

Firing instructions for Duceram Kiss in the Cergo furnace

		Pre-drying		Closing	Pre-Heating		Heat Rate	Vacuum			Final temp.	Holding		Tempering	
		°C	min	min	°C	min	°C/min	on/ off/cont.	on °C	off °C	°C	V min	min	°C	min
	Oxide firing	Please see the DFU of the corresponding alloy.													
Bio alloy program	Neutral paste	135	4:00	2:00	575	1:00	55	cont	575	900	900	0:00	3:00	–	–
	Paste Opaque	135	4:00	2:00	575	1:00	55	cont	575	900	900	0:00	3:00	–	–
	Powder Opaque	135	2:00	2:00	575	1:00	55	cont	575	900	900	0:00	3:00	–	–
Conventional alloy	Paste Opaque 1+2	135	4:00	2:00	575	1:00	55	cont	575	930	930	0:00	2:00	–	–
	Powder Opaque 1+2	135	2:00	2:00	575	1:00	55	cont	575	930	930	0:00	2:00	–	–
Without long-term cooling For example Degudent Kiss	Shoulder 1	135	2:00	2:00	575	2:00	55	cont	575	920	920	0:00	1:00	–	–
	Shoulder 2	135	2:00	2:00	575	2:00	55	cont	575	920	920	0:00	1:00	–	–
	Dentine 1	135	1:00	3:00	575	2:00	55	cont	575	910	910	0:00	1:00	–	–
	Dentine 2	135	1:00	2:00	575	2:00	55	cont	575	900	900	0:00	1:00	–	–
	Glaze	135	0:00	2:00	575	1:00	55	off	–	–	890	0:00	1:00	–	–
	Correction	135	1:00	1:00	575	1:00	55	cont	575	880	880	0:00	1:00	–	–
	Final Shoulder	135	1:00	2:00	450	1:00	55	cont	575	660	660	0:00	1:00	–	–
Long-term cooling ex CTE 14.5 µm/m·K	Dentine 1	135	2:00	2:00	575	2:00	55	cont	575	910	910	0:00	1:00	850	3:00
	Dentine 2	135	2:00	2:00	575	2:00	55	cont	575	900	900	0:00	1:00	850	3:00
	Glaze	135	2:00	2:00	575	2:00	55	off	–	–	890	0:00	1:00	850	3:00

