

# Servo Cast

## Precision investment for model casting

Servo-Cast is a high-precision investment for model casting, suitable for all polyether and silicon duplicating materials (final muffle temperature appr. 850 to 950 °C). Not indicated for Gel-duplication (Agar-Agar)!

## Instruction for use

Duplicate the carefully prepared and cleaned master model with Simply-Blue or with a similar elastic duplicating material.

After the duplicating material (Simply-Blue) has hardened, remove the master model from the form by means of air or using a suitable instrument (in the duplicating technique with flasks, the duplicating material must always remain in the flask part).

## Duplicating models (36 to 40 ml liquid: 200 g powder)

Mix Servo-Cast model-casting investment material under vacuum for 45 to 60 sec. Set the vibrator to a medium frequency and pour the investment slowly in the duplicating form, starting from the highest point. The duplicating form being filled with Servo-Cast investment switch off the vibrator immediately. Servo-Cast must set vibration-free, at room temperature for at least 30 min.

**In order to achieve constant results, measure and weigh exactly both liquid and powder.**

## Concentration\*

Combination Works	20ml/100g
High precious alloys	20ml/100g
Attachment works	20ml/100g
sceletrate works	18ml/100g

\*per 100% Concentrate

## Expansion instruction:

less liquid	→	more expansion
more liquid	→	less expansion

## Pre-drying the model

10 – 15 minutes at 120°C – 150°C. Subsequently use Servo-Fix adhesive to get a better bonding strength for the wax.



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## Coating (72 to 80 ml liquid: 400 g powder)

The liquid may become diluted with distilled water until 50%. Fill the casting form by medium vibration frequency and let the investment set in the flask, vibration-free for at least 30 min. Using closed flask systems, we recommend to coat the flask inside with Servo-Liner, before filling with Servo-Cast model casting investment. In this way, the setting expansion takes place smoothly, cracks in the flask may be avoided and the investment can be removed more easily out of the ring.

Grind both top and bottom side of the form slightly on the dry trimmer. The casting form is now ready and can be set into the oven (crucible former at the bottom side).

## Heating and holding times

Heating times	Holding times
4°C – 5°C/minute up to 300°C	60 minutes
7°C – 8°C/minute up to 600°C	hold 30 minutes
10°C/minute up to 900 – 950°C	hold 60 minutes

Start the casting procedure now.

We recommend to store the liquid at a temperature between 20 – 22°C.

- Servo-Cast** provides exact reproduction and the highest precision thanks to a particular grain composition.
- Servo-Cast** guarantees thermal stability (appr. 850 to 950 °C muffle temperature).
- Servo-Cast** grants perfect metal surfaces and extremely smooth inside areas.
- Servo-Cast** promises an extraordinary flowing capacity and a suitable processing period of time (appr. 5 min).
- Servo-Cast** owns a high gas permeability.
- Servo-Cast** offers a perfect fit for all chrome works thanks its favourable expansion values.
- Servo-Cast** ensures easy and smooth deflasing.
- Servo-Cast** guarantees easy sand-blasting.
- Servo-Cast** requires no electrolytic polishing.