EN

Lithium Disilicate-Based High Fusion Press Ingots

Amber® Press *Master*

User's Manual

www.hassbio.com

CE 2195 RX Only

Human-Aid System Supplier beLIVE HASS

Amber® Press Master User's Manual

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Lithium Disilicate-Based High Fusion Press Ingots

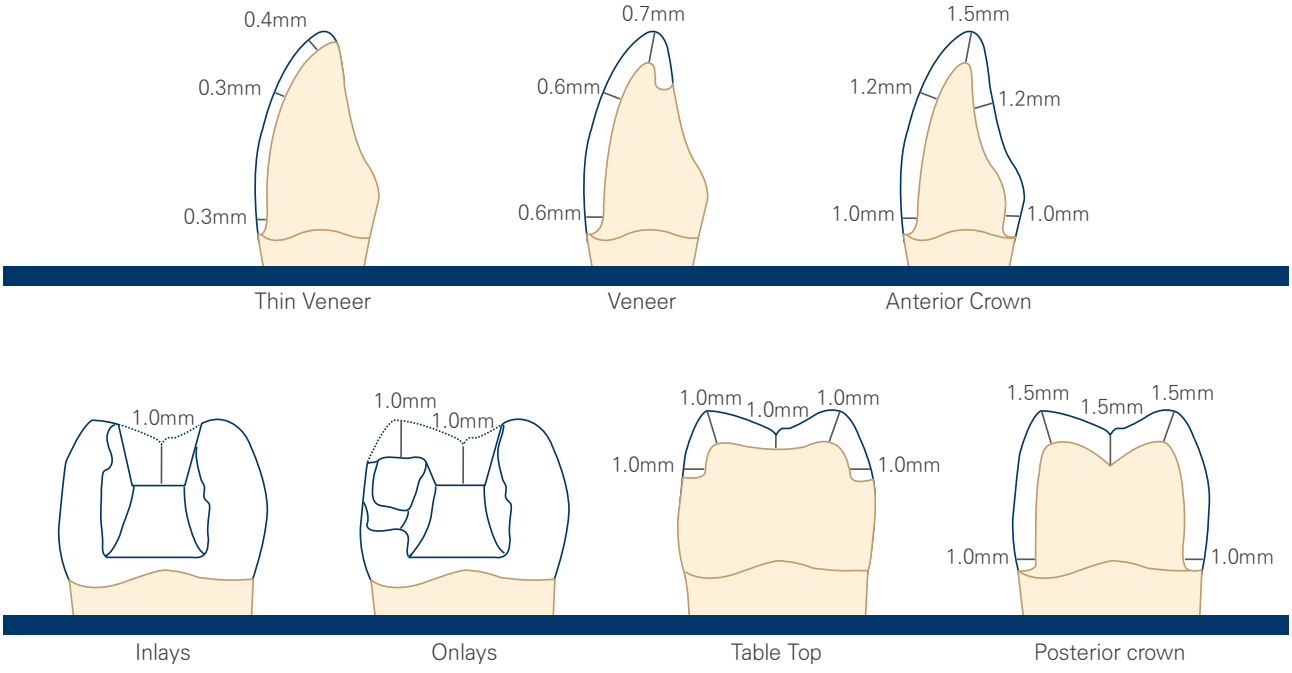
Amber® Press *Master*

Robust Framework for multiple firing

Broad compatibilty with Veneer powders

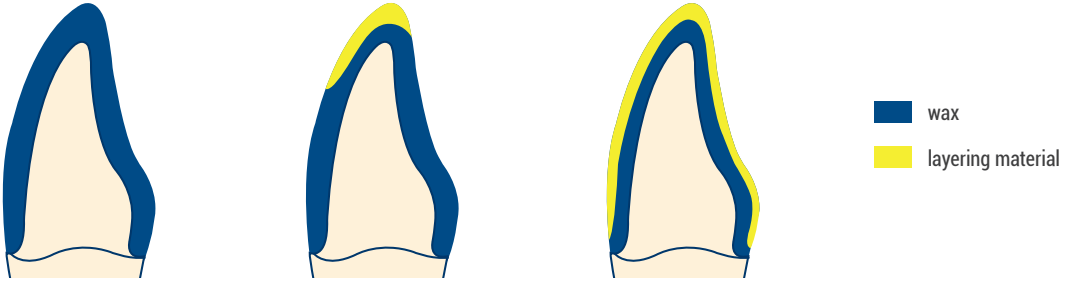
Natural aesthetics with fluorescence and opalescence

