



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
Degunorm Classic Base	Professional	575	Yes	6:00	2:00	575	0:30	55	780	1:00	No	780	0:00	Yes	Heating	780
Paste opaque		575	Yes	6:00	3:00	575	0:30	55	780	1:00	No	780	0:00	Yes	Heating	780
“Improved” paste opaque 1 + 2		500	Yes	6:00	7:00	500	0:30	55	780	2:00	No	780	0:00	Yes	Heating	780
Shoulder 1 + 2		450	Yes	2:00	4:00	450	0:30	55	780	1:00	No	780	0:00	Yes	Heating	780
Dentine 1		450	Yes	2:00	4:00	450	0:30	55	780	1:00	-Tempering: Yes -Tempering temp.: 720 -Tempering time 3:00	780	0:00	Yes	Heating	780
Dentine 2		450	Yes	2:00	4:00	450	0:30	55	780	1:00	No	780	0:00	Yes	Heating	780
Glaze		450	Yes	2:00	3:00	450	0:30	55	770	1:00	No	770	0:00	No	Heating	0
Correction (Final Kiss)		450	Yes	2:00	3:00	450	0:30	55	720	1:00	No	720	0:00	Yes	Heating	720
Final Shoulder (F SM)		450	Yes	2:00	3:00	450	0:30	55	720	1:00	No	720	0:00	Yes	Heating	720

- Tempering for all steps from the 1st dentine firing onwards, including glaze firing for Degunorm eco and Econolloy Au (3 min at 720°C) or long-term cooling.
- No tempering for Degunorm logic.




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

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





Austromat M

Cycle	START		↑	↓	VAC	Heating rate	END	↓	1 	2 
	°C	min	min	min		°C / min	°C	min	min	min
Degunorm classic Base	575	6:00	1:00	1:00	9	55	780	1:00	0	0
Paste opaque 1+2	575	6:00	1:00	2:00	9	55	780	1:00	0	0
Improved" paste opaque 1+2	500	6:00	6:00	1:00	9	55	780	2:00	0	0
Shoulder 1+2	450	2:00	2:00	2:00	9	55	780	1:00	0	0
Dentine 1	450	2:00	2:00	2:00	9	55	780	1:00	3	0
Dentine 2	450	2:00	2:00	2:00	9	55	780	1:00	0	0
Glaze	450	2:00	2:00	1:00	0	55	770	1:00	0	0
Correction (Final Kiss)	450	2:00	2:00	1:00	9	55	720	1:00	0	0
Final Shoulder (F-SM)	450	2:00	2:00	1:00	9	55	720	1:00	0	0

- Observe cooling level 1 (tempering substitute) for all steps from the 1st dentine firing onwards, including glaze firing for Degunorm eco and Econolloy Au (3 min).
- No cooling level 1 for Degunorm logic.

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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
Degunorm classic Base	8:00	55	780	1:00	450	779	Yes	–	0	0	400
Paste opaque 1+2	9:00	55	780	1:00	450	779	Yes	–	0	0	400
Improved” paste opaque 1+2	13:00	55	780	2:00	450	779	Yes	–	0	0	400
Shoulder 1+2	6:00	55	780	1:00	450	779	Yes	–	0	0	400
Dentine 1	6:00	55	780	1:00	450	779	Yes	–	500	50	400
Dentine 2	6:00	55	780	1:00	450	779	Yes	–	0	0	400
Glaze	5:00	55	770	1:00	0	0	Yes	–	0	0	400
Correction	5:00	55	720	1:00	450	719	Yes	–	0	0	400
Final Shoulder	5:00	55	720	1:00	450	719	Yes	–	0	0	400

- Long-term cooling to 500°C for all steps from the 1st dentine firing onwards, including glaze firing for **Degunorm eco** and **Econolloy Au** (3 min at 720°C) or long-term cooling.
- No long-term cooling for **Degunorm logic**.

