



Technical table 003 (GB) Spacer Manufacturing Procedure

1) Fully waxed-up duplicated model

- a) Duplicate the master preferably using an alginate.
- b) The duplicated model can be made of hard conventional plaster.

2) Position of the waxed-up model in the flask

- a) Remove the undercuts from the model
- b) The plaster layer in the mold must be as high as the model and must not cover the clasps.
- c) Tapered feeding channel from 8 to 3.5 mm.
- d) Use plaster-plaster insulation for the flask before making the countermold.

3) Open flask after wax removal

- a) Close the flask and place it on the oven centering device. Tighten the press manually.
- b) Start the melting process to pre-heat the flask.

4) The cast in the flask

5) Spacer placed on the master again.

Pressing® Mod. J-100 must be programmed as follows:

Melting temperature	220 ° C.
Melting time	20 minutes (J-100 Timer 1)
Heating time after injection	02 minutes (J-100 Timer 2)
Cooling time under pressure	20 minutes (J-100 Timer 3)
Injection pressure	04 Bar (J-100)

Remove the flask only at the end of the cycle.

- a) Open the flask when it is at room temperature.
- b) Conventional burrs for acrylic resins can be used for the finishing process.
- c) To enhance polish use "Universal Polish"