



# **Application guide of casting resin**

Dongguan Godsaid Technology Co., Ltd.

E-mail: support@godsaid3d.com



# STEP 1: CAD Design

## 1 Scan



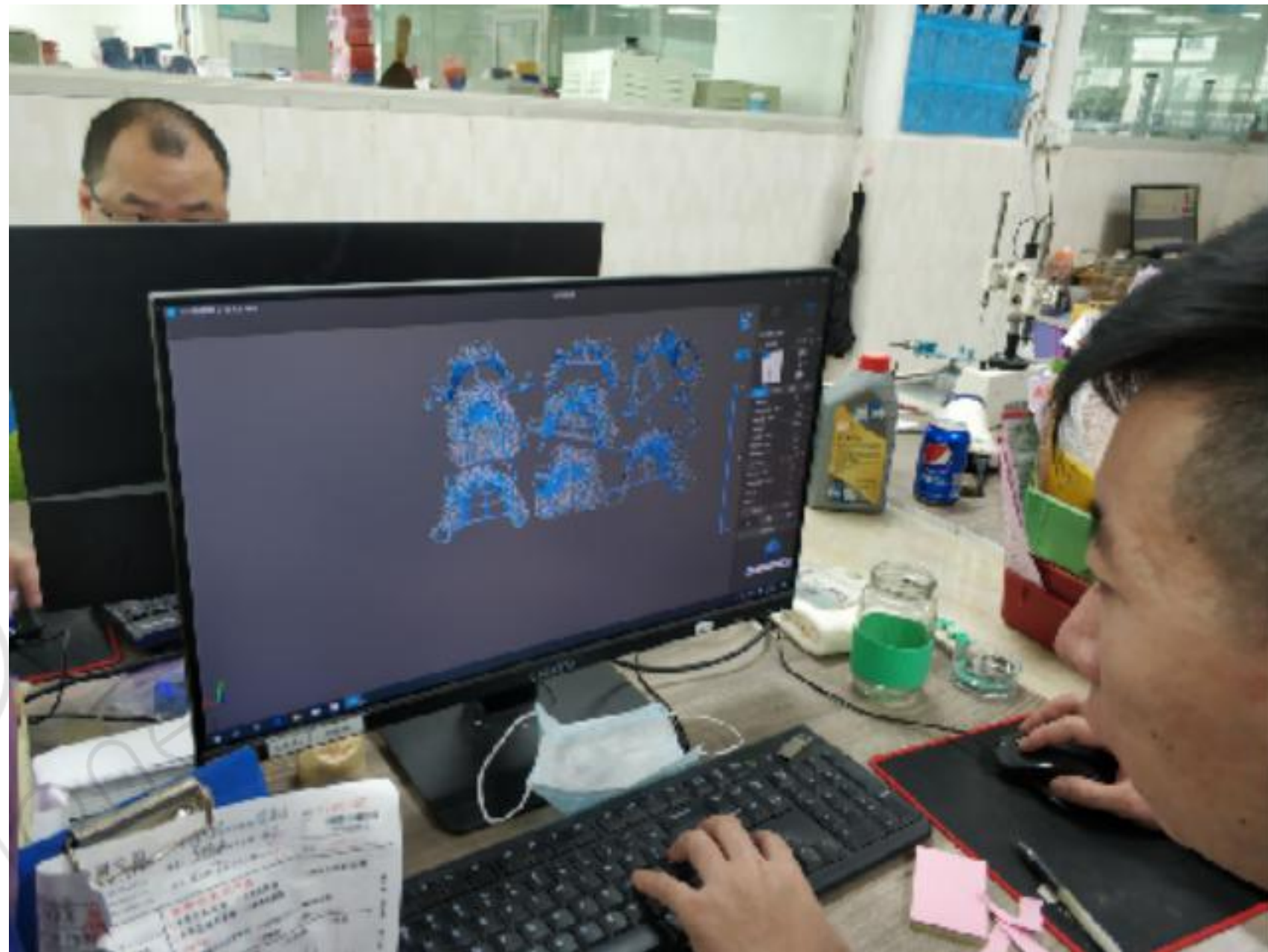
