

# GILCAST D/W SPEED



**Dental**

**Quick casting, cristobalite containing investment, free from graphite for precious metal alloys with liquidus temperatures not higher than 1080° C  
(Also suitable for the over night / tradicional technique)**

## Mixing ratio

Powder : dist. water 100 g : 31 - 33 ml

Temperature of powder and water  
approx. 23 °C.

## Mixing

GILCAST D/W SPEED must not get into contact with phosphate bonded investments. Use separate mixing tools.

Strew the powder into the water over a period of approx. 10 sec., allow to soak for approx. 15 sec., using limited movements of the spatula, if necessary, but avoiding any stirring movement.

Mix for 60 - 70 sec. It is advisable to use a vacuum mixer, mixing with 300 rpm. When mixing by hand take care not to trap air.

## Working time

approx. 5 min.

## Investing

Line the muffle with non-asbestos material, large muffles with two layers.

The competently prepared wax pattern may be treated with a surface tension reducing wetting agent. Let it dry completely before investing. Never use compressed air for drying!

Vibrate the investment mix into the muffle until it is slightly overfilled, then level the top of the muffle.

## Setting time

(Solidification time) approx. 13 min.

## Final setting time

(Hardening time before burnout) 30-45 min.

## Linear setting expansion

approx. 0.8 %

## Compressive strength

approx. 4 N/mm<sup>2</sup>

## Burnout and casting

Put the muffle into the 680 - 700 °C hot furnace

## Maximum temperature

700 °C

Hold the maximum temperature for 30 - 60 min. according to the size of muffle. The time between taking the muffle out of furnace and casting the alloy should be as short as possible. Cast the alloy according to the prescription of the manufacturer of the casting machine.

## Linear thermal expansion

0.8 - 0.9 %

It is invariable between 600 and 700 °C.

## Removing

Let the muffle cool in the air. Thereafter the casting can be removed from the muffle.

## Attention

GILCAST D/W SPEED contains quartz and cristobalite. Avoid inhaling dust!

## Shelf life

GILCAST D/W SPEED - like all gypsum bonded investments - will deteriorate if exposed to the atmosphere, especially if the humidity is high.

If stored in well closed, vapour-proof containers GILCAST D/W SPEED has shelf life of 12 months. Observe the expiry date on the labels.

## Packing units

Fibre drums with foil insert	45 kg
Portable cartons with foil insert	20 kg
PE-case sealed air-tight	4,0 kg
Envelopes	60/180 g

The recommendations are given to the best of our knowledge after careful control. We grant the quality of our products according to our specification. Any further liability cannot be accepted since the proper appliance of our products is outside of our control.