



Firing instructions for Duceragold Kiss in Cergo furnaces

			Oxidbrand	Degunorm Classic Base	Wash and Paste Opaque	Margin 1	Margin 2	Dentine 1	Dentine 2	Glaze	Correction Final Kiss	Final Margin
	Pre-drying	°C	250	135	135	135	135	135	135	135	135	135
		min	0:00	6:00	6:00	2:00	2:00	2:00	2:00	2:00	2:00	2:00
	Closing	min	0:00	1:00	1:00	2:00	2:00	2:00	2:00	2:00	2:00	2:00
	Pre-heating	°C	575	575	575	450	450	450	450	450	450	450
		min	0:00	1:00	2:00	2:00	2:00	2:00	2:00	1:00	1:00	1:00
	Vacuum		Cont.	Cont.	Cont.	Cont.	Cont.	Cont.	Cont.	Off	Cont.	Cont.
	Vacuum on	°C	450	450	450	450	450	450	450	–	450	450
Degunorm	Rate	°C/min	55	55	55	55	55	55	55	55	55	55
	Final temp.	°C	780	780	780	780	780	780	780	770	720	720
	Vacuum off	°C	780	780	780	780	780	780	780	–	720	720
Degunorm supra/pur	Rate	°C/min	80	–	80	80	80	80	80	80	80	80
	Final temp.	°C	800	–	800	800	800	800	790	780	730	730
	Vacuum off	°C	800	–	800	800	800	800	790	–	730	730
	Holding V	min	5:00	0:00	0:00	0:00	0:00	0:00	0:00	0:00	0:00	0:00
	Holding	min	0:00	1:00	1:00	1:15	1:15	1:00	1:00	1:00	1:00	1:00
	Tempering	°C	–	–	–	–	–	720	–	–	–	–
		min	0:00	5:00	0:00	0:00	0:00	3:00	0:00	0:00	0:00	0:00

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.

