

GILVEST MG-VARIO



**Dental**

Phosphate-bound investment for partial denture, cobalt-chrome dental alloys

Working temperature

powder and Liquid app. 21 °C

Mixing ratio

For silicone:

100 g powder : 17 ml **Gilvest Liquid**

For gel dubbling:

100 g powder : 16 - 17 ml **Gilvest Liquid**

Mixing time

Mix the powder and the Liquid vigorously by means of a spatula for 10 seconds, then mix with a mechanical stirrer under vacuum for 50 seconds and vibrate the mixture for 10 seconds.

Working time

100 g:17 ml app. 4 min
100 g:16 ml app. 3.5 min

Final setting time 45 - 60 min

Burnout

After hardening place the casting mould into the cold oven. At 280 °C and 580 °C the temperature should be maintained for 45 - 60 minutes, depending on the size and the number of the casting moulds.

Hold the final temperature, recommended for the alloys, 45 - 60 minutes.

Heating rate

3 - 5 °C/min to 280°C
5 - 7°C/min to 580°C
5 - 7°C/min to final temp.

Maximum temperature 1050 °C

Cast without delay.

After cooling down at room temperature the casting can be removed from the mould.

Quick Burnout

After Bench Set of approx. 25 min, the ring can also be placed into the already at max. 300° C preheated furnace and immediately heated up to final temperature.

Pressure Pot

In case of using pressure pots keep pressure constantly! Master-models and invested rings keep pressure for max. 12 mins., otherwise no setting expansion.

GILVEST MG-VARIO

Expansion values

Related on a Gilvest Liquid concentration of 100 %	
Setting expansion	app. 1,8 %
Thermal expansion	app. 1,3 %
Total expansion	app. 3,1 %

Related on a Gilvest Liquid concentration of 50%	
Setting expansion	app. 0,5 %
Thermal expansion	app. 1,1 %
Total expansion	app. 1,6 %

For higher expansion ask for **Gilvest Liquid G**.

Important hints

This investment must not come into contact with plaster or investments containing plaster. Use separate mixing tools.

If the wax model is treated with a surface tension reducing wetting agent, let it dry completely before investing. Never use compressed air for drying.

Attention

This investment contains quartz and cristobalite, therefore avoid inhaling dust when handling the powder

Packing units

Portable cartons with foil insert	20 kg
Pouches	5 kg
Pouches	180/400 g
For repacking:	
Paper bags with foil insert	25 kg

Storage

In well closed, vapour-proof packages. Pay attention to the expiry-date on the packages.

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