## 2 Crown and Bridge Design





## STEP 2: 3D Print

1 Orient parts for Printing With Supports



2 Printing parameters recommended by RESIONE





## STEP 3: Cleaning and post-treatment

1 Wash with  $\geq 95\%$  alcohol or IPA



2 Try on to verify accuracy



3 Support Removal

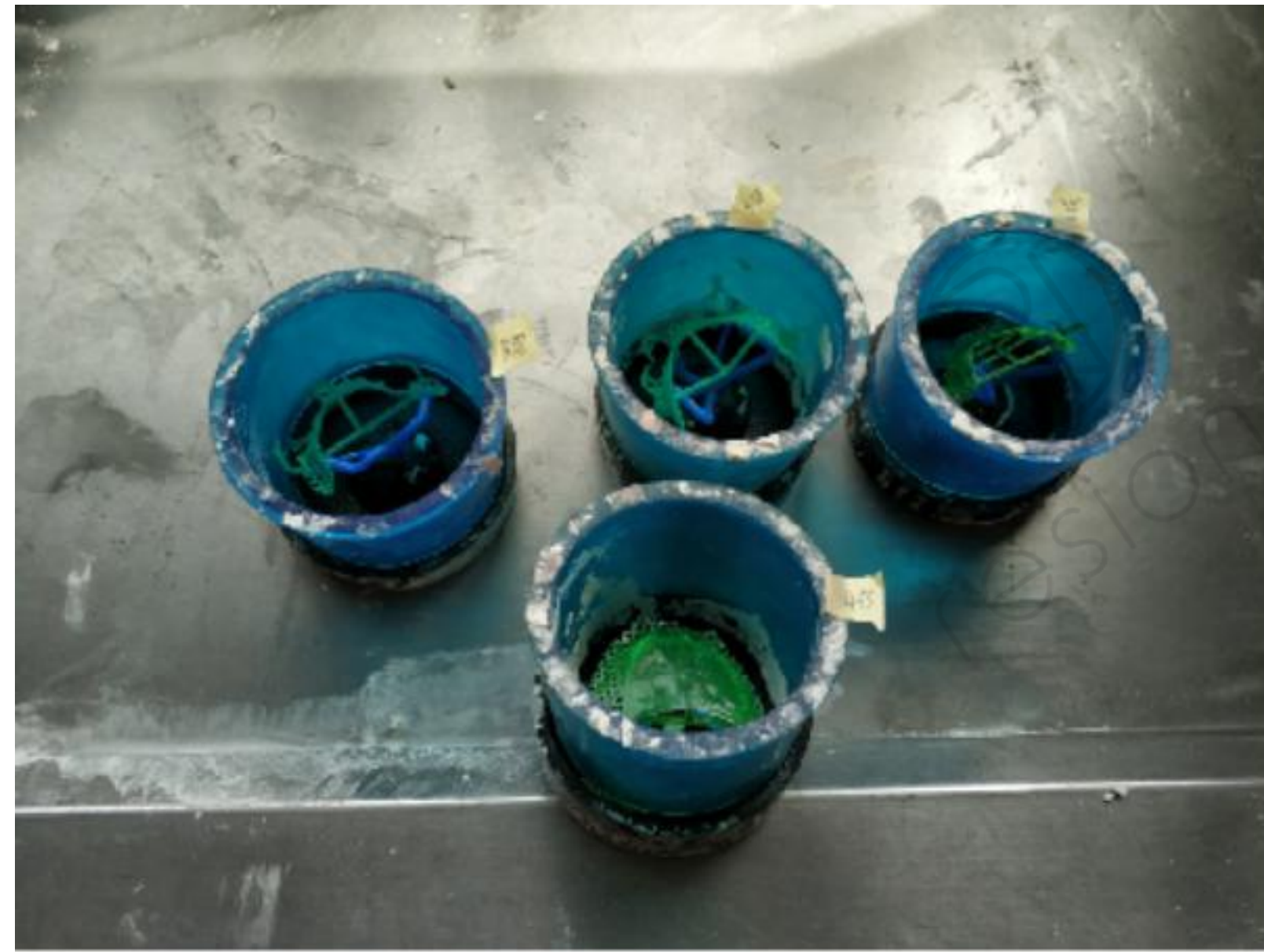
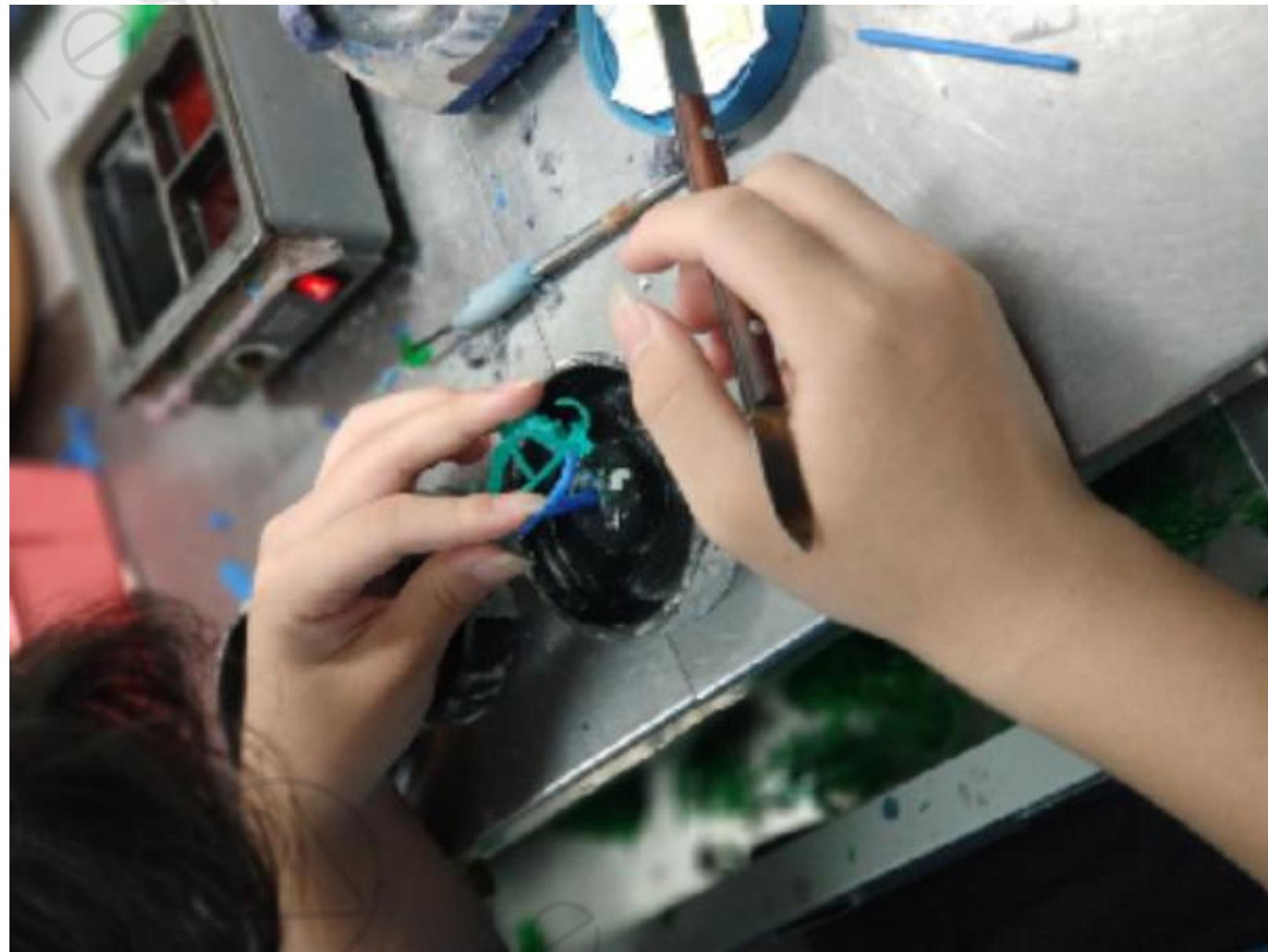


