

Firing recommendations
for Duceragold Kiss with
Programat P90/P95

	Stand by temp. °C	Closing time min	Degunorm		Degunorm supra/pur		Holding time min	Vacuum ON in °C	Degunorm	Degunorm supra/pur	Long-term cooling
			Heating rate °C/min	Firing temp. °C	Heating rate °C/min	Firing temp. °C			Vacuum OFF in °C		
Oxidation	500	0:30	55	780	80	800	5:00	500	779	799	–
Degunorm classic Base	500	7:00	55	780	–	–	1:00	500	779		–
Paste opaque	500	7:00	55	780	80	800	1:00	500	779	799	–
Margin 1	300	6:00	55	780	80	800	1:15	450	789	799	–
Margin 2	300	5:00	55	780	80	800	1:15	450	779	799	–
Dentine 1	300	6:00	55	780	80	800	1:00	450	779	799	680 °C
Dentine 2	300	6:00	55	780	80	790	1:00	450	779	789	–
Glaze	300	4:00	55	770	80	780	1:00	-	–	–	–
Correction (Final Kiss)	300	4:00	55	720	80	730	1:00	450	719	729	–
Final Margin	300	4:00	55	720	80	730	1:00	450	719	729	–

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.

