Technical table 003  (GB)  
Spacer Manufacturing Procedure

1) Fully waxed-up duplicated model
   a) Duplicate the master preferably using an alginate.
   b) The duplicated model can be made of hard conventional plaster.

2) Position of the waxed-up model in the flask
   a) Remove the undercuts from the model
   b) The plaster layer in the mold must be as high as the model and must not cover the clasps.
   c) Tapered feeding channel from 8 to 3.5 mm.
   d) Use plaster-plaster insulation for the flask before making the countermold.

3) Open flask after wax removal
   a) Close the flask and place it on the oven centering device. Tighten the press manually.
   b) Start the melting process to pre-heat the flask.

4) The cast in the flask

5) Spacer placed on the master again.

Pressing® Mod. J-100 must be programmed as follows:

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Melting temperature</td>
<td>220 °C</td>
</tr>
<tr>
<td>Melting time</td>
<td>20 minutes (J-100 Timer 1)</td>
</tr>
<tr>
<td>Heating time after injection</td>
<td>02 minutes (J-100 Timer 2)</td>
</tr>
<tr>
<td>Cooling time under pressure</td>
<td>20 minutes (J-100 Timer 3)</td>
</tr>
<tr>
<td>Injection pressure</td>
<td>04 Bar (J-100)</td>
</tr>
</tbody>
</table>

Remove the flask only at the end of the cycle.

a) Open the flask when it is at room temperature.

b) Conventional burrs for acrylic resins can be used for the finishing process.

c) To enhance polish use "Universal Polish"