

# Process Tips for Investing & Burnout of Resin Prints with “Prestige” “OPTIMA”

Note: ·For best mix to mix consistency, use distilled, or de-ionized water.

Recommended Mixing Ratios:

For lighter designs, mix using a 38/100 water to powder ratio.

For larger, thicker designs use a 37/100 ratio.

When conventional mixing machines are used: Add powder to the water and mix investment for a minimum of four (4) minutes. Vacuum bowl, pour and vacuum flask using a total working time of 8 minutes.

When Auto Vacuum Investing Machines are used: Mix with no vacuum for one (1) minute, with vacuum four (4) minutes, pour and vacuum flasks using a total working time of eight (8) minutes.

Note: Mixing a minimum of four (4) minutes and using the complete amount of cycle time allotted allows for a complete activation of the control additives used in Optima to promote a more uniform, smoother casting surface.

After the investing cycle has been completed and before starting burnout, allow flasks to sit undisturbed for a minimum of 3 to 4 hours. This allows for the highest green strength of the investment mold to be achieved.

## Burnout:

Best results in the burnout of photopolymer / wax resins using “Optima”, has been by either holding the oven temperature at 100C. (212F.) for 2 to 4 hour to remove all water used for mixing, then fast ramping directly to peak burnout temperature.

Another method is by loading the flask directly into an oven preheated to 500C (932F.) , held for 3 to four hours, then a quick ramp to peak temperatures as high as 780C. (1436F.) held for up to 5 hours, before reducing to desired flask temperature for two hours before casting. .

Personalized Customer Assistance:

For personalized assistance with the burnout of resin using Prestige “Optima”, please contact us through this web-site.