

Degunorm:

First Opaque firing with Degunorm classic Base,
semi-covering.
Second firing should be covering.
Heating rate: 55 °C/min – Final Temperature 780 °C.

Dependent on the capability of your furnace,
it may be necessary to raise the final temperature for larger
constructions (over 8 units) by 10–20 °C.

Degunorm supra:

First Opaque firing, semi-covering.
Second firing should be covering.
Heating rate can be raised to 80 °C/min
with a final temperature of 800 °C.

Dependent on the capability of your furnace,
it may be necessary to raise the final temperature for larger
constructions (over 8 units) by 10–20 °C.

Degunorm pur:

First Opaque firing, semi-covering.
Second firing should be covering.
Heating rate can be raised to 80 °C/min with a final
temperature of 800 °C.

Dependent on the capability of your furnace,
it may be necessary to raise the final temperature for larger
constructions (over 8 units) by 10–20 °C.

	Pre-heating temp. °C	Drying time min	Degunorm		Degunorm supra/pur		Holding time min	Vacuum HPa	Tempering
			Heating rate °C/min	Firing temp. °C	Heating rate °C/min	Firing temp. °C			
Oxidation	575	0:00	55	780	80	800	5:00	50	
Degunorm classic Base	575	7:00	55	780			1:00	50	
Paste Opaque	575	7:00	55	780	80	800	1:00	50	
Margin 1	450	5:00	55	780	80	800	1:15	50	
Margin 2	450	5:00	55	780	80	800	1:15	50	
Dentine 1	450	6:00	55	780	80	800	1:00	50	3 min/720 °C
Dentine 2	450	5:00	55	780	80	790	1:00	50	
Glazing	450	3:00	55	720	80	780	1:00		
Correction (Final Kiss)	450	2:00	55	720	80	730	1:00	50	
Final Margin	450	2:00	55	720	80	730	1:00	50	

Tempering or long-term cooling for initial dentine firing with Degunorm/Degunorm supra and pur tempering 3 min at 720 °C or alternatively cool in 5 min down to 680 °C!

No long-term cooling for Degunorm logic! Correction powders and Final Margin powders should not be fired below 760 °C!

All firing temperatures shown here are recommendations only. Variations are possible due to different furnace capabilities.

