



## Quick-casting embedding compound for model casting system – framework (also usable for overnight technique)

### Mixing ratio

For silicone:

100 g powder : 20 ml Gilvest

Liquid For gel dubbling:

100 g powder : 18 ml Gilvest Liquid

### Processing

- Provide requisite amount of Liquid
- Pour in the powder
- Mix thoroughly for 20 seconds.
- Mix for 1 minute under vacuum.
- Maintain the vacuum for another 10 seconds

Adjust the mould to the lowest agitation setting while filling it. Once the casting muffle has been filled, no further agitation is performed.

Working time approx. 5 minutes

Setting time max. 9 minutes

Processing temperature 21°C (70°F)

Different processing temperature can have a negative impact on the product properties.

**Overbedding could be made with dest. water.**

### Speed procedure

#### Preheating

25 - 30 minutes after filled up the mould, it can be placed into the oven, which can be preheated up to 1000°C. Based on melting-ranges of nearly all suitable NP-Alloys, we recommend selecting preheating temperatures of 900-940°C. Hold the final temperature, recommended for the alloy for at least 1 hour.

### Important

In case of ovens with floor heating, make sure

there is sufficient clearance (approx. 1 cm) between the mould and the floor plate

### Liquid concentration for model preparing:

- 50 - 65 % regulare frame work
- 65 - 75 % combination frame work depending on the size and extension of jaw
- 85 – 100 % combination frame work in one piece casting process

The concentrate admixture figures are for guidance only-they depend on the type of alloy involved.

### Over night technique

Due to the long heating time over night the liquid concentration should be reduced by 5% to 10%, according to alloy and application, as the full setting expansion is reached.

### Burnout

After hardening place the mould into the cold oven. At 280 °C and 580 °C the temperature should be maintained for 45 - 60 minutes, depending on the size and the number of the moulds.

Hold the final temperature, recommended for the alloys, 30 - 45 minutes.

# GILVEST MG SPEED



  
Dental

**Heating rate** app. 3 - 7 °C/min

**Maximum temperature** 1050 °C

Cast without delay.

## Packaging units

Portable cartons with foil liner 20 kg

Pouches 400 g and 5 kg

## Warning

This embedding compound contains quartz and cristobalite. So avoid inhaling the dust!

**Do not open the oven during the heating-phase as the arisen wax-steams might catch fire in the air.**

The recommendations are given to the best of our knowledge. We grant the quality of our products according to our specification. Any further liability cannot be accepted since the proper application of our products is outside of our control.