

Firing recommendations for
for Duceragold Kiss with Multimat
MC 2/Mach 2

		Oxidbrand	Degunorm Classic	Wash and Paste Base	Margin 1 Opaque	Margin 2	Dentine 1	Dentine 2	Glaze	Correction Final Kiss	Final Margin
	Pre-heating temp. °C	575	575	575	450	450	450	450	450	450	450
	Drying time min	1:00	7:00	7:00	2:00	2:00	3:00	2:00	2:00	2:00	2:00
	Pre-heating time min	0:00	1:00	1:00	3:00	3:00	3:00	3:00	3:00	3:00	3:00
	Vacuum time min	4:30	0:10	0:10	1:00	1:00	1:00	1:00	0:00	1:00	1:00
Degunorm	Heating rate °C/min	55	55	55	55	55	55	55	55	55	55
	Firing temp. °C	780	780	780	780	780	780	780	770	720	720
Degunorm supra/pur	Heating rate °C/min	80	–	80	80	80	80	80	80	80	80
	Firing temp. °C	800	–	800	800	800	800	790	780	730	730
	Firing time min	5:00	1:00	1:00	2:00	2:00	2:00	2:00	1:00	2:00	2:00
	Vacuum hPa	50	50	50	50	50	50	50	–	50	50
	Cooling stage/ Tempering	–	–	–	–	–	Level 9/ 3 min at 720 °C	–	–	–	–

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.

