

Technique For **CADVEST** **CAD RESIN PATTERN INVESTMENT** Fine-Grained Investment Formulated Specifically For Partial Framework Printed Resin Patterns

- 1 Sprue with the CAD software if possible or attach (6 ga) wax sprues to the resin pattern with sticky wax using accepted laboratory procedures. Attach sprue/cone former to the sprues with sticky wax.
- 2 CADVEST works well with all ringless techniques. Seal disposable ring (P/N 6030) around the sprued resin pattern.
- 3 Suggested ratio for partial denture framework investing is 70% High Expansion Phosphate Liquid and 30% distilled water. This can be mixed ahead of time, however, shake the mixed liquid each time you use it. Prepare 600 g of powder to 150 ml liquid/distilled water mixture for 1 ring.
- 4 Pour liquid mixture into the mixing bowl, then add the powder. Hand spatulate for 15 seconds until investment is wet. Vacuum mix for 60 seconds and invest using a little vibration, taking care not to trap air.
- 5 Place the poured ring into the Nobilium Pressure Vessel (PN 7555). Pressurize the unit. Allow ring to set for 15 minutes. After 15 minutes, remove disposable ring and allow to bench set for 1 hour.
- 6 Place in a furnace at 150°F (66°C) or lower, then turn the furnace on and heat directly to casting temperature in 1 hour. Hold for 30 to 60 minutes (use longer time for more cases) and then cast.

WARNING
This Product Contains Free Silica



Inhalation of dust may be harmful to your health. Take appropriate protective measures to avoid breathing dust. Immediate clean-up of spills is highly recommended. This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

May cause eye irritation. Inhalation may cause mucous membrane and respiratory irritation. Prolonged over exposure to respirable crystalline silica may cause lung disease (silicosis) and increase the risk of lung cancer. Risk of cancer depends on duration and level of exposure.



Division of CMP Industries LLC

413 North Pearl Street • Albany, New York 12207
518.434.3147 • 800.833.2343 • www.nobilium.com

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How to properly fit your case with Stratasys™ MED 610 Model Material

Follow these 6 steps to get a proper fit every time!

1 Cast



2 Sandblast



3 Acid or Tumbler

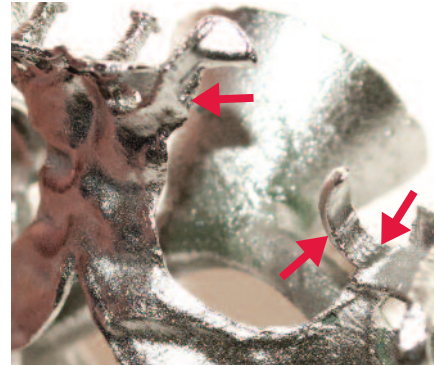


4 Adjust Clasps Slightly outward.



5 Trim Texture to Fit

Tip: Some areas of texture may appear due to MED 610 Model Material penetrating the support material. Since this texture is additive to the pattern, it should be trimmed away. Below are some examples of additive texture to be trimmed.



6 Check Fit of Frame

Adjust clasp inward at QC stage.