2. Preparation Guide



3. Select the ingots(for technique & indication)

For technique



Staining technique
HT+ / MT

Cut-back technique
HT+ / MT / LO

Layering technique
HT+ / MT / LO

For indication

Indications								
Table Tops	Thin Veneers	Veneers	Inlays	Onlays	Partial Crowns	Anterior Crowns	Posterior Crowns	3-Unit Bridges
HT+ (High Translucency plus)								
MT (Medium Translucency)								
					LO (Low Opacity)			

4. Select the ingots(for shade)

Available shades

HT⁺(High Translucency plus)

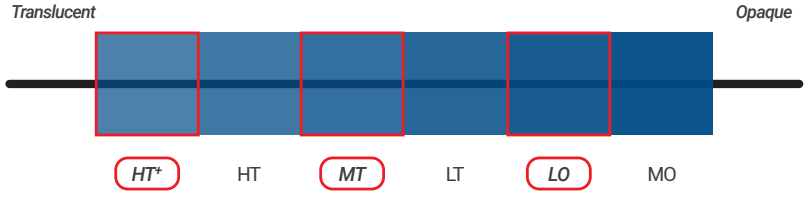
W0.5 A0.5 A1.5 A2.5

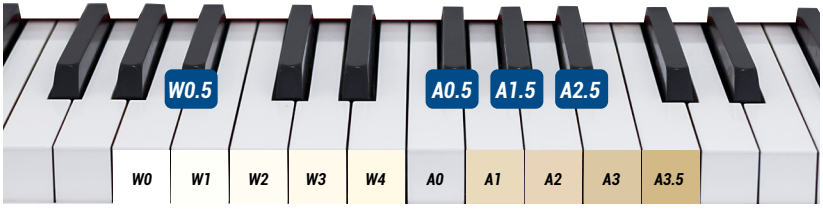
MT(Medium Translucency)

W0.5 A0.5 A1.5 A2.5

LO(Low Opacity)

0 2

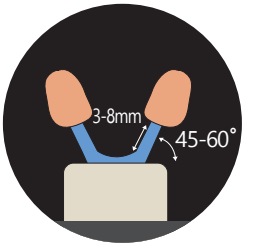




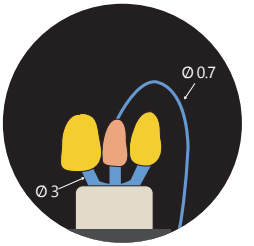
5. Sprueing

Attach the sprues in the direction of flow for ceramic so that ingot can flow smoother during pressing.

⇒



Connect the object and investment ring base at an ∠45~60°angle, at a length of 3~8mm, using ⌀3~3.5 mm of spruing wax.

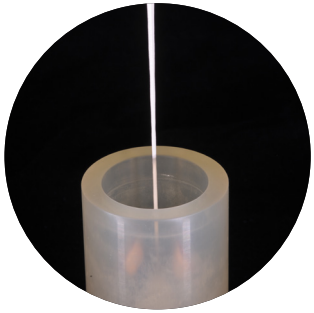


Keep a distance of at least 5 mm between the wax-up objects and silicone ring.

It is recommended to attach sprueing wax to each crown and it aids gas ventilation if air vent is attached in the thick part.

6. Investing

After mixing powder and liquid by hand for 20 seconds, mix it again with vacuum mixer. If it has hardened in the pressurizer after investing, strength and surface roughness are enhanced during pressing.



TIP!

For details, please refer to the IFU from the investment material manufacturer.

Phosphate-based investment material for ceramic press

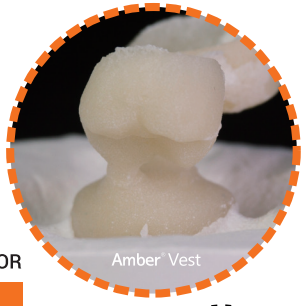
Amber® Vest

Packaging: KIT POWDER + EXPANSOR

Amber® Vest POWDER
5kg (50X100g)

+

Amber® Vest EXPANSOR-B
LIQUID (1,000ml)



Comparison of Reaction Layer Generation on Surface

7. Preheating(Burn-Out)

- Remove the silicone ring only after the investment is completely set.
- Trim the upper side flat and place the investment ring in the preheating furnace.
- The lower side of the investment should face down. Pay attention to ensure good drainage of the melted wax.

