



**Austromat M**

Cycle	START		↑	↓	VAC Level	↑	END	↓	1 ↓	2 ↓
Info	Starting temp.	Drying time	Closing time	Pre-heating	Vacuum level	Increase Linear	Final temp.	Holding time (V)	1 <sup>st</sup> cooling stage	2 <sup>nd</sup> cooling stage
	°C	min	min	min		°C / min	°C	min	min	min
Paste liner 1	575	6	2	3	9	55	970	1:00	0	0
Paste liner 2	575	6	2	3	9	55	960	1:00	0	0
Shoulder 1	450	3	3	3	9	55	850	1:00	0	0
Shoulder 2	450	3	3	3	9	55	850	2:00	0	0
Dentine 1	450	2	3	3	9	55	830	1:30	0	0
Dentine 2	450	2	3	3	9	55	820	1:30	0	0
Glaze	450	0	3	2	0	55	800	1:00	0	6
Correction	450	0	2	3	9	55	680	1:00	0	6
Final Shoulder	450	0	2	3	9	55	680	1:00	0	6

Slow cooling is mandatory after the last firing; this includes correction firings of restorations after try-in.

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Make sure to follow the Instructions for Use for Cercon ceram® Kiss, where you will find information on indications, contraindications, warnings, precautions and technical specifications.



# Cercon ceram® Kiss – Firing recommendations



## Programat EP5000

	Closing time min:s	Temperature gradient °C	Holding temp. °C	Holding time min:s	Vacuum on	Vacuum off	One-step program	Pre-vacuum	Long-term cooling °C	Cooling gradient	Standby temp. °C
	S	t↑	T	H	V1	V2			L	t↓	B
Paste liner 1	11:00	55	970	1:00	450	969	Yes	–	–	–	450
Paste liner 2	11:00	55	960	1:00	450	959	Yes	–	–	–	450
Shoulder 1	9:00	55	850	1:00	450	849	Yes	–	–	–	400
Shoulder 2	9:00	55	850	2:00	450	849	Yes	–	–	–	400
Dentine 1	8:00	55	830	1:30	450	829	Yes	–	–	–	400
Dentine 2	8:00	55	820	1:30	450	819	Yes	–	–	–	400
Glaze	5:00	55	800	1:00	–	–	Yes	–	500	50	400
Correction	5:00	55	680	1:00	450	679	Yes	–	500	50	400
Final Shoulder	5:00	55	680	1:00	450	679	Yes	–	500	50	400

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[www.kiss-keramik.de](http://www.kiss-keramik.de)

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**DeguDent**  
A Dentsply Company



**Austromat D4**

Cycle	Program type	Standby temp.	Drying	Closing	Pre-heating	Firing temp.			Cooling	Stress relief	VAC (level)
		°C	min	min	°C	min	°C	°C / min	min	min	%
Paste liner 1	Standard	575	6	2	575	3	970	55	1:00		100
Paste liner 2		575	6	2	575	3	960	55	1:00		100
Shoulder 1		450	3	3	450	3	850	55	1:00		100
Shoulder 2		450	3	3	450	3	850	55	2:00		100
Dentine 1		450	2	3	450	3	830	55	1:30		100
Dentine 2		450	2	3	450	3	820	55	1:30		100
Glaze		450	0	3	450	2	800	55	1:00	6	0
Correction		450	0	2	450	3	680	55	1:00	6	100
Final Shoulder		450	0	2	450	3	680	55	1:00	6	100

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# Cercon ceram® Kiss – Firing recommendations



