

SuperVest P.C.

Investment for Pressable Ceramic

TECHNIQUE INSTRUCTIONS

Powder to Liquid Ratio

Total volume of solution used is: 100 gm -> 22.5 ml, 200gm -> 45ml
Recommended starting ratio:

A. For the Empress/Leach & Dillon/Finesse Systems

100 gm powder: 13.5 ml special liquid plus 9.0 ml water
200 gm powder: 27.0 ml special liquid plus 18.0 ml water

B. For the OPC/Empress II Systems

100 gm powder: 15.0 ml special liquid plus 7.5 ml water
200 gm powder: 30.0 ml special liquid plus 15.0 ml water

To increase expansion, use more special liquid and less water. to get less expansion, use less special liquid and more water. Keep the total volume of the solution constant.

Mixing Instructions

For best results liquid and powder temperature should be between 24 - 27 °C (75 - 80 °F). **At slow speed (200 - 500 rpm) mix under vacuum for 90 seconds**, (if mixing more than 200gm at a time, then mixing time should be more than 90 seconds) then invest - no need to vibrate or hold in vacuum.

Vibrate the investment into paper ring using a sable brush to paint critical areas, then completely fill ring with remaining investment and place trim gauge on top of paper ring pushing investment through hole.

Burnout

Bench set for 30 minutes. After removing paper ring and trim gauge, immediately place mold into a pre-heated oven at 1565 °F, and hold at that temperature for 30 minutes, then begin normal pressing cycle.