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CHROMECAST-XF

CHROME PARTIAL INVESTMENT

Water Mix Phosphate

Instructions for use

CHROMECAST is a hard high-heat casting investment for casting partials with cobalt-chromium dental alloys. It can also be used for other castings in gold palladium, platinum and non-precious alloys when it is used with the special liquid. The selective use of special liquid provides controlled expansion required for other applications such as Crown & Bridge castings.

1. Properties At 100% Liquid:

Liquid to Powder Ratio: 24/100 - 25/100

Working Time: 4to 6minutes

Setting Time: 7 to 10 minutes

Setting Expansion: 0.2%

Hygroscopic Expansion: 0.5 %

Compression Strength at 60 minutes: 1500 PSI

The temperature of the mixing fluid (water or special liquid) should be between 18 and 22 degree C. Colder fluid temperature will increase working time. Warmer temperatures will shorten the working time. On very hot days refrigerate the liquid but do not freeze.

2. DIRECTIONS

Duplicate master model using a suitable duplicating material. Use a good quality duplicating material to avoid rough model surfaces .

MODEL

Mix water and the special liquid in desired proportions to obtain proper expansion for the casting alloy. Generally, a mix of 50% liquid and 50% water would provide adequate expansion and a smooth model.

Mix 14 ml liquid with 100 grams powder for 30 to 60 seconds under full vacuum with a low speed mechanical mixer (300 to 450 rpm). Pour the mix into the duplicating material under gentle vibration. Allow the investment to set and become hard for about one hour before separating the model from the duplicating material. Use reverse spruing through the model using sprues of appropriate length and diameters. This will eliminate necessity of cutting through the hard investment.

Dry model in oven at 200 to 250 degrees Fahrenheit for about 60 minutes. Dip the model into wax or rosin at 200 degrees F while the model is still hot. A good model spray can also be used to prepare the model surface for later wax up. Replace models in drying oven to absorb any surface rosin or wax on model surface. Remove model and blow off excess wax. You are now ready for wax-up.

PAINTING AND INVESTING

Mix desired amount of CHROMECAST - XF in proportion of 14 - 15 ml water or a mixture of water and the special liquid to 100 grams of investment. Again it is better to mix under vacuum with a mechanical mixer at low speed for 30 to 60 seconds. A liquid mix of 75% water and 25% special liquid will give a smooth and clean bubble-free casting .

Paint pattern with the investment and then gently fill the casting ring by pouring the investment from the sides of the ring under gentle vibration. You can also use liquid investment sold separately by other vendors for painting purposes .

The mechanical mixing under vacuum is the preferred method. Either a one piece or a split ring, removable type can be used. It is not necessary to have a casting ring around the investment during burnout or the casting .

BURNOUT & CASTING

Allow flask to bench set for one hour before burn-out. Place flask into a cold burn-out furnace and heat to 500 degrees Fahrenheit in 45 to 60 minutes; then raise the temperature to 1700-1800 degrees Fahrenheit over the next 60 minutes. Heat soak for about 30 minutes and cast as usual.

Manufactured by:

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