



# WordPress

**-Instruction for Use-**

## Storage

- **JP Vest** powder and liquid should be stored in a dry place at temperatures between **19-23Deg C**
- The liquid is sensitive to freezing and should not be stored below 5degC.
- Please dispose and use a new bottle if exposure to low temperatures has been suspected.

## Working Temperature

- Investing should be carried out at temperatures of **19-23degC**.
- Great variations in working temperatures can have significant effects on Working time and expansion.

## Powder to Liquid ratio

**14ml liquid + 10ml Deionised Water /100g of Investment**

Note – the supplied liquid needs to be diluted as required using deionised water. A concentration of 58% (14 liquid:10 water) is recommended as a starting point for muffles between 100-200g scale. Please ensure that all liquids used are at **19-23degC**.

## Spruing Technique

- Try to keep a space of at least 3mm between objects
- Avoid exceeding 2 objects on 100g muffles and 4 objects with 100g muffles (3 part Bridges deemed at 2 objects)

## Investing Procedure

- Hand mix the Powder/liquid mix for 30-45 seconds prior to machine mixing (mixture may be quite viscous at first but will become more fluid throughout mixing).
- Mixing time (Vacuum mixer) – **2.5 minutes** @ 300-400 RPM
- Investing – Gently vibrate the ring using a dental vibrator avoiding excessive movement
- Working time – 6-7 minutes (at Room Temperature)
- Set time – 9-11 minutes (at Room Temperature)
- Allow to stand for 30minutes prior to speed heating (measured from start of liquid addition).  
*Note – use of higher liquid concentrations will result in working times and set times at the longer end of the specified ranges*
- The investment may be removed from the silicone ring and sprue former after 20mins and further drying allowed uncovered for the remaining 10min bench set time.

