

Firing recommendations for  
Duceragold Kiss with Vacumat  
200/250/300

	Stand by temp. °C	Pre-drying time min	Degunorm		Degunorm supra/pur		Holding time min	Degunorm	Degunorm supra/pur	Tempering/ cooling
			Heating time min	Firing temp. °C	Heating time min	Firing temp. °C		Vacuum time min		
Oxidation	400	0:00	6:00	780	4:30	800	5:00	10:30	9:00	–
Degunorm classic Base	400	6:00	6:00	780	4:30	–	1:00	6:00		–
Paste opaque	450	6:00	6:00	780	4:30	800	1:00	6:00	4:30	–
Margin 1	450	6:00	6:00	780	4:30	800	1:15	6:00	4:30	–
Margin 2	450	6:00	6:00	780	4:30	800	1:15	6:00	4:30	–
Dentine 1	450	6:00	6:00	780	4:30	800	1:00	6:00	4:30	3 min/720 °C
Dentine 2	450	6:00	6:00	780	4:30	790	1:00	6:00	4:30	–
Glaze	450	4:00	6:00	770	4:30	780	1:00	0:00	0:00	–
Correction (Final Kiss)	450	4:00	6:00	720	4:30	730	1:00	6:00	4:30	–
Final Margin	450	4:00	6:00	720	4:30	730	1:00	6:00	4:30	–

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

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

- Vacumat 200: Program-Group 8
- Vacumat 250: allow to cool down to 720 °C with the firing chamber closed and temper for 3 min.
- Vacumat 300: Cooling stage 1: allow to cool down to 720 °C with the firing chamber closed. Following this: Cooling stage 2: 4 min at 3 °C
- Vacumat 500 or 2500: allow to cool down to 720 °C with the firing chamber closed and temper for 3 min.

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

