

HS-PC™ Investment

INSTRUCTIONS
FOR USE

FOR INLAYS AND ONLAYS
USING THE MICROSTAR INLAY MAKER™ OR FLEX RING

PHYSICAL PROPERTIES

| | |
|--------------|--------------------------|
| Mixing Ratio | 100g powder to 25mL liq. |
| Mixing Time | 60 seconds |
| Working Time | 3 - 5 minutes |
| Setting Time | 14 - 15 minutes |

LIQUID + WATER RATIO (mL)

| | LIQUID | WATER |
|-----------------------|--------|-------|
| Pressed Ceramic Inlay | 7.5 | 17.5 |

(This is a 30% liquid to 70% water ratio for minimum expansion)



MIXING INSTRUCTIONS

Pour the liquid into damp mixing bowl. Add powder and mix by hand with spatula. Apply vacuum to bowl for 20 seconds without spatulation. Mix for 60 seconds with vacuum and then vibrate for an additional 15-20 seconds. Adapt the investment on the clean, dry wax object with a fine instrument. Fill up ring and vibrate carefully until all wax patterns are covered. Place the leveling top on the ring to push out any excess investment.

RUSH TECHNIQUE

If using the Inlay Maker™, bench set for 15 minutes. Then remove the invested ring and let set for another 30 seconds, before placing into the center of a preheated oven at 1600°F. Burn out for 45 minutes if using 100g Inlay Maker; burn out for 60 minutes if using 200g Inlay Maker.

If using a silicone flex ring, bench set 14 minutes. Then remove the invested ring and let set for another two minutes, before placing into the center of a preheated oven at 1600°F. Burn out for 45 minutes if using 100g ring; burn out for 60 minutes if using 200g ring.

Note: The bench set times above are critical! The concept is to put a hot ring in a hot furnace. This minimizes expansion. If you go beyond the recommended bench set time, the ring will have cooled off too much to be put into the hot furnace. The longer the bench set time, the more expansion you will get.

ADJUSTING EXPANSION

To INCREASE expansion, use more liquid and less water. If still more expansion is needed, increase mixing time by 10-15 seconds. Never decrease liquid ratio below 30%. Be sure to keep the total amount of mixing liquid the same at 25mL per 100g.

See <http://www.jensendental.com/> or call your Jensen sales consultant for additional information about using the Microstar® Inlay Maker.™