

Duplicating flask

Thank you for having decided to purchase an item of dental laboratory equipment from BEGO. Our high-quality products are renowned for their reliability and ease of use.

Safety instructions Please read and follow these **Operating Instructions** to ensure safe operation and get the most from your new equipment.

Instructions for use

Availability

– see Fig 1 –

Duplicating flask, small REF 52072
 large REF 52083

consisting of:

- A base tray
- B sleeve
- C stabilization ring
- D palatal insert in three different sizes

Accessories

Stabilization ring with three palatal inserts
 small REF 52079
 large REF 52084

Preparing master model

1. It is **important** to grind master model parallelly.
2. Block out all undercut areas with BEGO blocking out wax.
3. Round off corners of model whenever possible.

Assembling flask

– see Fig 2 –

- Determine size of flask: the gap between master model and sleeve should be 5 to 10 mm.

1. Put master model in the tray.
Push sleeve in.
2. Determine the biggest palatal insert possible and push into the stabilization ring.
3. Only push stabilization ring so far into the sleeve to leave a gap of at least 5 mm for the silicone between model and all parts of the flask. If necessary adjust the palatal insert accordingly.

NB Do not allow the palatal insert to project out of the stabilisation ring, where it would interfere with the support surface for the finished silicone mould.

Making duplicate model

1. Pour thin stream of Wirosil® duplicating silicone in slowly until it reaches at least the circumferential bar of the palatal insert.
2. Allow silicone to harden for at least 30 minutes.
If the investment material model is to be made under pressure, the silicone mould, too, must set under pressure. A pressure of approx. 4 bar is sufficient to ensure that the silicone is also pressed into critical areas. Any bubbles in the silicone are not pressed out, but reduced!

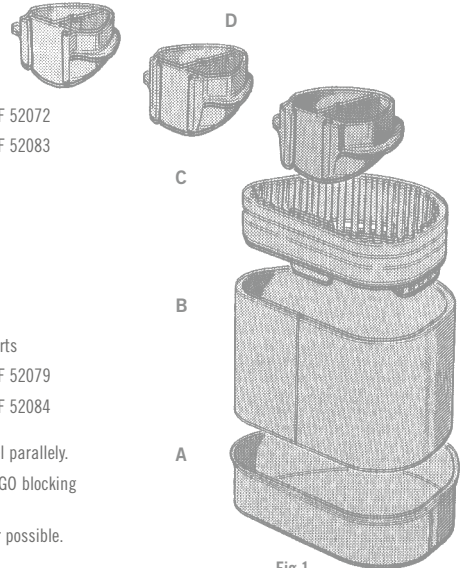


Fig 1

– Dok.-Nr. 85 659/02 –

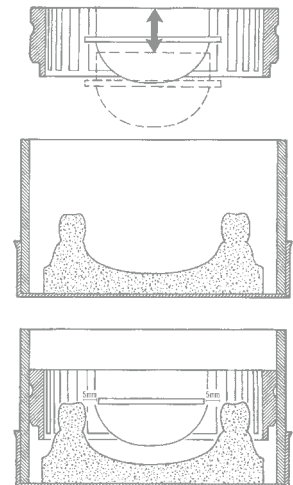


Fig 2

3. After hardening pull base tray off and remove sleeve. Remove the master model with compressed air if possible and pull out of the silicone mould without tilting.
NB Do not lay sleeve around the silicone mould again, as it may deform the mould.
4. **NB** Spray silicone mould sparingly with Aurofilm preparation liquid, then dry very carefully with compressed air! Aurofilm releases the surface tension of the silicone.
5. Mix investment material as described in the Instructions for Use and fill into the silicone mould.
6. Allow investment material to harden for at least 30 minutes.
7. After hardening release the duplicate model with compressed air and remove.
8. Spray duplicate model sparingly with Durofluid to improve the adhesion of the wax.

Recommended equipment and materials

Blocking out wax, 70 g tin	REF 40032
Wirosil®	Two component duplicating silicone, 2 × 1 kg REF 52001
	2 × 5 kg REF 54915
Wirosil® plus	2 × 1 kg REF 54854
	2 × 5 kg REF 54904
Aurofilm	1 atomizer = 100 ml REF 52019
	1 bottle = 1 l REF 52015
Durofluid	1 atomizer = 100 ml REF 52008
Wirovest® investment material,	e.g. 1 carton = 18 kg = 45 pieces 400-g bags REF 51046
Wiroplus® S investment material,	e.g. 1 carton = 18 kg = 45 pieces 400-g bags REF 50248
Wirovest® plus,	e.g. 1 carton = 18 kg = 45 pieces 400-g bags REF 54821
WiroFine investment material,	e.g. 1 carton = 18 kg = 45 pieces 400-g bags REF 54345

Warranty

Whether given verbally, in writing or by practical instructions, our recommendations for use are based upon our own experience and trials and can only be considered as standard values. Our products are subject to a constant further development. Therefore alternations in construction and composition are reserved.