

## Instructions for use

anaxvest PM is a phosphate-bound, graphite-free speed investment for the press, crown and bridge technique. It may only be used in the dental field and by accordingly trained staff.

### Instructions for metals

Line the mold ring with mold liner with a thickness of 1mm and a height of 55 mm:

**Mold size 3** – one layer

**Mold sizes 6 or 9** – two layers

Adjust the mold liner at the bottom of the mold.

For 150g of powder you need 36 ml of liquid.

1. Fill the liquid-water mixture into the mixing bowl
2. Add powder
3. Start the timer
4. Carefully spatulate the investment by hand
5. Pre-evacuate the investment for 15 sec
6. Mix for 2 min. under vacuum (no more than 380 rpm, a higher mixing speed reduces the processing time)
7. Keep the bowl under vacuum for 5 more sec. after the mixing process
8. Pour the investment into the mold using a vibrator and possibly an instrument
9. From the time of adding powder to liquid, you have 5 minutes for processing

### Speed method

10. Let set free of vibration for 30 to 35 min. before removing the plinth (the mold must be handhot)
11. Place it into the heated and clean preheating furnace with the opening looking downwards (set the temperature as required for the alloy)
12. In case of several molds, allow a time-lag of 10 min. before placing the next mold

### Delay

mold size 3	50 min.
mold size 6	60 min.
mold size 9	80 min.

### Regular heating

#### Wax/modelling acrylic

Place the cured mold into the cold furnace to cast out the wax or acrylic and for drying. Use a heat rate of 5–9°C. Heat up to 270°C (cristobalite inversion); hold for 30–60 min. depending on the size and number of the molds. Continue heating to 580°C (quartz inversion); hold for 30–60 min., heat up to the final temperature as defined by the alloy manufacturer. Please do not exceed 950°C! After casting, let the mold cool down to handhot, then divest.

### Divesting

Roughly sandblast with aluminum oxide (50 µm), at 1,5–2 bar; then expose and fineblast the pressed objects with glass polishing beads (70 µm) at 0,9–1,5 bar.

All investments suitable for dental laboratories contain quartz/cristobalite. If inhaled, these substances may harm the health of the user. Therefore, please water the mold before divesting. All specifications (powder/liquid) given refer to processing conditions at a room temperature of 22 °C! Constant results can only be achieved if powder and liquid are stored at a **constant temperature of 22 °C**. Please protect the liquid from freezing.

**Total expansion 2,7–3,2 %**

### Liquid concentration for metals

**Crowns and bridges** (all specifications in ml for 150g):

High-noble ceramic alloy	<b>15 ml</b>	(40 %)
Noble ceramic alloy	<b>15 ml</b>	(40 %)
High-noble casting alloy	<b>9–10 ml</b>	(25–28 %)
Noble casting alloy	<b>10 ml</b>	(28 %)
Non-precious alloy with HiEx liquid	<b>34–36 ml</b>	(95–100 %)

**Tele and double-crown technique** (all specifications in ml for 150g):

#### High-noble/Noble casting alloy

Wax-up 0° short die	<b>5 ml</b>	(15 %)
Wax-up 0° long die	<b>9 ml</b>	(25 %)
Wax-up 2°	<b>7 ml</b>	(20 %)
Wax-up 4°	<b>6 ml</b>	(17 %)
Wax-up 6°	<b>4 ml</b>	(11 %)

Deep-drawn coping 0° short die	<b>18 ml</b>	(50 %)
Deep-drawn coping 0° long die	<b>22 ml</b>	(60 %)
Deep-drawn coping 2°	<b>18 ml</b>	(50 %)
Deep-drawn coping 4°	<b>11 ml</b>	(30 %)
Deep-drawn coping 6°	<b>6 ml</b>	(17 %)

#### Non-precious alloys with HiEx liquid

0°, 2°, 4°, 6° **33–36 ml** (92–100 %)

*Please note:*

*The processing recommendations are based on reference values gained at our test lab and, thus, still require an individual, own adaptation.*

*anaxvest PM should be used within two years after production.*



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### Instructions for press ceramic

100 g of powder require a total liquid amount of 24 ml.  
200 g of powder require a total liquid amount of 48 ml.

1. Fill the liquid-water mixture into the mixing bowl
2. Add powder
3. Start the timer
4. Carefully spatulate the investment by hand
5. Pre-evacuate the investment for 15 sec
6. Mix for 2 min. under vacuum (no more than 380 rpm, a higher mixing speed reduces the processing time)
7. Keep the bowl under vacuum for 5 more sec. after the mixing process
8. Pour the investment into the mold using a vibrator and possibly an instrument. From the time of adding powder to liquid, you have 5 minutes for processing.
9. Setting time 30 – 35 min. (mold must be handhot). Keep the mold vibration-free during this time!
10. Remove the ring sleeve and plinth 1 min. before the end of the setting time
11. Trim the mold and make sure that the platform is level
12. Place it into the clean preheating furnace heated to 850°C with the opening looking downwards
13. In case of several molds, allow a time-lag of 10 min. before placing the next mold
14. After preheating, you can start pressing
15. Cooling grids are suitable to cool the mold

### Delay

100 g – mold	50 min.
200 g – mold	60 – 90 min.

### Divesting

Roughly sandblast with aluminum oxide (50 µm), at 1,5–2 bar; then expose and fineblast the pressed objects with glass polishing beads (50 µm) at 0,9–1,5 bar. All investments suitable for dental laboratories contain quartz/cristobalite. If inhaled, these substances may harm the health of the user. Therefore, please water the mold before divesting. All specifications (powder/liquid) given refer to processing conditions at a room temperature of 22°C! Constant results can only be achieved if powder and liquid are stored at a constant temperature of 22°C. Please protect the liquid from freezing.

**Total expansion 2,7 – 3,2 %**

### Liquid-concentrations for ceramic

#### Crowns, veneers, partial crowns, inlays (3-surface) 50 %

100 g of powder: 12 ml liquid + 12 ml distilled water  
200 g of powder: 24 ml liquid + 24 ml distilled water

#### Crowns, veneers, partial crowns, inlays (3-surface) 55 %

100 g of powder: 13 ml liquid + 11 ml distilled water  
200 g of powder: 26 ml liquid + 22 ml distilled water

#### Inlays (1–2 surface) 55 %

100 g of powder: 13 ml liquid + 11 ml distilled water  
200 g of powder: 26 ml liquid + 22 ml distilled water

#### Inlays (1–2 surface) 60 %

100 g of powder: 14 ml liquid + 10 ml distilled water  
200 g of powder: 28 ml liquid + 20 ml distilled water

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