

## Instructions for Hydraulic & Manual Presses & Portable Furnaces

All of us at Perflex want you to be highly successful with our materials. You will be successful with our materials if you closely follow these instructions. These instructions are for Biosens and Acryfree. These instructions can be used with either a Manual Injector or a Hydraulic injector.

After boilout, paint the separator on the models while they are hot.

Wait for the flask to dry.

Drill diatoric holes in teeth.

Cement teeth back into the mould.

By then, flasks should be cool. To heat flasks to correct temperature place open flasks ( two halves ) in pre-heated toaster oven for 17 to 19 minutes depending on material chosen, at 160 to 190F.

At the same time place tube in furnace.

For Biosens, set furnace temperature at 590F.....18 minute heat time

For Acryfree, set furnace temperature to 538F... 20 minute heat time

Take flasks out of toaster oven after 17 minutes for Biosens, and 19 minutes for Acryfree

Bolt the two halves together.

You have one minute to inject!

After injection, wait 2 minutes.

Remove flask from press

Let bench cool for 30 minutes before opening.