

uniVest Rapid

Phosphate bonded precision investment (graphite-free) for all precious alloys and non precious bonding alloys.

1. Expansion

The total expansion can be adjusted by selective dilution of the liquid. The liquid is supplied in 100% concentration and should be diluted according to the type of alloy to be cast either with distilled or demineralised water.

2. Mixing ratio

The powder and the liquid are always mixed in a ratio of **100g:22 ml**

(Casting rings: 1x = 50g:11 ml /

3x = 150g:33 ml / 6x = 300g:66 ml /

w9x = 450g:99 ml)

2.1 Recommended liquid concentrations

	C&B	Inlays			Telescop- Conical crowns	
		MOD	MO/ OD	Onlay	Wax	Resin
1	40%	30–35%	45%	60%		
2	40%	30–35%	45%	60%		
3	25–30%	20%	20%	20%	10–25%	50–75%
4	30%	20–25%	50%	60–65%	10–25%	50–75%
5	90–100%				90–100%	90–100%

1 = High gold bonding alloys

2 = Reduced gold bonding alloys

3 = High gold casting alloy

4 = Reduced gold casting alloy

5 = Non precious alloy

3. Mixing

Prepare the liquid according to the indicated concentration, add the powder, then spatulate for a short time. **Finish mixing mechanically under vacuum for about 60 seconds.**

4. Preparation for investing

The uniVest Rapid investment can be used only with a metallic casting ring. For a controlled expansion use one layer of liner with 1x and 3x casting rings, for larger casting rings use two layers. Ensure that the liner is slightly longer than the length of the casting ring. Fill up the casting ring using vibration and then allow the investment to set.

Beginning of setting time

approx. 6 min.

Setting time	20 min.
Setting expansion	1.6–2%
Thermal expansion	1.1–1.2%
Total expansion	2.7–3.2%

The times mentioned are valid for room temperature of approx. 20–22°C.

5. Preheating of the casting ring

High Heat Preheating:

– Let the casting ringset for 20 minutes, and put it immediately in the preheated furnace.

Holding times: Casting ring 1x = 30 min.

Casting ring 3x = 40 min.

Casting ring 6x = 50 min.

Casting ring 9x = 70 min.

Standard-Preheating:

– Put the casting ring in the cold furnace.

– Heat to and stabilize at 270°C for 30 to 60 minutes (according to the size of the casting ring).

– Heat to 580°C and hold it for 30 minutes.

– Then rise to the required temperature and hold the temperature for approx. 30 to 60 minutes.

Heat soaking temperatures:

– Bonding alloys	800 to 850°C
– Casting alloys	600 to 700°C
– Non precious alloys	850 to 950°C

Note: Storage and processing temperatures for investment powder and mixing liquid are very important for the setting expansion, precision and surface finish of the casting. The container of the uniVest Rapid investment should be sealed and stored at room temperature. If the liquid becomes frozen it is irreversibly damaged. Do not shake before use. Keep away from humidity. These instructions for use have been formulated after considerable testing in our laboratories. Alteration of these instructions for use may lead to changes in the results.



Warning

Important


These instructions supersede all previous editions.

- H373 May cause damage to lungs through prolonged or repeated exposure.
Route of exposure: aspiration/inhalation.
- P260 Do not breathe dust.
- P284 Wear respiratory protection.
- P501 Dispose of contents/container to a recognised waste disposal centre.

Product contains: quartz and cristobalite.

For further information ask for the Health and Safety Datasheet from Cendres+Métaux SA.

Storage: uniVest Rapid cannot be stored for an unlimited period, please refer to the back of the bag. As investment compounds are sensitive products, they must be protected against air, moisture and warmth in their original packaging. The ideal storage temperature is 18°C.

5°C  Attention: store at room temperature!

The special liquid is sensitive to low temperatures such as when being transported during cold weather.

Traceability, lot numbers: When placing complaints, always quote the lot number (back of bag).

Allergies: Certain constituents of investment compounds may cause contact allergies on skin while using the investment. It is therefore advisable to wear gloves to protect the hands, and a face mask.

Never mix investment compounds with different lot numbers.

Liability

The information provided herein represents state-of-the-art technology and assumes that the product has been checked carefully. We guarantee impeccable quality but are not liable for results due to further processing which is not usually within our control.

The manufacturer assumes no responsibility whatsoever for damage due to non-adherence to these instructions, especially if the investment compound is used after the expiry date.

Product range

Carton, 30 × 150 g bags

Cat. No. 0805 2162

1 × 1 litre uniVest Plus liquid

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