

Specifically designed for dental casting

A high precision material for casting the coping and substructure, casting the full contour crown, casting the removable partial denture frame(RPDs) and dental inlay casting.

## 3D printing dental casting resin

**Colours:** Green

**Wavelength:** 405nm

- Easy casting
- Burns without ash
- High precision
- Easy to print
- Low irritating



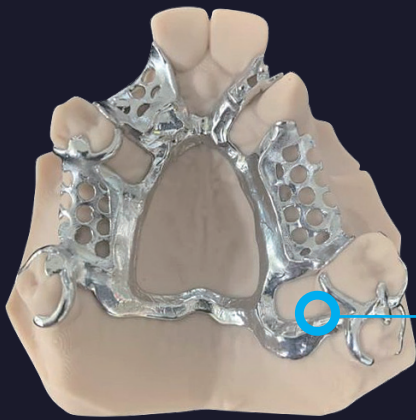
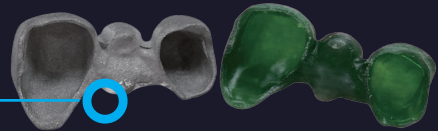
content	Data value	testing method
viscosity	250-280cps(25°C)	ASTM D1084-1997
density	1.09g/cm <sup>3</sup>	ASM D1875-69(1980)
shrinkage	< 0.5%	Capillary method
hardness	63D	ASTM D2240-05(2010)
modulus of elasticity	650MPa	ASTM D1929-1996
breaking strength	20-25MPa	ASTM D 1781





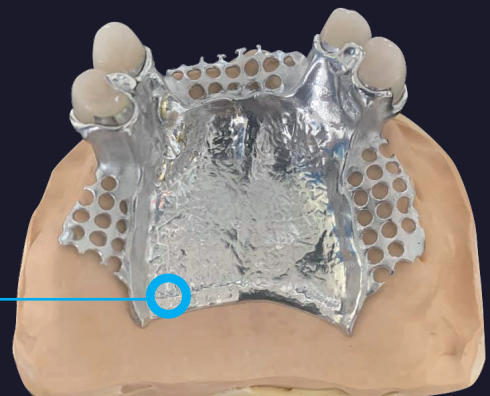
Rapid printing, the exposure time on a 4K mono printer is only 2.5s per layer, 110 crowns are printed within 40mins, and 7 partial denture frames are printed within 2.5 hours.

High precision, smooth surface, this resin can perfectly restore the design details of the digital models, the tolerance is  $\pm 50\mu\text{m}$ .



After printing and curing, it's high deformation resistant, easy casting, no residue after casting, and good surface effect.

Resin thermal expansion coefficient is low, suitable for casting fine structure objects, high adhesion degree after casting.



# How To Casting

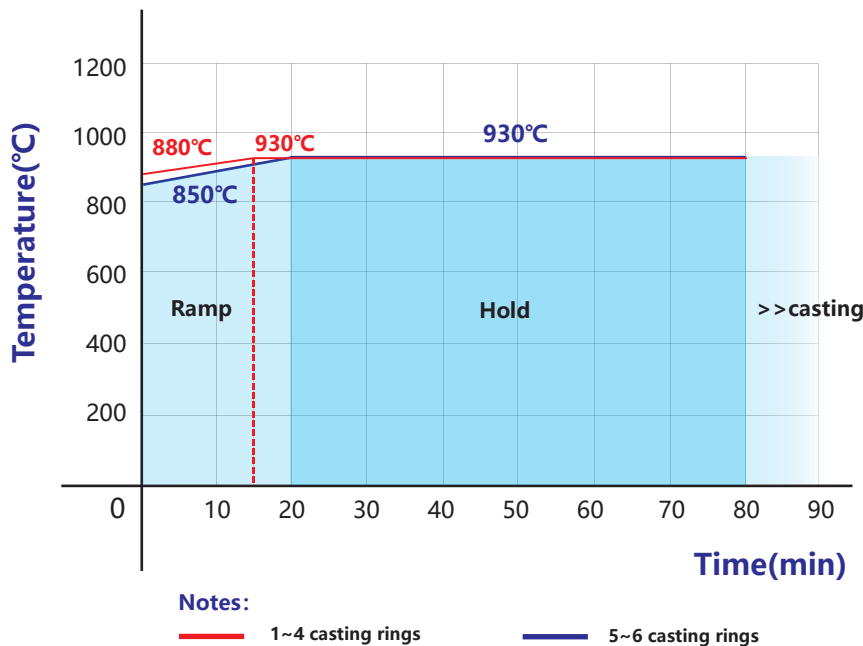
## 一、 Post-processing process

1. Clean the model with clean 95% alcohol for 1-2 minutes  
(can not be reused, it must be clean alcohol)
2. \*Use ultrasonic cleaning for 1 minute
3. \*Dry the model with a fan or oven to make sure the model is dry
4. Just put the model in the curing box for 3 minutes

## 二、 Casting aspects

### STANDARD BURNOUT SCHEDULE

It is recommended to use embedding powder for dental casting. The addition ratio of each component of the embedding powder: 400 grams of powder + 20 ml of water + 80 ml of embedding solution (phosphate), working temperature: 18-24 degrees Celsius, vacuum stirring for 45-60 seconds.



### Description

#### **[1~4 casting rings] :**

start at 850°C, heat up at 8~10°C/min for 20 minutes, hold at 930°C for 60 minutes

#### **[5~6 casting rings] :**

start at 880°C, heat up at 10°C/min for 15 minutes, hold at 930°C for 55~65 minutes

More than 6 circles can be baked in batches, or a muffle furnace with higher power can be used (the purpose is to ensure the heating rate when burning circles)

Note: The cast ring refers to the size of the No. 5 dental rubber ring

### Remove flasks from oven and start casting

The temperature of the casting ring is 930°C for porcelain, and the bracket is 960°C

**Remarks:** The thickness of the dental department is generally 0.3-0.6mm, If it is thick, the sprue should be thickened.