

Niranium

FOUR SEASONS

PRECISION "WATER-MIX" INVESTMENT FOR CASTING PARTIAL DENTURES

INTRODUCTION

Niranium's FOUR SEASONS Investment has been successfully used in quality dental labs for many years. Due to its well-distributed, small particle size, Four Seasons assures a smooth surface and an accurate casting. Four Seasons has been developed to be compatible with Niranium ORGANA II™ and INSTALOID™ (Niraloid) Hydrocolloids. It is also compatible with Polysilaxane Rubber duplicating systems.

Specifications	
Working Time:	5 Minutes
P to L Consistency:	100 g : 11 cc
Ready for	
Model Separation:	1 Hour
Ready for Burnout:	1 Hour
Burnout Temperature:	1800°F (982°C)
Setting Expansion:	0.25%
Thermal Expansion:	1.4%

DIRECTIONS

Surveying

Survey and design the master model utilizing the technique of choice.

Duplicating

Add exactly 22cc water to 200 grams (7 oz) Four Seasons Investment and spatulate vigorously until mixed thoroughly. Carefully vibrate mix into the negative colloid mold. Allow to bench set for 55 minutes.

Caution: During the summer months when temperature goes above 80°F (27°C) keep water temperature at about 70°F (21°C) otherwise investment will set too rapidly. It is advisable to pour not more than two (2) models at a time.

The model is removed with a sharp knife by creating 4 to 6 slices and peeling like a banana or orange. Place model in Model Drying Oven at 450°F (275°C) for 1/2 hour then submerge in Niranium model Dip for no more than 10 seconds at 250°F (121°C) and allow to drain and cool. If Niranium cold Model Dip is used, follow the directions on label.

Waxing

Use technique of choice using Niranium Patterns, Niranium Stipple waxes and Wax Mesh. The use of Niraseal with applicator helps plastic forms to adhere. It is important to note that this material should be applied sparingly, otherwise it will lay on the surface of the model and cast as a fin.

Spruing

Use Niranium Sprue Cone (central reservoir built-in). The case should be sprued in 8 to 10 gauge (2.5-3mm) wax. Use from 2 to 4 sprues depending on size. Set the sprued case in the Niranium Split Ring Base using wax so that the model will remain stationary. Apply Niranium Precoat Paint-On to wax up areas and shake off excess. Allow to dry 12-15 minutes. (Wetting solution may be used as a substitute.

FOUR SEASONS

Investing

Set an Inconel Split Ring on the base sealing both the seam and bottom with wax. For average cases, mix 66-68cc water with 594 grams (21 oz) Four Seasons Investment. Spatulate and pour into split ring. Allow to bench set for one hour. Remove the base and place in the furnace with the split ring.

Burnout

Run Furnace up to 500°F (260°C) and hold for one hour. Then increase to 1850°F (1010°C) and hold for 30 minutes before casting. **Note:** *More rapid run up will cause fins and cracking.*

NIRANIUM FOUR SEASONS "WATER MIX" Investment Product Line

Stock No: 805004	55 Lb (25 Kg) Four Seasons Powder (<i>Water-Mix</i>)
Stock No: 806004	5 Gal (18.9 Ltr) Organa II Hydrocolloid
Stock No: 72-10	1 Gal (3.79 Ltr) Instaloid "Concentrated" Hydrocolloid (<i>Makes 3 Gallons</i>)
Stock No: 806008	1 Gal (3.79 Ltr) Niraloid "Concentrated" Hydrocolloid (<i>Makes 3 Gallons</i>) Export Only
Stock No: 805005	8 Oz (237 cc) Precoat Liquid Paint-On
Stock No: 807003	5 Lb (2.27 Kg) Flake Model Dip
Stock No: 807093	1 Gal (3.79 Ltr) "Environmentally-Safe" Cold-Dip

WARNING

This Product Contains Free Silica

Inhalation of dust may be harmful to your health and excessive inhalation will increase the risk of serious respiratory disease (silicosis).

Take appropriate protective measures to avoid breathing dust.

Immediate clean-up of spills is highly recommended.

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