

# Technical Tips for PC 15

PC 15 investment is for use with all pressable ceramic systems. For optimal performance, review the instructions and adjust according to the following guidelines.

## Mold Cracking or Exploding During Burnout

### Solution

- If using paper rings, smooth seam in investment mold.
- If mixing 200 grams or more, reduce mix time to 30 seconds.
- Re-wet mold if benchset was longer than 1 hour.
- If using Rapid Burnout Technique, decrease entry temperature approximately 250°F (139°C).
- Remove mold from ring at 15 minutes. Benchset additional 10 minutes.

## Mold Splitting During Pressing

### Solution

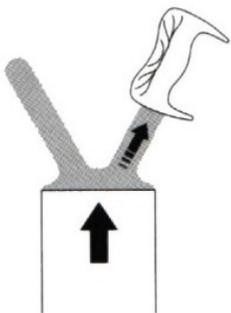
- Increase hold time at high temperature 5-10 minutes before the pressing begins. This will help completely soften the ingot.
- Check for internal and external cracks. Review benchset and burnout procedures.
- Ensure molds sit level and perpendicular to the furnace base.
- Increase heat soak time in burnout furnace, 10 minutes per mold.

## Reaction Layer

### Solution

- Review glass manufacturer's instructions.
- Decrease your maximum pressing temperature in increments of 5°C, until the reaction layer is minimized. **Note:** Check manufacturer's recommendation.
- Calibrate pressing furnace.
- Decrease press time in increments of 30 seconds.

## Sprueing Tips



- Use 6 or 8 gauge direct wax sprues.
- Sprue length should be from 4-6mm.
- Total length of sprue/restoration should not exceed 16mm.
- Attach sprue to incisal/occlusal surface. **See diagram.**
- Use smooth connections – avoid sharp angles.
- Place sprues/patterns in line with flow of ceramic material, with a vertical angle of 30°- 45°. **See diagram.**
- Weigh wax patterns with sprues attached. **Note:** See glass manufacturer's recommendations.

