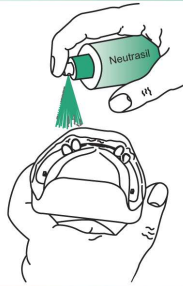




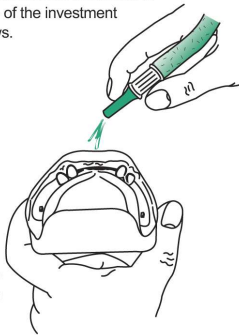
The production of the investment by the SILADENT-SYSTEM

1. Preparing the silicone duplicating mould



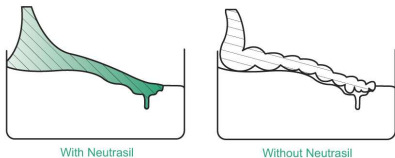
2. Placing the patented duplicating adhesive tape round the mould

The surface of the silicone should be wetted to ensure that the surface of the investment model is free from blows.



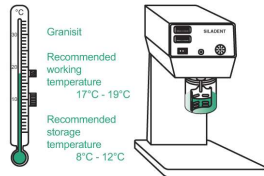
Exception:

It is not necessary to apply wetting agents to HYDROSIL duplicating moulds, because this special silicone has unique hydrophilic properties and produces perfect models without applying wetting agent.



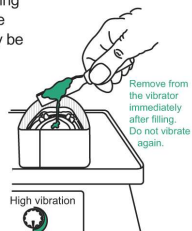
3. Investments for the duplicate model

Mix the investment selected exactly according to the instructions (GRANSIT, MICRO, JET 2000 or PREMIUM). Follow the instructions and advice on storage and working temperatures.



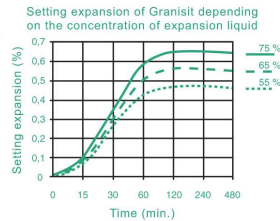
4. Pouring the investment

Place the prepared silicone duplicating mould onto the vibrator and pour the contours using high vibration. It may be helpful to use an instrument when pouring. If required, place the mould under pressure (2.5 – 6.00 bar), following precisely the instructions for using the different investments.



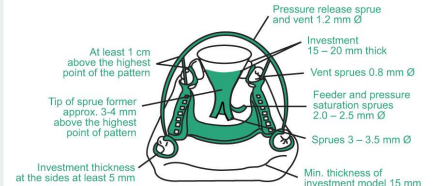
5. Setting expansion

Setting expansion begins after 8 – 12 min. depending on the type of investment used. During expansion, temperatures can reach 85°C.



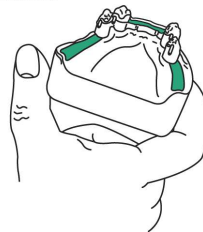
10. Investing diagram

Diagram of model with pressure release and vent sprues.



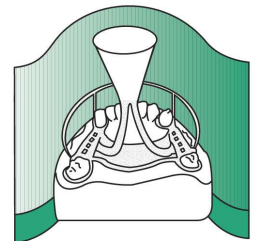
6. Investment duplicate model

The duplicate model can be removed from the duplicating mould approx. 30 min. after pouring. Caution: SILADENT investment models should not be dried in a hot air cabinet or dipped in hardener.



11. Crepe sleeve

Place the patented SILADENT crepe sleeve around the model prepared for investing. Wetting agent is not required.



7. Applying wax adhesive

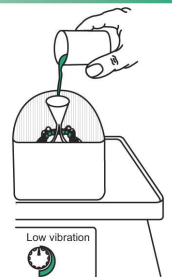
Apply SILADENT wax adhesive 2 – 3 times thinly on areas where preformed wax patterns are to be placed.



12. Investing

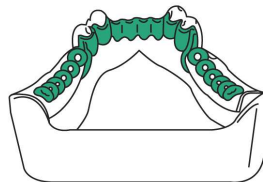
Mix the investment under vacuum according to the instructions and pour using minimum vibration.

Important! Switch off the vibrator immediately after the wax pattern is covered. Do not vibrate again.



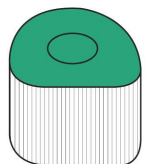
8. Waxing up and attaching sprues

Follow the instructions for attaching sprues in the SILADENT SYSTEM.



13. Speed or conventional preheating

Subsequent handling of the casting ring depends on the investment used. With speed investments, follow the instructions precisely regarding the time for placing the casting ring in the hot furnace. Conventionally preheated investments are placed in a cold furnace, with the sprue former facing down, at least 60 min. after investing and then preheated according to the preheating parameters in the instructions.



9. Trimming the investment model

The investment model can be trimmed (dry) before the crepe sleeve is placed around it.

Ensure that there is a uniform gap for investment of at least 5 mm between the model and sleeve.