4 Repair the damaged





## STEP 4: Seed wax casting channel





# Investment

**Please follow the instructions provided by the dental investment material supplier. If you do not have dental investment material, you can refer to our scheme**

The most suitable temperature for preparing dental investment materials is above 20°C

**Powder : Mixed liquid  
100g : 22ml**

**(Mixed liquid=Tap water 13.2ml: Dental casting liquid 6.6ml )**

Note: when the temperature is lower than 10°C, the liquid should be adjusted to 20ml; when the temperature is lower than 5°C, the liquid should be adjusted to 18ml. If the thin edge model is not completely cast, the liquid can be appropriately reduced.





# Investment

1. Effective operation time: about 3-5 minutes (15-25°C), the higher the room temperature, the shorter the operation time

2 .Clean and wipe the mixing container before operation.

3. Add the liquid first and then the powder. Mix manually for about 20 seconds and then vacuum blender for 45 seconds.

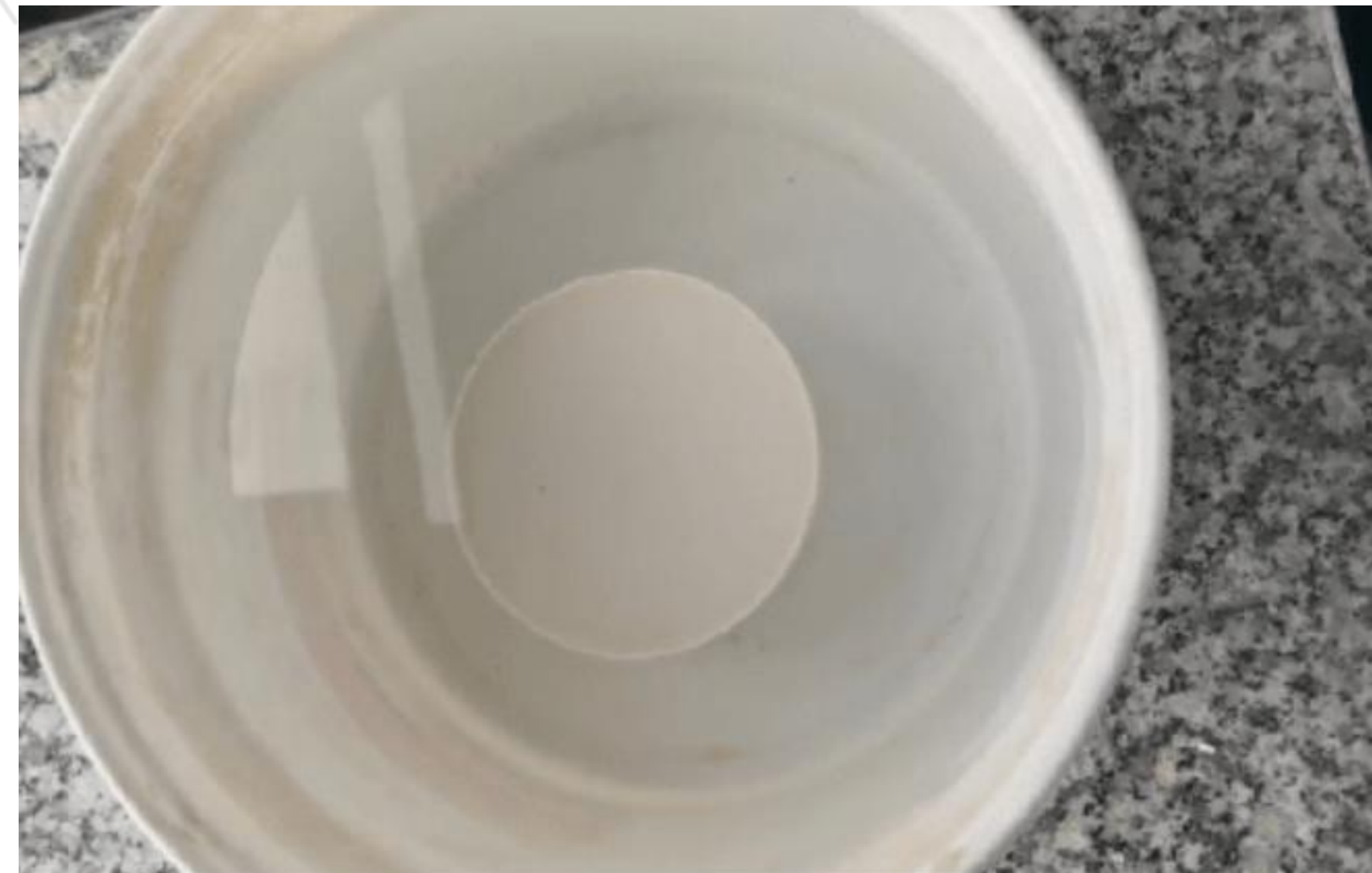




# Investment

1. The casting ring oscillates on the oscillating machine at the lowest vibration level for 10 seconds. The embedding of paste is carefully poured into the casting dental model, and no vibration is allowed after complete filling.
2. The casting ring is removed as soon as possible after curing and heating up to about 43°C, so that the expansion is more uniform and the ring is not easy to crack
3. The mould is soaked in water and let stand for 25-30 minutes to make the embedding material completely solidified

