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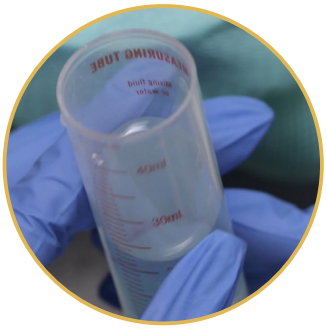
Phosphate-based investment material for ceramic press

Amber® Vest

User's Manual

HASS | Human-Aid System Supplier

Working instructions



1. Liquid/Cylinder Preparation

2. Preparation for Mixing

3. Mixing

4. Filling the cylinder

5. Working Time

6. Burn out

SCAN ME! >>

Video Tutorial
by Anna Dimitriou, Greece

Pressing Process
by HASSBIO

1. Liquid/Cylinder Preparation

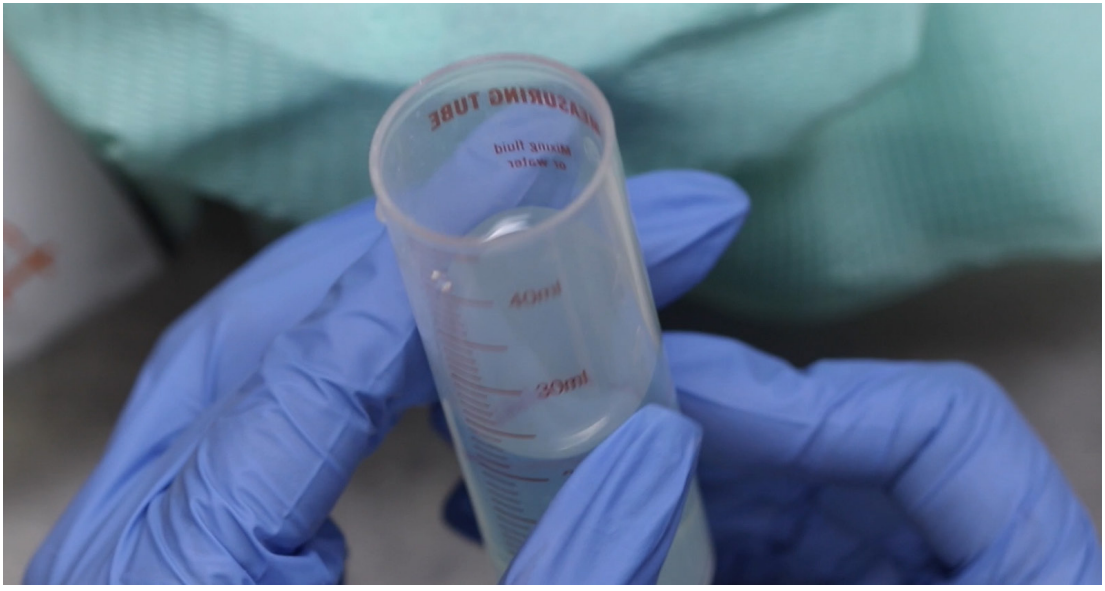
% Concentration of mixing liquid

Indication	Liquid (EXPANSOR–B)	Distilled water
Inlays	13 ml (50%)	13 ml (50%)
Veneers	15.6 ml (60%)	10.4 ml (40%)
Crowns	18.2 ml (70%)	7.8 ml (30%)

IMPORTANT:

Amber® Vest must always be used with its special mixing liquid EXPANSOR-B, pure or diluted. The dilutions can be effected by adding distilled or demineralised water, shaking slightly and then applying to the bottle an identifying label of the concentration made.

⚠ DO NOT USE EXPANSOR LIQUID WHICH HAS BEEN FROZEN. (BECOME CRYSTALLISED)

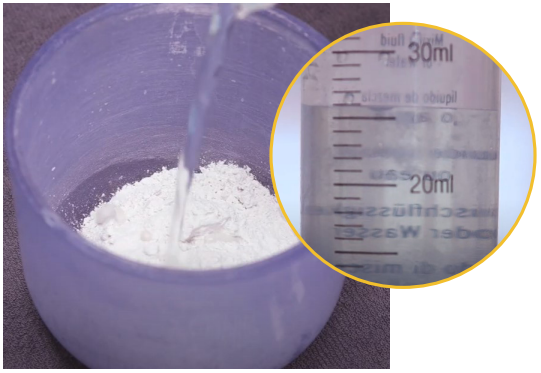


2. Mixing

- To obtain good results, it is essential to use the precise measurements.
- For greater ease of use, Amber Vest is supplied in predosed sachets of 100g, and a dosing tube is supplied for the liquid.
- It is always recommended to use whole sachets and to measure the liquid with the original dosing tube.
- In the case of using non-pre-dosed portions of powder, weigh the exact contents with a scale.

The powder liquid ratio
100g powder : 26 ml liquid

⚠ DO NOT USE BOWLS NEITHER CONTAINERS
WHICH HAVE BEEN IN CONTACT WITH PLASTER.



- Prepare the liquid EXPANSOR-B according to the concentration required (as indicated above).
- Add the powder to the liquid and mix vigorously by hand to obtain a totally moist and uniform mass.
- Then pass to mechanical **vacuum mixing for 60 seconds** depending on the mixer.

3. Filling the cylinder

· Before filling the cylinder, apply a degreasing agent or wax cleaner with a spray or a brush uniformly and dry for a few seconds. It may allow a better adherence and flows of the investment.
· **When the mixing time is completed, fill the cylinder, vibrating gently, for 10-15 seconds, then stop.**

4. Working Time

6-7 minutes (20-22°C) from the moment that powder and liquid contact.
The working time can be reduced:
· When the liquid is at a higher temperature
· With ambient temperatures above 22°C
· With the use of contaminated utensils

5. Burn out

Heating can be carried out in two different ways.

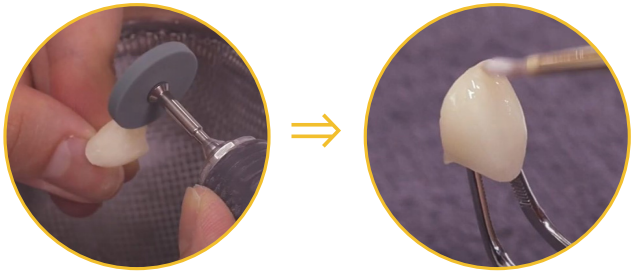
5-1. Rapid burn out

1. Before investment, preheat the ring furnace to the final temperature.
2. Proceed with the investment process.
3. Place the ring in the ring furnace 20-30 minutes after the investment, before it reaches the final temperature. Press at the final temperature (850°C)
   * **Caution: the furnace temperature may vary depending on the brand and environmental conditions.**

5-2. Standard burn out

1. After allowing the cylinder to settle at room temperature, place it in the furnace and maintain a temperature of 250°C for 40 minutes.
   * **Caution: for a safer procedure, it is recommended to anchor the temperature at 500°C for approximately 30 minutes.**
2. Gradually increase the temperature to the final target casting temperature at a rate 7°C/ min.

6. Final Result



Sprue cutting

Stain and Glaze firing

PACKAGE

Packing: Export standard box
GW. 6kg [37 x 28 x 26(cm)] **/ 1kit**

1 kit

Powder
5 kg
(100g x 50ea)
KIT POWDER

+

Liquid
1 L
EXPANSOR-B

+

Cylinder
1ea

* HS Code: 3407.00
* Classification: Type1, Class2

Human-Aid
System Supplier

Manufacturer

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