsply Company

# Firing Instructions for non-precious alloys



## Duceram® love – Ivoclar Programat 5000

	Pre-Drying	Pre-Drying	Closing	Temp-erature Increase	hold-tempera-ture	hold time	Temp-erature Increase 2. level	hold tempera-ture 2. level	hold time 2. level	hold time Vacuum	Vakuu on Temp. 2. level	Vakuu off Temp. 2. level	long term Cooling	Cool down gradient
	°C	min.	min	°C	°C	min	°C	°C	min	min	°C	°C	°C	°C
			S	t↑	T	H	t2↑	T2	H2	Hv	V1 2	V2 2	L	tL
<b>NE-Bond/ Powder</b>	450	4:00	2:00	55	575	1:00	55	980	2:00	0	575	980	-	-
<b>NE-Bond/Paste</b>	450	6:00	2:00	55	575	1:00	55	980	3:00	0	575	980	-	-
<b>PO opaque 1+2</b>	450	6:00	2:00	100	550	1:00	100	910	2:00	2:00	550	910	-	-
<b>Margin 1</b>	450	1:00	3:00	100	500	2:00	100	880	0:30	0:30	500	880	500	40
<b>Margin 1</b>	450	1:00	3:00	100	500	2:00	100	860	0:30	0:30	500	860	500	40
<b>Dentin 1</b>	450	4:00	3:00	55	500	2:00	55	820	0:30	0:30	500	820	500	50
<b>Dentin 2</b>	450	4:00	2:00	55	500	2:00	55	810	0:30	0:30	500	810	500	50
<b>Glaze</b>	0	0	2:00	55	500	2:00	55	800	0:30	0	0	0	500	50
<b>Final Shoulder/ Add-On</b>	450	1:00	2:00	55	450	2:00	55	680	0:30	0:30	450	680	-	-
<b>Stains</b>	450	1:00	2:00	55	450	1:00	55	660	1:00	-	-	-	-	-

**CE** 0124 The firing temperature must be adjusted to the number of units fired. Five to ten units require an increase by 5°C to 10°C; more than ten units require an increase by 10°C to 20°C.

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

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