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Duceragold® Kiss – Firing recommendations



Dekema 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	%	
Degunorm classic Base	Standard	575	6:00	1:00	575	1:00	780	55	1:00	0	0	100
Paste opaque 1+2		575	6:00	1:00	575	2:00	780	55	1:00	0	0	100
Improved" paste opaque 1+2		500	6:00	6:00	500	1:00	780	55	2:00	0	0	100
Shoulder 1+2		450	2:00	2:00	450	2:00	780	55	1:00	0	0	100
Dentine 1		450	2:00	2:00	450	2:00	780	55	1:00	3:00	0	100
Dentine 2		450	2:00	2:00	450	2:00	780	55	1:00	0	0	100
Glaze		450	2:00	2:00	450	1:00	770	55	1:00	0	0	0
Correction		450	2:00	2:00	450	1:00	720	55	1:00	0	0	100
Final Shoulder		450	2:00	2:00	450	1:00	720	55	1:00	0	0	100

- Observe cooling level (tempering substitute) for all steps from the 1st dentine firing onwards, including glaze firing for Degunorm eco and Econolloy Au (3 min).
- No cooling for Degunorm logic.

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DeguDent
A Dentsply Company



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
	Prg	B	t↑	T	S	H	L	V1	V2
Degunorm classic Base		450	55	780	8:00	1:00	0	450	779
Paste opaque		450	55	780	9:00	1:00	0	450	779
Improved* paste opaque		450	55	780	9:00 before start 4:00 min pre-drying	2:00	0	450	779
Shoulder 1 + 2		400	55	780	6:00	1:00	0	450	779
Dentine 1		400	55	780	6:00	1:00	680	450	779
Dentine 2		400	55	780	6:00	1:00	0	450	779
Glaze		400	55	770	5:00	1:00	0	–	–
Correction		400	55	720	5:00	1:00	0	450	719
Final Shoulder		400	55	720	5:00	1:00	0	450	719

- Observe long-term cooling to 680°C for all steps from the 1st dentine firing onwards, including glaze firing for **Degunorm eco** and **Econolloy Au**.
- No long-term cooling for **Degunorm logic**.

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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	%	C° / min	C° / min	%
Degunorm classic Base	575 / 8:00	c 1:00 b 1:00 a 6:00	100 / 0:00	55 3:43	100 3:43	780 / 1:00	0	0
Paste opaque 1+2	575 / 9:00	c 2:00 b 1:00 a 6:00	100 / 0:00	55 3:43	100 3:43	780 / 1:00	0	0
Improved" paste opaque 1+2	500 / 13:00	c 1:00 b 6:00 a 6:00	100 / 0:00	55 5:05	100 6:05	780 / 2:00	0	0
Shoulder 1+2	450 / 6:00	c 2:00 b 2:00 a 2:00	100 / 0:00	55 6:00	100 6:00	780 / 1:00	0	0
Dentine 1	450 / 6:00	c 2:00 b 2:00 a 2:00	100 / 0:00	55 6:00	100 6:00	780 / 1:00	720 / 3:00	100
Dentine 2	450 / 6:00	c 2:00 b 2:00 a 2:00	100 / 0:00	55 6:00	100 6:00	780 / 1:00	0	0
Glaze	450 / 5:00	c 1:00 b 2:00 a 2:00	0	55 6:00	0	770 / 1:00	0	0
Correction	450 / 5:00	c 1:00 b 2:00 a 2:00	100 / 0:00	55 4:54	100 4:54	720 / 1:00	0	0
Final Shoulder	450 / 5:00	c 1:00 b 2:00 a 2:00	100 / 0:00	55 4:54	100 4:54	720 / 1:00	0	0

- Observe cooling temperature and lifting plate level 75 (tempering substitute) for all steps from the 1st dentine firing onwards, including glaze firing for Degunorm eco and Econolloy Au.
- No cooling temperature and lifting plate level 75 for Degunorm logic.

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