

# Firing instructions for Duceram Kiss in the Multimat Touch&Press

		Pre-Heating		Drying	Heat Rate	Final temp.	Holding	Vacuum		Tempering	
		°C	min	min	°C/min	°C	min	hPa	min	°C	min
	Oxide firing	Please see the DFU of the corresponding alloy.									
Bio alloy program	Neutral paste	575	1:00	7:00	55	900	3:00	50	2:00	–	–
	Paste Opaque	575	2:00	7:00	55	900	3:00	50	2:00	–	–
	Powder Opaque	575	1:00	4:00	55	900	3:00	50	2:00	–	–
Conventional alloy	Paste Opaque 1+2	575	1:00	7:00	55	930	2:00	50	2:00	–	–
	Powder Opaque 1+2	575	1:00	4:00	55	930	2:00	50	2:00	–	–
Without long-term cooling For example Degudent Kiss	Shoulder 1	575	2:00	5:00	55	920	1:00	50	2:00	–	–
	Shoulder 2	575	2:00	5:00	55	920	1:00	50	2:00	–	–
	Dentine 1	575	2:00	5:00	55	910	1:00	50	2:00	–	–
	Dentine 2	575	2:00	4:00	55	900	1:00	50	2:00	–	–
	Glaze	575	1:00	3:00	55	890	1:00	–	–	–	–
	Correction	575	1:00	3:00	55	880	1:00	50	2:00	–	–
	Final Shoulder	450	2:00	3:00	55	660	1:00	50	2:00	–	–
Long-term cooling ex CTE 14.5 µm/m·K	Dentine 1	575	2:00	5:00	55	910	1:00	50	2:00	850 °C	3 min
	Dentine 2	575	2:00	5:00	55	900	1:00	50	2:00	850 °C	3 min
	Glaze	575	1:00	3:00	55	890	1:00	–	–	850 °C	3 min

