

en Duplicating material on agar-agar base
for investment material, plaster and acrylic casting technique

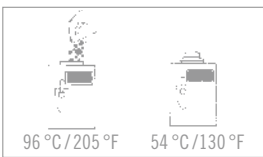
General instructions



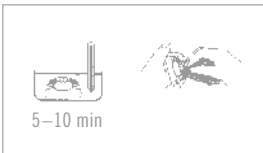
- WiroGel® M requires precise compliance with the recommended temperatures:
melting temperature **96 °C** (205 °F) ± 1 °C (2 °F)
working temperature **54 °C** (130 °F) ± 0.5 °C (1 °F)
- The duplicating equipment used must:
 - be adjustable to the indicated temperatures*
 - guarantee compliance with the indicated temperature ranges
 - be checked for conformity between temperature display and actual temperature.

* Older BEGO duplicating equipment, such as Gelovit with rectangular analog temperature display and Gelovit SLE with 7-segment numerical display, is not suitable because the melting temperature is set to a fixed value of 92 °C (198 °F).
- The best duplication results are achieved with BEGO's Gelovit 200 duplicating unit. The reduced working temperature (T3) of the BEGO duplicating units must not be used with WiroGel® M. When heating up with a hotplate or microwave (400 g: 400 W ~ 4 min) unit, ensure that the melting temperature is not exceeded and is maintained no longer than 1 minute. Otherwise WiroGel® M ages prematurely. Replace evaporating water! When heating up on a hotplate, stir constantly in order to avoid boiling temperatures in the bottom area! Only use containers made of enamel, stainless steel or heat-resistant glass.
- Thermostability: approx. 15 melting cycles.

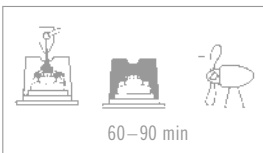
Work



- Cut WiroGel® M into small pieces.
- Heat to 96 °C (205 °F) in a duplicating unit.
- Then allow to cool down to working temperature of 54 °C (130 °F).



- Soak the model in warm water (approx. 38 °C / 100 °F) for 5 to 10 minutes.
- Then dry gently with a cloth.



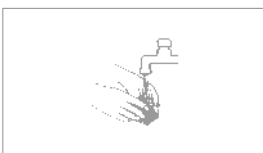
- Fix the model to the base of the flask. Fill flask with WiroGel® M (54 °C / 130 °F).
- After that allow WiroGel® M to cool down in the air for 60 to 90 minutes.
- Detach the model carefully from the gel mould. Blow-dry the gel mould with air as necessary.



Duplication with investment material Mix the investment material according to the manufacturer's instructions and pour into the gel mould without bubbles. After the setting time (see manufacturer's data) detach the gel mould carefully from the duplicate model.

Duplicating with plaster Mix the plaster (recommended type 4) according to the manufacturer's instructions and pour into the gel mould without bubbles. Hardening time from 30–45 minutes (quick-setting) to 45–60 minutes (slow-setting).

Acrylic casting technique Soak the prepared model in accordance with the special instructions for the acrylic casting technique and place in the flask. If a wax with a softening temperature of between 50 °C / 120 °F and 55 °C / 130 °F is used, the interdental spaces should first be filled with WiroGel® M (using a brush or fingers). The low amount of gel rapidly cools down and serves as a heat buffer against the gel that continues to flow. See special instructions for the acrylic casting technique with regard to the further processing procedure.



- After use clean WiroGel® M of investment material and plaster residues, rinse with clear water and keep in original tub.
- Keep tub closed. Melt liquids that collect in the tub together with WiroGel® M.
- The addition of water prevents dry and brittle gel moulds after repeated use (add approx. 100 ml for 6 kg reused gel; approx. 170 ml for 10 kg).