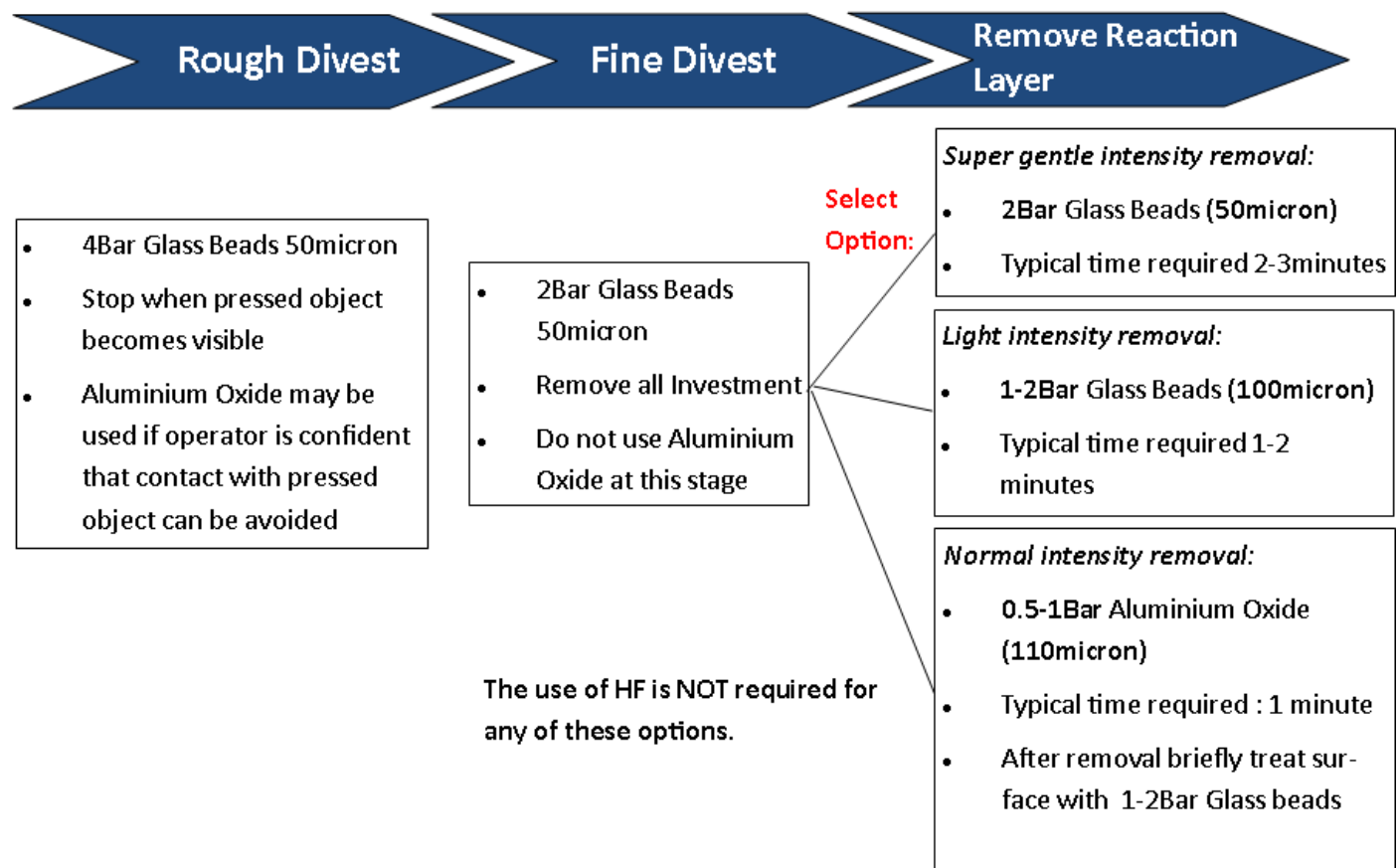
## Burnout

- Preheat temperature of burnout furnace should be at **850 Deg C**
- Please follow the manufacturer's instructions for Ingot and Plunger pre-heat requirements and procedure.
- Place Investment muffle into the burnout furnace at 850 Deg C.
- Once 850 Deg C has been reached again, a **Hold Time of at least 45minutes should be applied for 100g investments**
- Transfer from Burnout furnace to Pressing Furnace must not take longer than 30seconds to avoid excessive temperature drop (cracking may occur below 650deg C)  
*Note – for larger investments of 200g, please increase the minimum hold time to 60minutes.*

## Pressing Procedure

-Please follow the Ingot and Press Oven manufacturer's procedure-

## Divesting



Note – final treatment with low pressure Aluminium Oxide followed by Glass beads affords a smoother surface but can affect the fit if carried out on inside of crown. Please use as per preference.

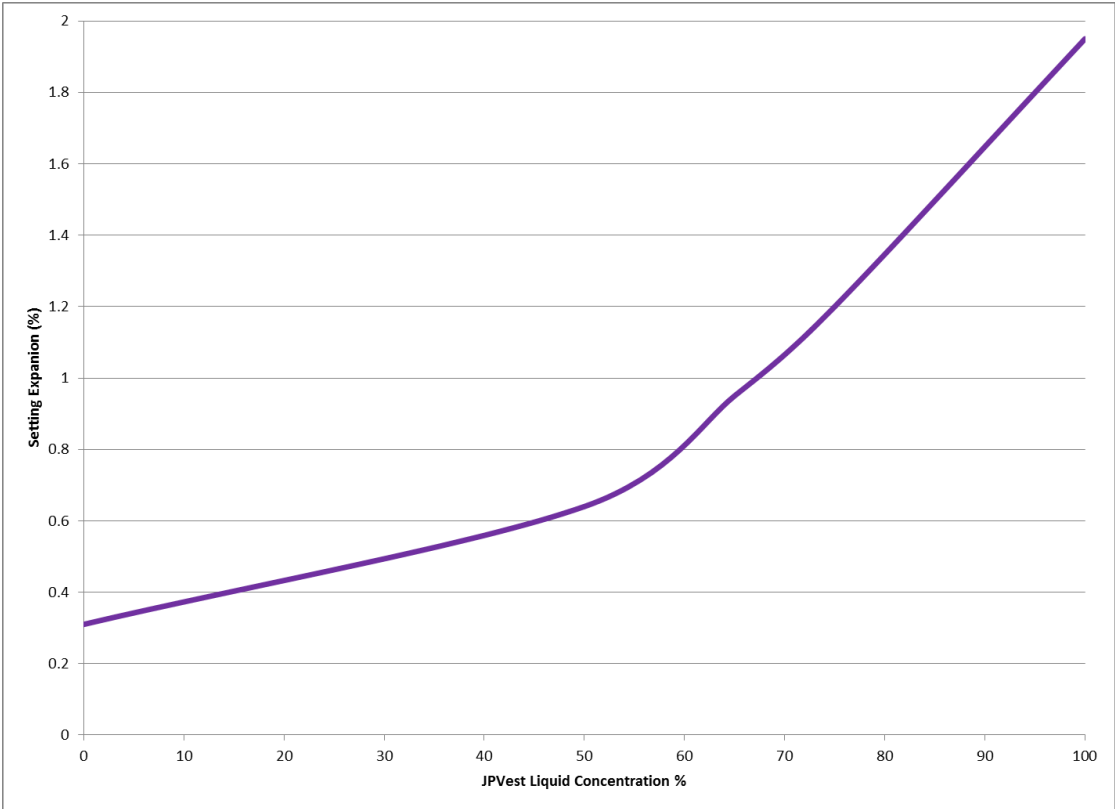
## Typical setting expansion results at 20°C:

Setting Expansion %	0.86
Working time (mins)	7
Set Time (mins)	10

- This product has not been fully tested with debubblers and the use of these should therefore be avoided in case of any unforeseen interactions.
- Please ensure that all mixing equipment is dry and decontaminated prior to use
- The supplied liquid should be diluted with deionised water at 19-23degC prior to use.
- This investment material contains quartz powder and inhalation should be avoided.
- Where supplied, examine the Freeze Indicator for a distinctive purple colour – if this is the case, the liquid may have frozen during transit or storage and should not be used.**

# Expansion Data:

Setting Expansion vs JPVest Liquid concentration:



Thermal Expansion at 50% liquid concentration (total- 1.1%):

