Investment material for 3D - Instructions

Investment - 3D is a phosphate-bonded, graphite-free investment specially for 3D-Print and light curing modelling resins.

Mixing ratio:	100gr Powder : 24ml Liquid 150gr Powder : 36ml Liquid
Working time:	approx. 5 min.
Working temperature:	19 °C
Mixing advices:	Pour the investment into the same bowl. Mix manually for 20-30 seconds, then place in a vacuum mixing unit and mix for 1 minute.
Setting time:	approx.. 20 min.
Pre-heating:	900 °C
Standard values for the Liquid Concentration:	see concentration table.

Pre-heat / Burnout

Conventional Heating (with holding stages)

Fill casting ring with investment and allow to set. Allow the ring to cool to room temperature.

Roughen the outer surfaces of the muffel and place in a cold furnace.

Depending upon muffel size, allow to heat for 20-30 minutes at 250°C.

Heat the furnace at a constant rate to final temperature.

Allow the muffel to heat for a further 30-60 minutes.

Store investment powder always cool and dry.

This investment powder contains quartz and cristobalite. Invoid inhaling the dust!

Guarantee
All recommendations regarding the handling are based on our own experiences and tests. Therefore they may only be taken as guide values. Our products are subject to a continuous advancement. Construction and composition are subject to alteration. Our information and recommendations are subject to the current state of the scientific and technical knowledge and are to our knowledge and experiences presently to be seen as correct. The forthcoming version replaces all former

Concentration table 3D

Casting

Mixing ratio: 150g : 36ml

Objects Alloy	Inlay 3 surface	C + B	other telescope	Tap.Crowns 6°	partial denture
Precius >70% Au	18ml Liquid 18ml Aqua dest.	18ml Liquid 18ml Aqua dest.	14ml Liquid 22ml Aqua dest.	14ml Liquid 22ml Aqua dest.	
AU reduced <55% for ceramics	20ml Liquid 16ml Aqua dest.	20ml Liquid 16ml Aqua dest.	16ml Liquid 20ml Aqua dest.	16ml Liquid 20ml Aqua dest.	
Palladium based Alloys	24ml Liquid 12ml Aqua dest.	24ml Liquid 12ml Aqua dest.	20ml Liquid 16ml Aqua dest.	20ml Liquid 16ml Aqua dest.	
NPA		36ml Liquid			18 ml Liquid 18 ml Aqua dest.