

# picodent easysoft

## Gypsum-based investment material

For hot and cold ovens

Mixing ratio:	32 - 37 ml distilled water to 100 g <b>easysoft</b> powder
Mixing time under vacuum:	60 seconds
Processing time:	approx. 7 minutes
Setting time:	approx. 60 minutes
Setting expansion:	0, 4 - 0.8% according to mixing ratio
Thermal expansion:	1, 2%

### Product information

**easysoft** is the special investment material for all low-melting alloys with a liquid temperature of maximum 1060°C and a casting temperature of maximum 1200°C. **easysoft** is best suited for inlays, onlays and part crowns, crowns and bridges and ensures perfect fit of secondary parts, independent whether the muffle can be set in the cold or the already pre-warmed kiln. Also the use of modelling plastics and deep-drawing film guarantees optimal results of the unique stability of. The particular choice of raw materials and the stringent quality control always guarantees optimal casting results independent of casting procedure and modelling raw materials.

### Processing Instructions

In order to always get optimal results please pay attention to the processing instructions of **easysoft**:

- For all cast-iron techniques (vacuum-pressure casting or centrifugal casting) beam placement is recommended. This is also applicable for single objects. The diameter of the beam has to be 4 - 5 mm. The diameter of the feeder and the distance of the beam to the object should be 3 mm. For the cast canals from the cone to the beam choose between 3 to 4 mm diameters.
- Ensure a minimum distance of the modelling of approx 8 mm to the top side of the muzzle and about 5-7 mm to the muzzle ring.
- A pre-treatment of the model with a wax flash trap is not necessary due to the excellent flowing characteristics of **easysoft**.
- Always use a metal muzzle ring and cover this with a ceramic fleece as follows: rub a little Vaseline on the ring, put the fleece in and finish the task with the lower muzzle ring. Rub some Vaseline on the inside of the fleece as a protection against the absorption of water (Dry fleece can draw the moisture out of the investment material; moist fleece can dissipate water onto the investment material). With a ring size six times as big the fleece should be inserted twice.
- Measure distilled water and place in vacuum mug. **Caution:** Older, mixing mugs with a rough surface could draw 2 – 3 ml water in a dry condition, therefore first shake the mug with water then dry. **Please do not use mugs that are also used to mix phosphate-bound investment material!**
- Put mug on scale, press tare button, measure **easysoft** powder, scoop through then mix under vacuum for 60 seconds.
- Apply **easysoft** with an instrument or with a brush on the object and then fill the muzzle ensuring that the influence of the vibrating unit remains slight. As soon as the objects are covered with investment material take the muzzle from the vibrating unit and fill it without shaking.
- Allow muzzle 60 minutes to set.

### There are two possibilities of heating

- **Possibility 1:** Put the muzzle in the **cold** or hot furnace which should have a maximum temperature of 200°C and increase heat under controlled conditions. Pay attention to the hold time of 30 to 40 minutes depending on the size of the muzzle and the filling level of the furnace, and then pour out quickly.
- **Possibility 2:** Place the muzzle in the **pre-heated** furnace which already has its end temperature (according to alloys up to maximum 740°C.). Keep this temperature according to the size of the muzzle and the filling level of furnace 40 to 60 minutes then pour out quickly.
- For embedding allow the muzzle to cool to room temperature. Caution! By embedding too early (quenching the hot muzzle) the oxide film sticks to the object. This aggravates the de-acidification and continued processing. Imbed the cast objects under running water. Investment material remains could be removed with a steam-blaster.

### General Tips and Recommendations

As wax, organic wax should be used because it burns residuelessly. As **modelling plastics**, brush plastics are recommended such as pattern resin or bredent pi-ku-plast. Process these plastics with little monomer liquid and wait at least 4- 5 hours after out- polymerizing before you imbed. Plastics which harden in the light lead to an unsatisfactory casting result. Construct the plastic modelling from the beginning onwards as delicately as possible. When grinding too strongly, distortions in the modelling and fitting problems could result from the selective heating depending on rotation speed and grinding pressure. Always ensure a thin wax layer on the one side of the plastic modelling. Thereby you avoid tensions and surface damages caused by swelling plastic in the furnace. Blocking between secondary parts should always take place in wax.

Otherwise the massive plastic block lying between the stubs can lead to a breakage of the stub in the muzzle when swelling.

Pay attention to residues of relaxants or residues of insulating agents (gypsum versus wax) on your objects. These residues could lead to setting distortions of the investment material and thus to a roughness of the cast surface! As a muzzle **fleece** please use at least a 1 mm thick ceramic fleece (preferably picodent-easyvlies). Paper is not suitable because it is too thin, the expansion is confronted with too much resistance and burns which leads to the development of soot and the slipping out of the muzzle from the ring when taking out of the furnace. Always place the muzzle with the cast funnel facing down in the furnace.

It is recommended that the **size of the muzzle** is only 3X and 6X, 1X and 9X should not be used. When **setting up the muzzle overnight** the furnace must be cold in the evening. Programme your furnace according to the instructions and protect the muzzle from drying by putting on a wax layer on both sides.

It suffices to put on 0.25 mm slab wax and to go over it with a hot wax knife once round the ring. The remaining water in the muzzle rinses the burnt residues from the cast cavity during heating. Take note when entering the final temperature of the furnace the details of the alloy manufacturer.

**Reduce the starting torque of the casting unit when casting centrifugally.** Since most of the casting throws are also used in the casting of model casts, **easysoft** needs mainly a third of the maximum of the starting torque. Should you be using cast centrifuge that does not allow for a reduction of the starting torque, minimize the number of your objects per muzzle and never exceed the maximum amount of metal of 25g per cast.

**Warning:** Causes damage to lungs through prolonged or repeated exposure by inhalation.

Do not breathe dust. Wash hands thoroughly after handling. Do not eat, drink or smoke when using this product.

Get medical advice/attention if you feel unwell. Dispose of contents/container in accordance with local / regional / national regulations.

