



Firing Instructions for non-precious alloys

Duceram® love – General firing recommendations

	Pre-heating	Drying			Heating	Firing	Holding		Vacuum	Tempering	Cooling
		Pre-heating	Closing	Pre-heating			Vacuum	No Vacuum			
	°C	min	min	min	°C/Min.	°C	min	min	hPa	min	min
NE Bonder Powder/Paste	575	4/6	2	1	55	980	0	2/3	50	–	–
Opaque	550	6	2	1	100	910	2	2	50	–	–
Shoulder 1	500	1	3	2	100	880	0,5	0,5	50	*3 min/ 850 °C	6*
Shoulder 2	500	1	3	2	100	860	0,5	0,5	50	*3 min/ 850 °C	6*
Dentine 1	500	4	3	2	55	820	0,5	0,5	50	–	6
Dentine 2	500	4	2	2	55	810	0,5	0,5	50	–	6
Glaze	500	0	2	2	55	800	0	0,5	–	–	6
Final Shoulder/ Add-On	450	1	2	2	55	680	0,5	0,5	50	–	–
Stains	450	1	2	1	55	660	0	1	–	–	–

Ⓒ 0124 * For alloys with a CTE $\geq 14.6 \mu\text{m}/\text{m} \cdot \text{K}$ (25–500°C), shoulder firing must be extended by a tempering phase (3 min/850°C) and a cooling phase (6 min).

The firing temperature must be adjusted to the number of units fired. Five to ten units require an increase by 5°C to 10°C; more than ten units require an increase by 10°C to 20°C.

The values listed here are intended for orientation only and should be regarded only as guidelines. Your firing results may differ. All firing results depend on the performance of the furnace used, which in turn depends on the make, model and age of the furnace. Therefore, the guideline values will have to be adapted individually for each firing. We recommend running a test firing cycle to evaluate the performance of the furnace used. We have compiled and checked all values and other data with great care. However, we cannot be liable for your results under any circumstances.

When Duceram love is fired onto Ducera press, the firing parameters for the Cervical correction (see Ducera press Instructions for Use) must be applied.

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Firing Instructions for non-precious alloys

Duceram® love – General firing instructions Multimat Touch & Press / Touch & Press 2 / NT / NTpress / Easy

	Pre-heating	Drying	Pre-heating	Vacuum	Heating	Firing	Vacuum	Firing	Tempering	Tempering	Cooling level
	°C	min	min	hPa	°C/min.	°C	min	min	°C	min	
NE-Bond Powder	575	6:00	1:00	50	55	980	0:10	2:00			
NE-Bond Paste	575	8:00	1:00	50	55	980	0:10	3:00			
PO opaque 1+2	550	8:00	1:00	50	100	910	2:00	4:00			
Margin 1	500	4:00	2:00	50	100	880	0:30	1:00	850*	3*	1*
Margin 2	500	4:00	2:00	50	100	860	0:30	1:00	850*	3*	1*
Dentine 1	500	7:00	2:00	50	55	820	0:30	1:30			1
Dentine 2	500	6:00	2:00	50	55	810	0:30	1:30			1
Glaze	500	2:00	2:00	–	55	800	–	0:30			1
Final Shoulder/ Add-On	450	3:00	2:00	50	55	680	0:30	1:00			
Stains	450	3:00	1:00	–	55	660	–	1:00			

CE 0124 * For alloys with a CTE $\geq 14.6 \mu\text{m}/\text{m} \cdot \text{K}$ (25–500°C), shoulder firing must be extended by a tempering phase (3 min/850°C) and a cooling level (level 1).

The firing temperature must be adjusted to the number of units fired. Five to ten units require an increase by 5°C to 10°C; more than ten units require an increase by 10°C to 20°C.

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Firing Instructions for non-precious alloys

Duceram® love – General firing instructions Cergo Press

	Drying	Drying	Closing	Pre-heating	Pre-heating	Vacuum	Vacuum	Vacuum	Heating	Firing	Vacuum	Holding	Tempe- ring	Tempe- ring	Cooling
	°C	min	min	°C	min	cont. on off	on	off	°C/min	°C	min	min	min	°C	min
NE-Bonder	135	4:00	2:00	575	1:00	cont	575	980	55	980	0:00	2:00	–	–	–
NE-Bond Paste	135	6:00	2:00	575	1:00	cont	575	980	55	980	0:00	3:00	–	–	–
Paste opaque 1+2	135	6:00	2:00	550	1:00	cont	550	910	100	910	2:00	2:00	–	–	–
Margin 1	135	1:00	3:00	500	2:00	cont	500	880	100	880	0:30	0:30	3*	850*	6*
Margin 2	135	1:00	3:00	500	2:00	cont	500	860	100	860	0:30	0:30	3*	850*	6*
Dentine 1	135	4:00	3:00	500	2:00	cont	500	820	55	820	0:30	0:30	–	–	6
Dentine 2	135	4:00	2:00	500	2:00	cont	500	810	55	810	0:30	0:30	–	–	6
Glaze	135	0:00	2:00	500	2:00	off	–	–	55	800	–	0:30	–	–	6
Final Shoulder/ Add-On	135	1:00	2:00	450	2:00	cont	450	680	55	680	0:30	0:30	–	–	–
Stains	135	1:00	2:00	450	1:00	off	–	–	55	660	–	1:00	–	–	–

CE 0124 * For alloys with a CTE above $14.6 \mu\text{m} / \text{m} \cdot \text{K}$ (25–500 °C), shoulder firing must be extended by a tempering phase (3 min / 850 °C) and a cooling phase (6 min).

