

# Instruction for use press-ceramic LS2

This press-ceramic investment material is phosphate-bound, carbon-free and dust-reduced. It covers the entire press technology, **including lithium disilicate**. This investment compound can be used both for the quick casting process and for conventional preheating.

## Processing instructions / product data

### Mixing ratio:

100gr. Powder: 22ml Liquid

Expansion see table

Processing time:

ca. 5 min

Beginning of solidification:

after 9 min

Compressive strength:

ca. 5 to 15 MPa

### Processing:

First, add the required amount of investment into the beaker. Afterwards the corresponding liquid, with appropriate concentration, and spat for 30 seconds by hand. Then stir in the vacuum mixer for 60 seconds.

### Preheating / Burnout

#### speed heating

- Embed press object and allow it to harden for at least 20 minutes (after contact liquid with powder!)
- Roughen the muffle surface and place in the oven heated to the final temperature (Max. 850 ° C).
- Leave the muffle, depending on the size, for 30 to 90 minutes at the final temperature.
- Please observe the manufacturer's data for the press pellets.

#### Conventional heating

At the end of the setting time, place the investment ring to be pre-heated in the cold furnace ("cold" meaning less than 100 °C (212 °F)). Depending on the type of furnace used, a program with a heating rate of 7 °C/min (45 °F/min) will be started with the following holding levels and holding times (depending on the size of the investment ring):

- 1st holding level, 45–60 min at 270 °C (518 °F) (cristobalite transition)
- 2nd holding level, 30–60 min at 580 °C (1076 °F) (quartz transition)
- 3rd holding time at final temperature (850 °C / 1562 °F):

100g investment ring = 45 min

200g investment ring = 60 min

### Concentration table

#### 100 / 200 gr Powder – 22 ml / 44 ml Liquid

	100gr – Liquid / Aqua dest.	200gr – Liquid / Aqua dest.
Inlay 3-surface	10 ml / 12 ml	20 ml / 24 ml
Inlay 1-surface	8 ml / 14 ml	16 ml / 28 ml
crown	13 ml / 9 ml	26 ml / 18 ml