The embedded material deformation caused by moving the die or removing the casting ring prematurely may lead to micro cracks in the model

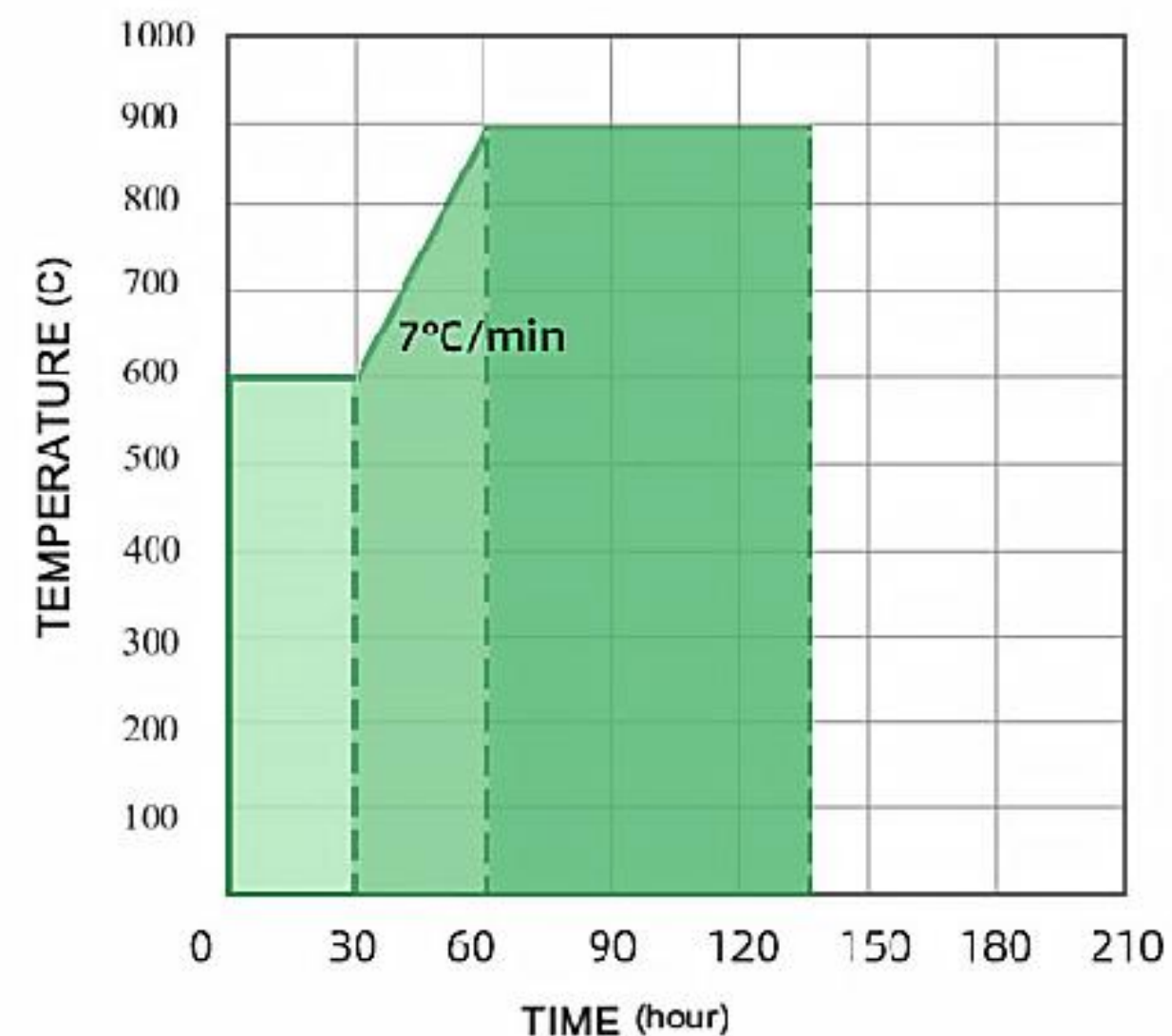




# Burnout Process

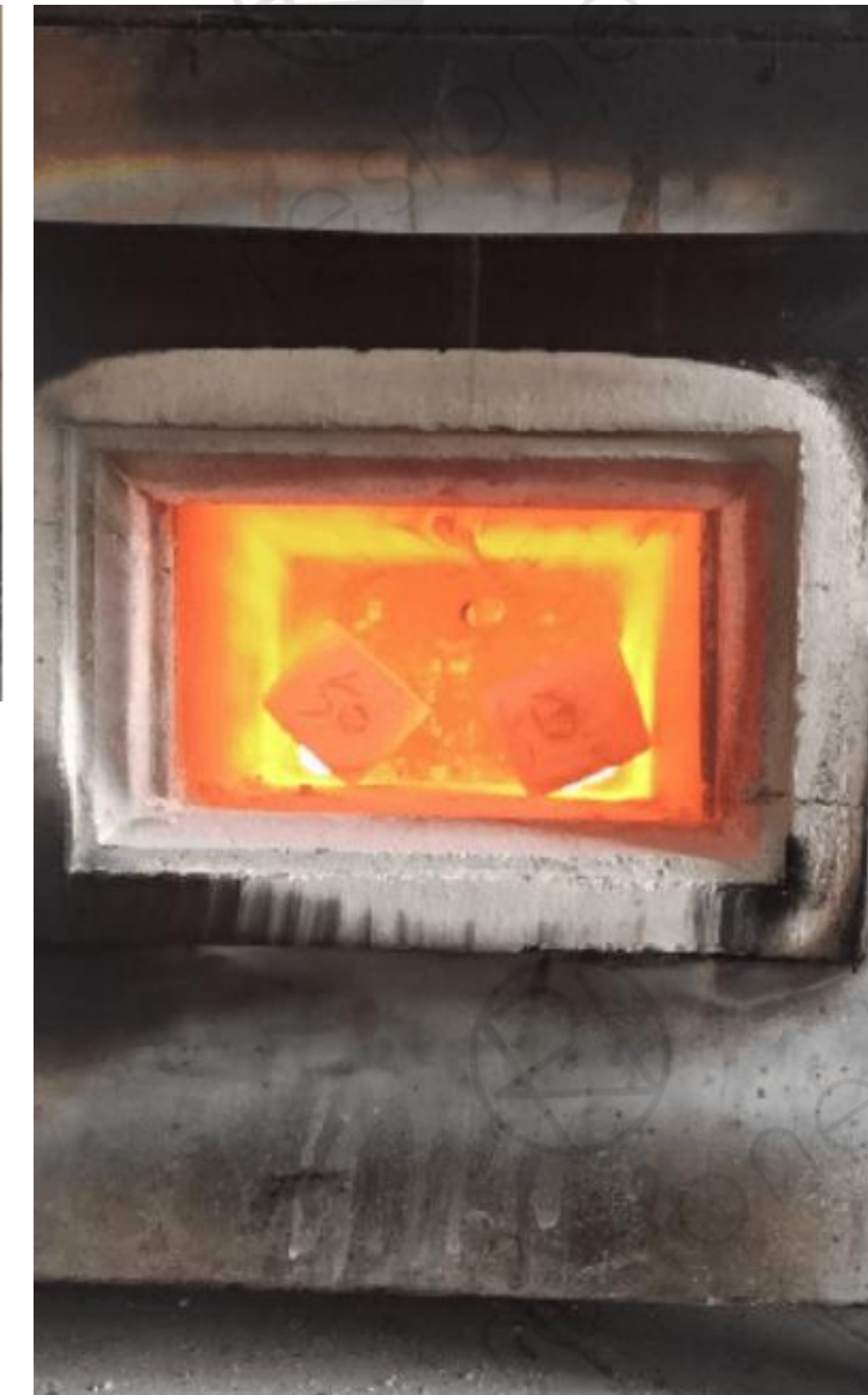
Preheat the furnace to 600°C, put in furnace at 600°C, insulation for 30 minutes is the best, adjust the heating rate of 7°C/min to rise to 900°C, insulation for 30 minutes to 60 minutes can be cast successfully.

