

OMEGACAST RP

Instructions for use

Technical data:

Mixing liquid	OMEGA Liquid
Mixing ratio, Powder :	liquid 100 g : 20 ml
Mixing under vacuum	60 sec.
Working time	4 - 5 min.
Recommended storage / Working temperature approx.	22°C (Room temperature)
Initial setting time	7 - 10 min.
Setting expansion	approx. 1.00% (75% diluted type 100 liquid)
Preheating temperature range for placing in the furnace	850 - 900° C
Place in the hot furnace	25 min. after investing

Description:

OMEGACAST RP is a phosphate bonded, graphite free and very fine grain precision investment specially for partial denture frameworks made with 'Rapid-Prototype' technologies. OMEGACAST RP is specially developed to burn out plastic frames made with Rapid-Prototyping resins. It is usable for the conventional and speed casting techniques and is suitable for casting all types of dental alloys (except Titanium).

Concentration of the expansion liquid: 20 ml liquid / 100 g powder

Frameworks - Liquid ratio Typ 100 / distilled water: 80 % / 20 %

100 g	180 g	400 g
16 ml / 4 ml	29 ml / 7 ml	64 ml / 16 ml

Investing: Follow the instructions according to the OMEGATECH-system when attaching sprues to the framework. Place the framework in the model forming silicone sleeves (REF 22603-605) and ensure that it is placed out of the heat centre of the mould. Thin sections, e.g. clasps, should face towards the sides of the mould and be 5 mm from the casting ring.

Measure and mix OMEGACAST RP as described above. Pour with minimum vibration until the framework is completely covered. Switch off the vibrator, fill the ring and do not vibrate again. Put the muffle immediately after investing in a pressure chamber at approx. 2 bar for 25 minutes and let it harden vibration free.

Preheating with the speed casting technique: 25 minutes after investing, place the mould with the sprue hole pointing downwards in a furnace preheated to the correct temperature of 850° C – 900°C. OMEGATECH recommend a maximum preheating temperature of 900° C. This temperature is perfectly adequate for both casting the mould and final thermal expansion. Moulds are ready to cast approx. 60 minutes after the final temperature is reached. During the first 15 minutes after inserting the moulds, the furnace fan and extractor should remain switched off and the furnace door should

not be opened because of the risk of instant combustion.

Please note: Technical recommendations are based on tests and findings from work in our development laboratory and can only be regarded as guidelines. OMEGATECH products are subjected to strict quality controls. We reserve the right to make technical changes.

Warning:

Investments contain quartz and cristobalite. Do not breathe in dust. Danger of lung diseases (silicosis or cancer). Use a suitable dust mask!