

## **TROUBLE SHOOTING CHART FOR FLEXITE PLASTICS**

<u>TROUBLE</u>	<u>POSSIBLE CAUSES</u>	<u>REMEDY</u>
<b>Short incomplete</b>	Wrong temperature	Check Chart for Correct Temperature.
	Cold Flasks	Check lamps for proper heat. Flasks should be hot to the Touch.
	Improper Sprues	Use sheet of base plate wax for sprue. See page 10 in manual.
	Waxup Too Thin	Check areas where wax stretches in palate.
	Not enough Pressure	175 lbs max. pressure for all plastics.
	Left in oven too long	Check proper time in oven.
<b>Color Change</b>	Overheating	Bring Oven Down to Proper Temp. Check proper length of time in oven.
<b>Bubbles</b>	Overheating	Reduce Temperature or Time.
<b>Streak or Separations</b>	Silicone Grease on Entry Side of Cartridge.	Do not put silicone near entry hole carry only to crimp on cartridge. Occasionally boilout steel chambers.
<b>Raised Bites</b>	Matrix Transfer Not Accurate.	Check Carefully. Cut away stone where interfering with bite.
	Check Metal to Metal Contact on Flasks.	Use Stone for Investing. Follow Instructions in booklet, pge 8 Ditch stone around edges to make sure upper and lower flasks are flush.
	Using 1/2 & 1/2 plaster/stone	Correct by using <b>all</b> stone.
<b>Teeth Popping out</b>	No Diatorics present	Create Diatorics. See page 6