

General firing recommendations for Duceram Kiss

General information for firing:

1. You can optionally fire Duceram Kiss in connection with conventional alloys (not bio alloys) and non precious alloys using a higher heating rate of 80 °C/min. When using the higher heating rate, the firing temperature should also be increased by 10 °C.

2. Note the required long-term cooling/tempering process for alloys with a CTE ex 14.5 µm/m·K (25–600 °C).

3. Different ceramic furnaces may perform completely differently. The actual firing temperatures may have to be adjusted accordingly.

		Pre-heating	Drying	Heat rate	Firing temp.	Holding	Vacuum	Tempering
		°C	min	°C/min	°C	min	hPa	
	Oxide firing	Please see the DFU of the corresponding alloy.						
Bio alloy program	Neutral paste	575	7:00	55	900	3:00	50	–
	Paste opaque	575	7:00	55	900	3:00	50	–
	Powder opaque	575	5:00	55	900	3:00	50	–
Conventional alloy	Paste op. 1 + 2	575	7:00	55	930	2:00	50	–
	Powder op. 1 + 2	575	5:00	55	930	2:00	50	–
Without long-term cooling For example Degudent Kiss	Shoulder 1	575	7:00	55	920	1:00	50	–
	Shoulder 2	575	7:00	55	920	1:00	50	–
	Dentine 1	575	6:00	55	910	1:00	50	–
	Dentine 2	575	4:00	55	900	1:00	50	–
	Glaze	575	3:00	55	890	1:00	–	–
	Correction	575	4:00	55	880	1:00	50	–
	Final Shoulder	575	4:00	55	660	1:00	50	–
Long-term cooling ex CTE 14.5 µm/m·K	Dentine 1	575	6:00	55	910	1:00	50	3 min/850 °C
	Dentine 2	575	4:00	55	900	1:00	50	3 min/850 °C
	Glaze	575	3:00	55	890	1:00	–	3 min/850 °C

