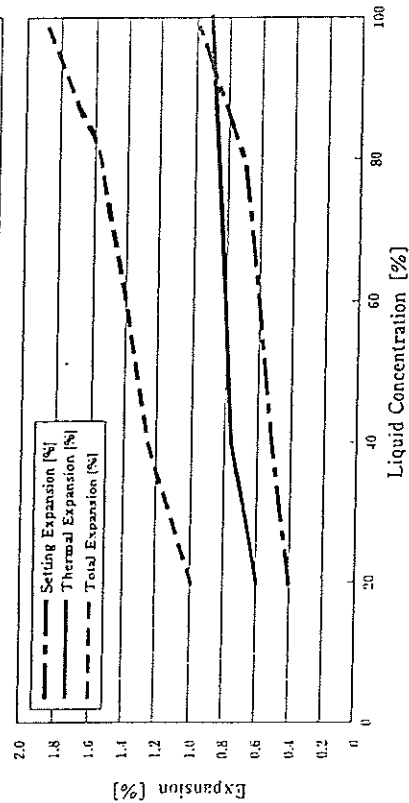


|                                          |             |
|------------------------------------------|-------------|
| Powder : Liquid Ratio                    | 100g : 20mL |
| Working Time [min.]                      | 6.0         |
| Setting Time [min.]                      | 9.0         |
| Thermal Expansion [850°C (1562°F)] [%]   | 0.9         |
| Compressive Strength [MPa] after 2 hours | 10.0        |

|                    |                                | Ceravety Press & Cast<br>liquid : water |
|--------------------|--------------------------------|-----------------------------------------|
| Non-precious alloy | Bridge                         | 18 mm L 9:1 2 mm L                      |
|                    | Crown                          | 15 4:1 5                                |
| Precious alloy     | Bridge                         | 12 3:2 8                                |
|                    | Crown                          | 10 1:1 10                               |
| Press ceramics     | Pressing onto crown and coping | 8 2:3 12                                |
|                    | Inlay, MOI                     | 5 1:4 15                                |

NOTE : Pressing onto coping means pressing onto the metal coping (including press over) or the zirconia frame.  
ex) VINTAGE Press Over  
VINTAGE ZR Press Over

| Liquid Concentration [%] | Setting Expansion [%] | Thermal Expansion [%] | Total Expansion [%] |
|--------------------------|-----------------------|-----------------------|---------------------|
| 0                        |                       |                       |                     |
| 20                       | 0.40                  | 0.50                  |                     |
| 40                       | 0.50                  | 0.75                  | 1.00                |
| 60                       | 0.60                  | 0.80                  | 1.40                |
| 80                       |                       | 0.85                  | 1.55                |
| 100                      | 1.00                  | 0.90                  | 1.90                |



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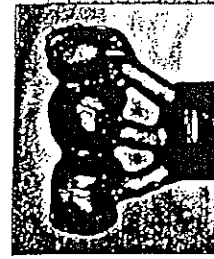
# Instructions for use

1. Quick burnout (temperature setting: 1000°C (1832°F) or less) without a ring is possible at 20 min. after investing.
2. Casting and pressing of non-precious alloys, precious alloys and press ceramics is possible.
3. Cast surface is finished smoothly with less burning (reaction layer) of press ceramics and an investment material.
4. Especially when press ceramics is used, removal of the mold becomes easy. Therefore it reduces chipping of ceramics.
5. Less stress remained in press ceramics reduces cracks in pressed ceramics.
6. Long working time

This product can be used for both press ceramics and casting alloys using the ringless method (using the ring method is also possible).  
Mixing ratio : 20mL/100g powder

## Wax-up

1. In the case of usual casting alloys or pressing ceramics onto copings, the conventional way of wax-up should be applied. In the case of pressing ceramics, spruing should be done using a sprue of  $\phi 3.0\text{mm}$  and more as the photos below show. In the case of pressing ceramics onto the metal coping, or zirconia frame, opaque is applied and wax-up is provided on top of that.



**Spruing model of press ceramics  
(Example of pressing ceramics onto Zirconia coping)**

## Mixing

Temperature setting for best performance is 20~26°C (68~79°F).

