

(GB)

1 Duplication

- Duplicate the master model using a type of silicone consisting of two components.
- The duplicated model must be made of a natural precision (non-resinous) plaster, with a resistance to compression of at least 400 kg. per cm².
- Apply on the part to be modelled a thin layer of photopolymerizing varnish UV Abutment and polymerize it, using for example the Complex Lux S-8 equipment for 5 min.

2 Modelling / casting pins (see examples)

- The pin connecting the wax element to the bar must have a 3mm diameter. The bar's distance is 3mm.
 - The feeding bar must have a diameter of 5mm.
 - The melting canals from the muffle mouth to the bar must have a 5mm diameter.
 - Place the feeding bar paying attention to approach the manufactured item as much as possible to the material entrance.

3 Positioning of the model into the muffle base

- a) Use a plaster that can resist compression of at least 400 Kg/cm²
- b) The mould plaster must go beyond 50% of the connecting and feeding pins' height. This is to favour the opening of the muffle after the pressure-injection phase.
- c) Insulate the muffle with a plaster-plaster insulating material of the "Separating Pressing" type before carrying out the counter-mould.

4 Open muffle after wax removal and maintenance of the muffle

- Once the wax has been removed, check that no loose or indented plaster parts remain. During the pressure-injection phase they may be transported into the resin.
- Isolate the muffle using the insulating material "Separating Pressing". When the insulating material has dried, close the muffle.
 - To avoid problems to the screws and obtain a more uniform closing, we recommend the use of a pneumatic screwing device of the type Pressing mod. "Avv."
 - It is important for the muffle temperature to remain at about 500° C until it is positioned on the centering device of the equipment.
 - The muffle has to be positioned on the centering device of the "type with insulating material" only 2/3 minutes before injection.

5 Injection

- When the first Timer indicates 3-4 minutes to injection, take the muffle, always using the gloves, open the equipment's safety door and place the hot muffle on the oven centering device. We recommend using the centering device model with insulating material.
- Tighten well with the manual press, close the safety door.
- Now the equipment has stopped the automatic cycle and will produce a sound, just press the "auto/man" button to resume the cycle.

Caution: it is indispensable that the least possible time elapses between the safety door opening and the pushing of "auto/man" button, less than a minute is usually necessary.

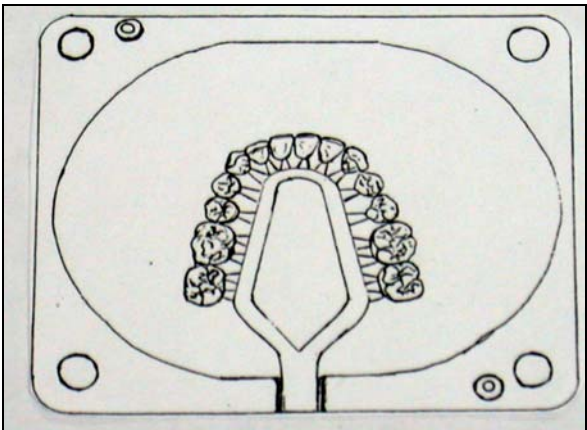
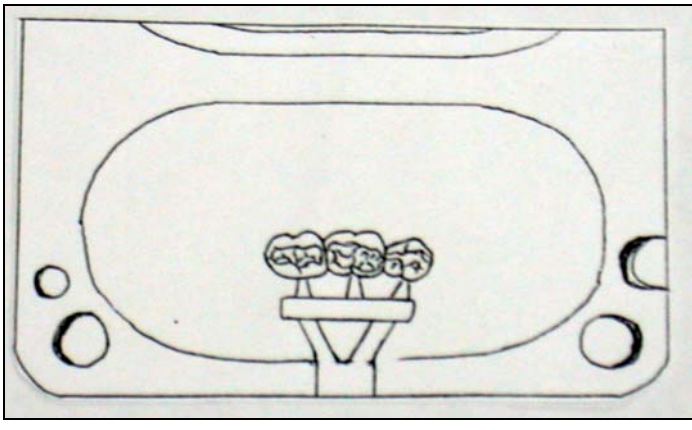
6 Muffle removal

- The muffle can be removed from the equipment only at the end of the cycle, in any case, before opening the muffle, the latter must be at room temperature.
- As for finishing and polishing, refer to the information contained in the instructions for use.

7 Programming the equipment

- Melting temperature	228°C	
- Melting time	10'	(equipment J-100 ref. timer 1)
- Heating time after injection	01'	(equipment J-100 ref. timer 2)
- Cooling time under pressure	35'	(equipment J-100 ref. timer 3)
- Injection pressure	4 Bar	(equipment J-100)
- Injection speed	Tightened screw	(equipment J-100)

Examples of works' positioning in the muffle

	
<p>Ex. Circular working or bite Central 5mm canal 3mm connectors</p>	<p>Ex. Bridge working: 5mm canals and bar 3mm connectors</p>