

Gresco C & P

Universal Dental Investment for Casting and Pressing

Directions for Ringless Casting

Liquid/Powder Ratio: 22cc/100g envelope

1. Pre-heat burnout furnace to burnout temperature.
2. Mix powder and liquid for 90 - 120 seconds (under vacuum, slow speed).
3. Pour mold, then benchset for 15 minutes.**
4. De-mold, and grind the top if desired.
5. Place ring in hot oven and hold for 30 minutes, then cast. Add 10 minutes to hold time for each extra ring.

***Rings that benchset for more than 30 minutes should be wetted with water prior to burnout.*

Starting Point for Liquid/Water Ratios

*Note: these ratios are based on input from various dental labs, adjust as needed.
Increasing liquid concentration loosens a crown and tightens an inlay.*

Alloy Type	Liquid	Distilled Water
Non-Precious	64% (14.0cc)	36% (8.0cc)
Semi-Precious	55% (12.0cc)	45% (10.0cc)
High Noble	50% (11.0cc)	50% (11.0cc)
Pressable Crowns, Veneers	68% (15.0cc)	32% (7.0cc)
Pressable Inlays	55% (12.0cc)	45% (10.0cc)

Warning: contains crystalline silica. Do not breathe dust when mixing or divesting. Use only with adequate dust collection systems. May cause lung injury if inhaled. For professional use only.

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