The firing temperature must be adjusted to the number of units fired. Five to ten units require an increase by 5°C to 10°C; more than ten units require an increase by 10°C to 20°C.

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Firing Instructions for non-precious alloys

Duceram® love – General firing instructions ProFire

	Drying	Drying	Closing	Pre-heating	Pre-heating	Vacuum	Vacuum	Vacuum	Heating	Firing	Vacuum	Holding	Tempe- ring	Tempe- ring	Cooling
	°C	min	min	°C	min	cont. on off	ein	aus	°C/min	°C	min	min	min	°C	min
NE-Bonder	135	4:00	2:00	575	1:00	cont	575	980	55	980	0:00	2:00	–	–	–
NE-Bond Paste	135	6:00	2:00	575	1:00	cont	575	980	55	980	0:00	3:00	–	–	–
Paste opaque 1+2	135	6:00	2:00	550	1:00	cont	550	910	100	910	2:00	2:00	–	–	–
Margin 1	135	1:00	3:00	500	2:00	cont	500	880	100	880	0:30	0:30	3*	850*	6*
Margin 2	135	1:00	3:00	500	2:00	cont	500	860	100	860	0:30	0:30	3*	850*	6*
Dentine 1	135	4:00	3:00	500	2:00	cont	500	820	55	820	0:30	0:30	–	–	6
Dentine 2	135	4:00	2:00	500	2:00	cont	500	810	55	810	0:30	0:30	–	–	6
Glaze	135	0:00	2:00	500	2:00	off	–	–	55	800	–	0:30	–	–	6
Final Shoulder/ Add-On	135	1:00	2:00	450	2:00	cont	450	680	55	680	0:30	0:30	–	–	–
Stains	135	1:00	2:00	450	1:00	off	–	–	55	660	–	1:00	–	–	–

CE 0124 * For alloys with a CTE above $14.6 \mu\text{m} / \text{m} \cdot \text{K}$ (25–500 °C), shoulder firing must be extended by a tempering phase (3 min / 850 °C) and a cooling phase (6 min).

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Firing Instructions for non-precious alloys

Duceram® love – General firing instructions Dekema Austromat 3001

NE-Bond Paste	C575 T360 T120 • L9 T60 V9 T055 • C980 V0 T180 C0 L0 T2 C575
NE-Bonder	C575 T240 T120 • L9 T60 V9 T055 • C980 V0 T120 C0 L0 T2 C575
Paste opaque 1+2	C550 T360 T120 • L9 T60 V9 T099 • C910 T120 V0 T120 C0 L0 T2 C550
Margin 1*	C500 T60 T180 • L9 T120 V9 T099 • C880 T30 V0 T30 C0 L0 T2 C500
Margin 2*	C500 T60 T180 • L9 T120 V9 T099 • C860 T30 V0 T30 C0 L0 T2 C500
Dentine 1	C500 T240 T180 • L9 T120 V9 T055 • C820 T30 V0 T30 C0 T360 • L0 T2 C500
Dentine 2	C500 T240 T120 • L9 T120 V9 T055 • C810 T30 V0 T30 C0 T360 • L0 T2 C500
Glaze	C500 T120 • L9 T120 T055 • C800 T30 C0 T360 • L0 T2 C500
Final Shoulder/Add-On	C450 T60 T120 • L9 T120 V9 T055 • C680 V0 T30 C0 L0 C450
Stains	C450 T60 T120 • L9 T120 T055 • C660 T30 C0 L0 C450

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Firing Instructions for non-precious alloys

Duceram® love – Ivoclar Programat 5000

	Pre-Drying	Pre-Drying	Closing	Temp-erature Increase	hold-tempera-ture	hold time	Temp-erature Increase 2. level	hold temperature 2. level	hold time 2. level	hold time Vacuum	Vakuu on Temp. 2. level	Vakuu off Temp. 2. level	long term Cooling	Cool down gradient
	°C	min.	min	°C	°C	min	°C	°C	min	min	°C	°C	°C	°C
			S	tt	T	H	t2t	T2	H2	Hv	V1 2	V2 2	L	tL
NE-Bond/ Powder	450	4:00	2:00	55	575	1:00	55	980	2:00	0	575	980	-	-
NE-Bond/ Paste	450	6:00	2:00	55	575	1:00	55	980	3:00	0	575	980	-	-
PO opaque 1+2	450	6:00	2:00	100	550	1:00	100	910	2:00	2:00	550	910	-	-
Margin 1	450	1:00	3:00	100	500	2:00	100	880	0:30	0:30	500	880	500	40
Margin 1	450	1:00	3:00	100	500	2:00	100	860	0:30	0:30	500	860	500	40
Dentin 1	450	4:00	3:00	55	500	2:00	55	820	0:30	0:30	500	820	500	50
Dentin 2	450	4:00	2:00	55	500	2:00	55	810	0:30	0:30	500	810	500	50
Glaze	0	0	2:00	55	500	2:00	55	800	0:30	0	0	0	500	50
Final Shoulder/ Add-On	450	1:00	2:00	55	450	2:00	55	680	0:30	0:30	450	680	-	-
Stains	450	1:00	2:00	55	450	1:00	55	660	1:00	-	-	-	-	-

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