**Burnout Schedule**



Note: The casting mold tilts to leave an air inlet at the bottom.

The insulation time shall be adjusted according to the actual number and size of casting molds.



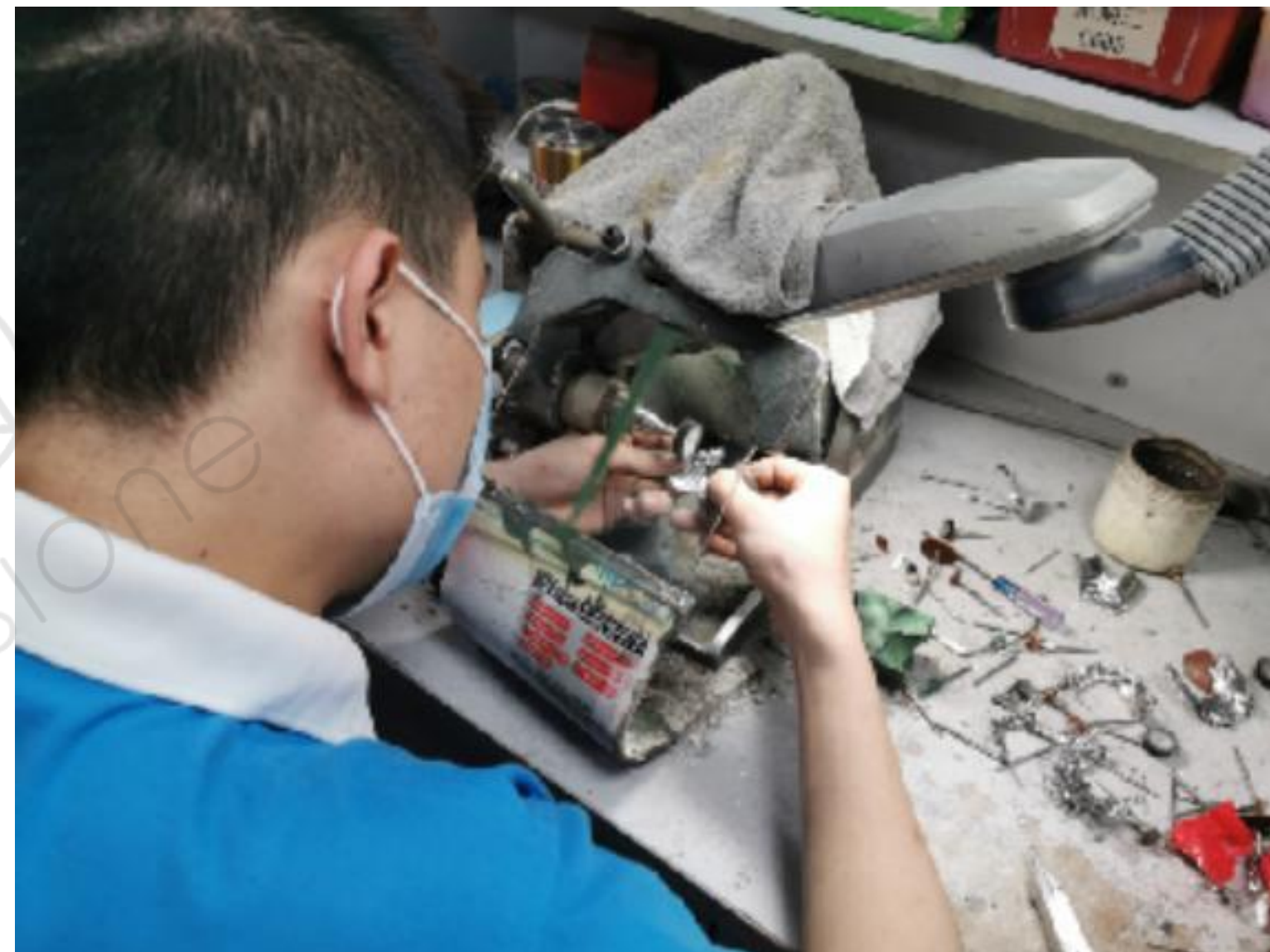


# ■ The alloy is fused and centrifugal filling





# Take the model out and polish it





# Cast ceramic patch







**THANK YOU**

**Thank you for watching**