## Programat P90/95

Cycle	Program number	Standby temp.	Heating rate	Firing temp.	Closing time	Holding time	Long-term cooling	Vacuum on	Vacuum off
		°C	min	°C	min	min	°C	°C	°C
	<b>Prg</b>	<b>B</b>	<b>t↑</b>	<b>T</b>	<b>S</b>	<b>H</b>	<b>L</b>	<b>V1</b>	<b>V2</b>
Paste liner 1		450	55	970	9:00	1:00	0	450	969
Paste liner 2		450	55	960	9:00	1:00	0	450	959
Shoulder 1		400	55	850	9:00	1:00	0	450	849
Shoulder 2		400	55	850	9:00	2:00	0	450	849
Dentine 1		400	55	830	8:00	1:00	0	450	829
Dentine 2		400	55	820	8:00	1:00	0	450	819
Glaze		400	55	800	5:00	1:00	450	–	–
Correction		400	55	680	5:00	1:00	450	450	679
Final Shoulder		400	55	680	5:00	1:00	450	450	679

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A Dentsply Company



**VITA Vacumat 6000 MP**

Cycle	Pre-drying temp.	Lifting plate positions	Pre-vacuum	Heating rate	Main vacuum	Firing temp.	Cooling temperature	Lifting plate position
	Pre-drying time	Pre-drying				Holding time	Holding time	
	°C / min	c 100 % b 62 % a 44 %				% / min	C° / min	%
Paste liner 1	575 / 11:00	c 3:00 b 2:00 a 6:00		55 7:10	100 7:10	970 / 1:00	0	
Paste liner 2	575 / 11:00	c 3:00 b 2:00 a 6:00		55 7:00	100 7:00	960 / 1:00	0	
Shoulder 1	450 / 9:00	c 3:00 b 3:00 a 3:00		55 7:16	100 7:16	850 / 1:00	0	
Shoulder 2	450 / 9:00	c 3:00 b 3:00 a 3:00		55 7:16	100 7:16	850 / 2:00	0	
Dentine 1	450 / 8:00	c 3:00 b 3:00 a 2:00	100 / 0:00	55/ 6:54	100 6:54	830 / 1:30	0	
Dentine 2	450 / 8:00	c 3:00 b 3:00 a 2:00		55 6:43	100 6:43	820 / 1:30	0	
Glaze	450 / 4:00	c 2:00 b 2:00 a 0:00		55 6:21	0	800 / 1:00	450 / 0:00	75
Correction (Final Kiss)	450 / 8:00	c 3:00 b 3:00 a 2:00		55 4:10	100 4:10	680 / 1:00	450 / 0:00	75
Final Shoulder	450 / 8:00	c 3:00 b 3:00 a 2:00		55 4:10	100 4:10	680 / 1:00	450 / 0:00	75

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**Zubler Vario Press 300**

	Program type	Starting temp.	Pre-drying	Pre-drying time	Closing time	Homogenizing temp.	Homogenizing time	Heating rate	Final temp.	Holding time	Tempering °C / min	Opening temp.	Opening time	Vacuum	Vacuum release	Vacuum end
Paste liner 1	Professional	575	Yes	6:00	5:00	575	0:30	55	970	1:00	No	970	0:00	Yes	Heating	970
Paste liner 2		575	Yes	6:00	5:00	575	0:30	55	960	1:00	No	960	0:00	Yes	Heating	960
Shoulder 1		450	Yes	3:00	6:00	450	0:30	55	850	1:00	No	850	0:00	Yes	Heating	850
Shoulder 2		450	Yes	3:00	6:00	450	0:30	55	850	2:00		850	0:00	Yes	Heating	850
Dentine 1		450	Yes	2:00	6:00	450	0:30	55	830	1:30	No	830	0:00	Yes	Heating	830
Dentine 2		450	Yes	2:00	6:00	450	0:30	55	820	1:30	No	820	0:00	Yes	Heating	820
Glaze		450	Yes	0:00	5:00	450	0:30	55	800	1:00	No	800	6:00	No	Heating	0
Correction (Final Kiss)		450	Yes	2:00	6:00	450	0:30	55	680	1:00	No	680	6:00	Yes	Heating	680
Final Shoulder (F-SM)		450	Yes	2:00	6:00	450	0:30	55	680	1:00	No	680	6:00	Yes	Heating	680

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