1. According to the kind of metal and its usage, set the mixing ratio of CERAVEITY liquid and water referring to the table below. Mix the materials by hand for 30 sec. In order to increase expansion, enhance concentration of the liquid. In order to decrease expansion, reduce concentration of the liquid.
2. Mix with a vacuum mixer for 60 sec.
3. If the wax cleaner spray is used as surface treatment, spray it lightly on the waxed surface.
4. Pour the investment into the ring using a vibrator.

## Waiting after investing

1. After investing, preserve the investment at room temperature for 20 min.
2. In the case that press ceramics is used without using a ring, trim the bottom face of the hardened mold to make it parallel to the other bottom face so that it can be placed appropriately into the pressable porcelain furnace.
3. If not using a ring, place the hardened mold into the furnace preferably within 30 minutes and at least for fewer than 3 hours. Regardless of with a ring or without a ring, if the hardened mold is burn-out on the following day, soak the mold in water for 5 minutes and heat it from the room temperature.

## Burn-out

### Quick burn-out method

1. In the case of press ceramics, place the hardened mold into the furnace at the temperature of 850°C(1562°F) 20 min. after investing (If temperature is designated by the ceramic ingot manufacturer, set the designated temperature).  
In the case of casting alloy, put it in the furnace at the temperature of 800°C(1472°F)
2. According to the size of the ring, hold the temperature : 100g ring for 45 min., 200g ring for 60 min.

### Normal burn-out method

1. Raise the temperature by 20°C/min. from room temperature.
2. According to the size of the ring, hold the temperature : 100g ring for 45 min., 200g ring for 60 min.

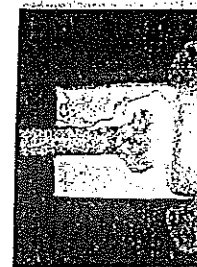
## Casting

### Casting alloy

Casting is conducted in the way designated by the manufacturer of metal or casting machine.

### Press ceramics

1. Press a ceramic ingot in the way designated by the manufacturer of a press ingot.
2. In the case of 200g ring, two ingots can be used.



## Removal of investment

1. Remove the investment around the casting metal or press ceramics. In the case of press ceramics, cut the sprue and then remove the investment remained on the pressed ceramics by sandblasting with glass beads.

## NOTES

1. Based on the table below, adjust expansion. In order to increase expansion, enhance concentration of the liquid. In order to decrease expansion, reduce concentration of the liquid.
2. Use a ring liner fitting the ring size and wrap it till the top surface of the ring without making space on the ring. Do not allow the investment overflow from the ring.
3. Secure 5mm or more between the end of the wax-up pattern and the upper end of the ring.
4. Secure 5mm or more between the side end of the ring and the end of the wax-up pattern.
5. Insufficient mixing and excessive vibration when pouring the investment into the ring may cause a rough cast surface or trapped air bubbles. Therefore appropriate adjustment is necessary.
6. In the following cases, do not apply quick burn-out, dry the mold at the temperature of 100°C(212°F) and below. Raise the burn-out temperature up to 300°C(572°F) by degree and hold at the designated temperature for 30 min.
  - ①Casting is conducted on the following day of investing.
  - ②When a plastic pattern is used.
  - ③When using a ring bigger than the one with 60mm diameter and 55mm height.

## [CAUTIONS]

- ① This material contains free silica. Long-term inhalation of silica may cause lung damage. In order to avoid effects of powder dust to human body, use the local exhaust ventilation, dust preventive mask etc. authorized by the public institutions. If eye contact occur, flush with water and seek medical treatment.
- ② When heating this material, conduct all the process of work in the room where exhaust system, ventilation system or fan is placed in order not to inhale gas generated by heat.
- ③ When grinding the hardened material, use protective equipment such as eye protection in order to avoid eye damage.
- ④ Persons other than dental professionals with appropriate qualifications should not use this product.
- ⑤ Ceravely Press & Cast should be stored at room temperature. In case of the powder should be stored avoiding high humidity and the liquid should be stored avoiding direct sunlight(Do not store the liquid below 0°C).

## NOTE

Investments contain free silica.

DO NOT BREATH DUST. MAY cause delayed lung (silicosis / lung cancer)

## [PACKAGE]

Ceravely Press & Cast Powder 100g x 120 pcs  
Ceravely Press & Cast Liquid 2 L