

Operating Instructions

YETIVEST®

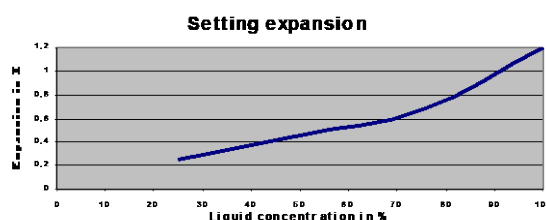
Crown and Bridge Investment Material

YETIVEST is a phosphate-bound precision investment material for all precious, metal to ceramic and non precious alloy. YETIVEST can be used as Speed investment or the traditional way by using the Preheating progress.

Setting expansion	1,20 %	Flow capability	13cm
Thermal Expansion	1,10 %	Working time (20-22 °Grad)	4-7 min
Total expansion	2,30 %	Pressure	4 MPa

Physical properties (100% Liquid-Concentration) EN ISO 9694 (1998)

Ring	YETIVEST Powder	YETIVEST Liquid/dist. Water
X3	1x160g	35 ml
X6	2x160g	70 ml
X9	3x160g	105 ml

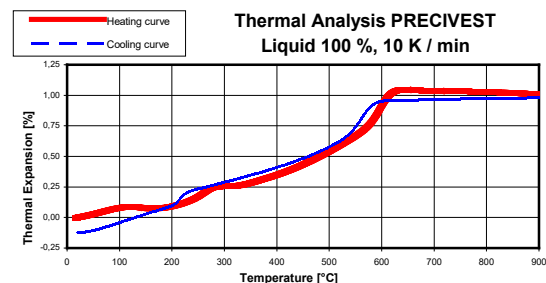


Expansion

YETIVEST Investment will be mixed with the YETIVEST Liquid as mentioned in the below table. The Expansion of the investment can be controlled by the quantity of the distilled water mixed with the YETIVEST Special Liquid. The total liquid quantity (160g-35ml) must not be exceeded. The *Expansion* of YETIVEST is even to the metal contraction according to the below table depending on the type of alloy used by the technician.

Higher is the concentration of the special liquid, higher is the total expansion of the investment.

Type of the Alloy	Mixing Ratio
Crown and Bridge / Wax	
Low melting alloys Concentrate	55%
Metal to Ceramic Gold alloys Concentrate	65%
Non precious alloys Concentrate	95%
Inlays and Telescope crown / Wax	
Low melting alloys Concentrate	45%
Inlays and Telescope crown / Synthetic material	
Low melting alloys Concentrate	50%



By using the Non Precious metal to ceramic alloys, we suggest you to mix 80% of the High Expansion liquid 931-2000, with 20% distilled Water which increases 0,5% the setting expansion, and which is equivalent to 100% of the normal standard liquid.

STORAGE

The storage of the powder and the special liquid must be done at a normal room temperature (21°C). In case the special liquid for investment is stored in a temperature below 5 °C, it will be subjected to be frozen and will not be suitable to be used. Storage shelf life YETIVEST Powder and YETIVEST Liquid is 24 months.

Packaging

Item. Nr.: 930-0160	YETIVEST Powder	- 4,0 kg (25x160 g)
Item. Nr.: 931-1000	YETIVEST Liquid	- 1000 ml Bottle
Item. Nr.: 932-0000	YETIVEST Powder + Liquid	- 4,0 kg (25x160 g) + 1000 ml
Item. Nr.: 931-2000	YETIVEST High Expansion Liquid	- 1000 ml Bottle

Dokument:	Erstellt am/von:	geändert am/von:	Revision:	freigegeben am/von:	Seitenzahl:
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Best and steady results are obtained when storing and working at a constant room temperature of 21°C (min. 20°C).

The mixing bowls must not be dry and not suitable for mixing gypsum. The mixing units might have an influence on the quality and your work, for that reason they must be regularly checked.

Preparation

Debubbilizer can be used, (Yeti 142-0000) but it is not obligatory. Be sure that the wax is totally dry before start working.

Flask System

Use a wet flask liner and coat totally the metal casting flasks. Use a double coat liner when using a X9 flask.

Mixing

First fill in the liquid and than the powder and mix by hand with a clean spatula (not a gypsum spatula). Put the under vacuum for 15 seconds without using the mixing machine. Than the Investment must be mixed for 60 seconds under the vacuum.

Setting Time

The working time (21 °C) is 6 Minutes since starting the mixing procedure. The setting time must be carried out under small Vibration. Stop the filling and the usage of the vibrator when the metal ring is full, and let the casting flask sets for about 30 minutes.

Please do not use any Vaseline.

It is also possible to have the flask set at a pressure of (2-3 bar) maximum.

Deflasking

After a setting time of 30 Min. at 21° C and having the flasks cool down deflask prudently.

Preheating temperatures

Adjust your oven at the necessary temperature depending on the type of alloy used, and place the flask with the sprue former downwards on the corrugated base plate of the preheating furnace.

Use a sharp knife to scratch the surface of the investment in the upper part of the flask.

700-750°C	for Gold Cast Alloys
750-820°C	for Metal to Ceramic Alloys
820-850° C	For Non precious Alloys

Rapid Firing

Only flasks with the following sizes X1 - X6 are allowed to a High-Speed Burnout.

According to the alloy type and after the setting time of the investment (30 min.), place the flask directly in the furnace at the final temperature.

Holding time at final temperature **X3 for 60 min.** **X6 for 90 min.**

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Preheating methode

Heating process	Heating rate	x 3	x 6	x 9
1. Holding step 170°C	4-6°C/Min.	45 min.	60 min.	90 min
2.- Holding step 300°C	4-6°C/Min.	30-45 min.	60-90 min.	60-90 min.
3. Holding step 580°C	8-10°C/Min.	30-45 min	60-90 min.	60-90 min.
Final temperature 700-850°C	8-10°C/Min.	30-45 min.	60-90 min.	60-90 min.

Casting/Cooldown

Upon removal from oven, independent from the way of casting, centrifuge, vacuum pressing, open flame, immediatly cast according to alloy manufacturer's instructions. Place the flask with the sprue former in the upper direction to allow a rapid cool down of the YETIVEST in a room temperature.

Important recommendations

The investment material contains Quartz. Do not BREATH DUST ! May cause delayed lung injury.

The above given instructions correspond to the actual technical status. We assure a very high top quality of our products, any claim must be only made up on the quality of our merchandise.

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