



Phosphate-bonded, graphite-free investment material for the entire alloy range of the crown and bridge technique.

Processing temperature

Powder and liquid approx. 21 °C

Mixing ratio

100 g powder : 24 ml Gilvest Liquid

Mixing time

Spatulate powder and liquid vigorously for approx. 20 sec., then stir for 45 sec. under vacuum and vibrate for approx. 10 sec.

Working time approx. 6 minutes

Curing time 45 - 60 minutes
depending on the size of the investment ring

Gilvest EHT Superfine can also be cast ringless.

Preheating

Place the investment ring in the cold furnace after curing. At 290 °C and at 580 °C, a holding time of 45 - 60 min. is required, depending on the size and number of the investment rings. The alloy-dependent final temperature must also be held for 45 - 60 minutes.

Heating rate

maximum 7 - 9 °C/min. with linear furnace control.

Maximum final temperature 1050° C.

Pour quickly, avoid casting delays!

Devesting

after cooling to room temperature.

Expansion control through Gilvest Liquid

The higher the proportion of **Gilvest Liquid** in the total mixing liquid the higher

the expansion value of the investment system.
Only dilute **Gilvest Liquid** with dist. Water.

Expansion values related to a liquid concentration of 100 %.

Setting expansion	approx. 1.4 %
Thermal expansion	approx. 1.3 %
Total expansion	approx. 2.7 %

For higher expansions, use our **Gilvest Liquid concentrated** or **Liquid G**.

Special hints

This phosphate-bonded investment material must not come into contact with plaster or investment materials containing plaster. Use separate mixing tools!

If the wax pattern is treated with a wax surface relaxer, it must be completely dry before investing. Do not blow with dry air.

Attention

This investment contains quartz and cristobalite. Avoid inhalation of dust!

Packaging

Carrying carton with foil insert	20 kg
Portion bag	160 g
Bag	4 kg

Storage

In well-sealed, moisture-proof containers. Observe the end use date on the containers!

The above information is given to the best of our knowledge and after careful examination. They correspond to the current state of the art. We guarantee the flawless quality of our products, but are not liable for further processing results, which usually occur outside our sphere of influence.