



Special investment for pressable ceramics and Press to Metal– for use in speed-and overnight technique

Mixing ratio

Powder : Gilvest Liquid 100 g : 25 ml

Mixing of investment powder

- Provide required amount of liquid
- Add the investment powder
- Soak for 10 sec.
- Mix thoroughly for 20 sec.
- Agitate for 1 min. under vacuum
- Maintain vacuum for another 15 sec.

Fill the ring at lowest vibration speed. Once the ring is filled, no further vibration and agitation is performed

Processing

Processing time: > 5 min.
Processing temp.: 19 - 22° C = 66 – 72° F

Wax-up the wax patterns / objects on the base of the pressing cylinder in the usual manner. Lightly coat base of pressing cylinder with Vaseline to ensure pressing cylinder can be removed easily and reliably after investment has hardened.

Liquid concentrate

- 40 – 60 % for Inlays and Onlays, depending on preparation, size and volume
- 60 – 70 % for single / individual crowns
- 70 – 85 % for anterior / posterior bridges

The concentrate figures are for guidance only and can be individually adjusted; higher liquid concentration increase total expansion.

Ring / Muffle Set

- 100 g max. 3 equivalent wax parts
- 200 g max. 5 equivalent wax parts

Speed procedure / process

After investing, allow the 100 g cylinder to harden in atmosphere for 23 – 28 min. and the 200 g cylinder for 25 – 30 min. After removing the plastic base of the cylinder, place it into the preheated furnace / oven already set to a temperature of 850° C.

Warning

Do not open the furnace during heating phase as the wax-steams might catch fire in the air.

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Over night heating

For over night process, liquid concentration should be reduced by 5 – 10 %, depending on ceramic type and application, as the full setting expansion is reached.

Recommended heating rate:
3 - 5° C / min. (37 – 41° F / min.)

In case of putting several rings into the furnace at the same time, increase preheating time by 10 min. for each additional ring.

Recommendation / Warning

Ensure a ground clearance of at least 1 cm between ring and furnace ground.

Final preheating temperature: 850°C (1562°F)

Preheating time: 100 g cyl. – minimum 45 min
200 g cyl. – minimum 60 min

Max. thermal stability: 1200° C (2192° F)

The required press ceramic material is then added to the cylinder and put it into the press oven accordingly.

Cooling and Removing the Cylinder

After the cylinder has cooled down to room temperature, please remove and clean abrasively according to usual techniques for pressable ceramic.

We recommend using 50 – 110 µ Alu-oxide respectively 50 µ glass-beads at 2 - 2,5 bar pressure.

Warning

This investment compound contains quartz and cristobalite. Avoid inhaling dust.

Packaging

100 g pouches

Storage

In cool and dry areas, and well closed, vapor-proof packages. Pay attention to expiry-date.

The above recommendations are given to the best of our knowledge after careful control. We guarantee the quality of our products. Any further liability cannot be accepted since the proper application of our products is outside of our control.