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In order to understanding about investment casting, we make the operation brochure of dental casting process. Your valuable opinions and suggestions will be more than welcome.

Preparation before casting

1. Clear the job after remove from platform, put in isopropanol and slightly shake it, let it naturelly dry or blow it with cool air.
2. Post curing if it is nessecory (not more than 1 min).

1. Plant Wax Tree

- 1) Remove unnecessary support and clean again.
- 2) Then install sprue wax and make it as tree with maximum 32 teeth, place the tree in the middle of flask, the interspace between tree and flask will be $>5\text{mm}$.



2. Filling flask

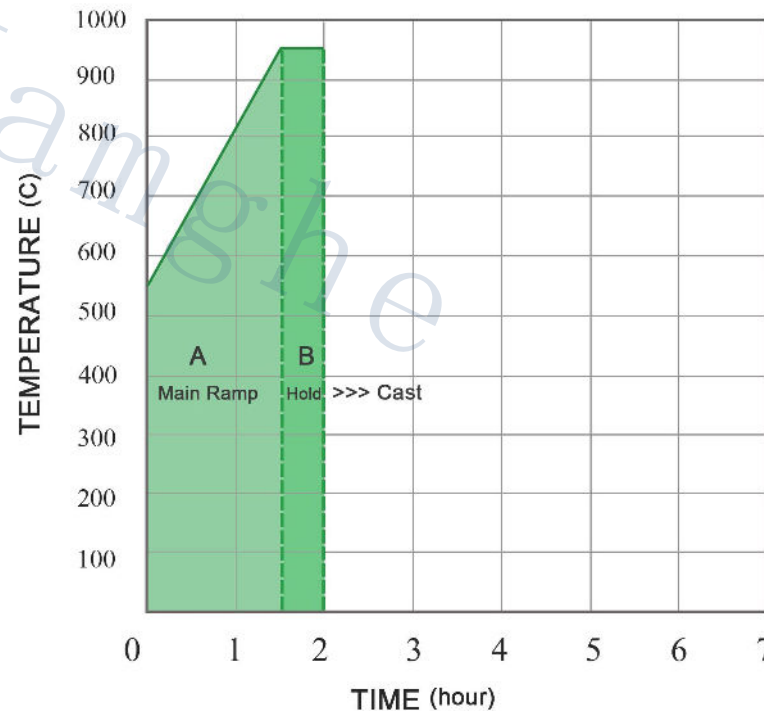
- 2.1 Use vacuum stirring machine, mix the gypsum with liquid according the instruction.
- 2.2 Avoid filling on jobs straightly and try to reduce bubbles when pouring in.

Notice: Use gypsum powder that special designed for dental.



3. Burnt out

Put in furnace at 550°C, set one and a half hours from 550 °C to 950 °C (adjust the duration according the power of furnace), hold for half hour and then can be cast.



4. Casting

Dental Centrifugal casting with traditional melting method, which require engineer has inabundant experience.



5. Divesting

Cooling naturally, break it and take out the jobs,
and then apply sand blasting.



Our dental resins are medical class 1 approved, for customized photopolymer resins, be free to reach us.

Dental Casting Resin	MU-2000(Green)	ME-2000 (Green)	MC-2000 (Green)	MS-2000 (Green)
Surgical Guide Resin	//	GTE-10 Clear	DB-06 Clear	//
Teeth Model Resin	//	Prosthodontic DNE-19-02 (Skin)	Prosthodontic DNC-19-02 (Skin)	//
		Prosthodontic DNE-00 (Yellow) Orthodontic PJHC series		//
	//			//
Gingiva Mask Resin	//	GE-82 Red	GC-81 Red GC-82 Pink	//