Setting time	**min. 30 min, max. 45 min.**
Preheating furnance temperature	**850°C(1562℉) ; Switch on the preheating furnace in time**
Position of the investment ring in the preheating furnace	**Towards the rear wall, tipped with the opening facing down**
Final temperature upon preheating the investment ring	**850°C / 1562℉**
Holding time of investment ring at the temperature	**100g investment ring - min. 45 min.**
Ingot & plunger	**no preheating**
Plunger (option)	**no preheating**

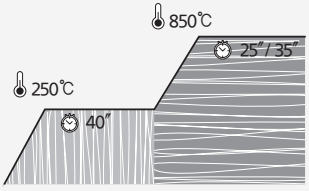
TIP!

Burn-out temperature and time should be according to the manufacturer`s guidelines.

ex) Phosphate-based investment material for ceramic press

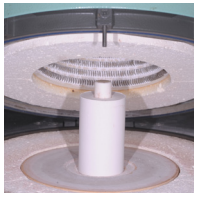
Amber® Vest

The highest temperature : 850℃



8. Pressing

Make sure to put the ingot and plunger into the ring only at room temperature. At this time, printed side of the ingot should face up. Check if the ring bottom is placed flat.



Proceed to pressing the ingot at the appropriate temperature.

Pressing Schedules

Austromat 654 press-i-dent

Translucency	Start Temp. (°C)	Heating Rate (°C/min)	Max. Temp. (°C)	Holding Time (min)	Pressing Duration	Press level
HT+ / MT / LO	**700**	**60**	**945**	**20**	**Auto 1**	**5**

*Austromat 654 press–i–dent is a registered trademark of DEKEMA.

EP3000

Stand-by temperature B (°C)	Closing time S (min)	Temperature increase rate t (°C)	Holding temperature T (°C)	Holding Time H (min)	Vacuum on V1 (°C)	Vacuum off V2 (°C)	Long-term cooling L (°C)	Cooling time tL (°C)
700	**3:00**	**60**	**935**	**10:00**	**750**	**935**	**690**	**-**

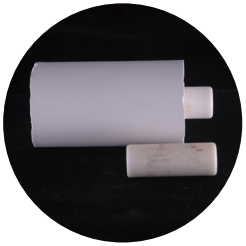
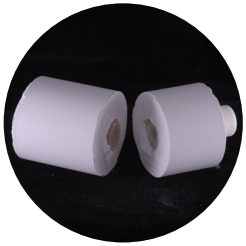
*EP3000 is a registered trademark of Ivoclar Vivadent.

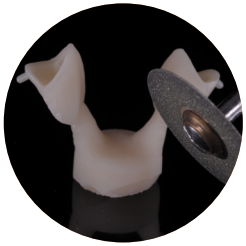
TIP!

Before you press ingots, please verify that the above recommended schedule is suitable for the furnace being used. Otherwise, try to find the optimized pressing temperature though the following process.

- If there are some traces of tiny bubbles on the surface of object, reduce the max. temperature by -5~-10°C and retry the pressing procedure.
- If the marginal area of object is not formed completely, increase the max. temperature by +5~+10°C and retry the pressing process.

9. Divesting



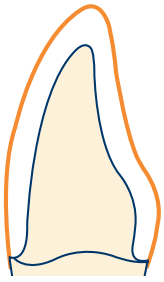
First check the length of the plunger and cut the investment with a disk.

Use Al_2O_3 for sandblasting.
4 bar of pressure for general blasting and 2 bar for precise blasting is recommended.
Be cautious and only work after the ring has fully cool down.

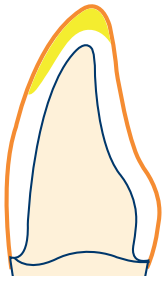
TIP!

When cutting sprues, keep getting disk wet with plenty of water so that you can be cautious about micro fracturing.
Refer to the instructions for use of the corresponding investment materials. Just few amount of reaction layer remains on the result at the recommended temperature.

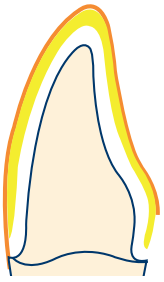
10. Characterization & Glazing



Staining technique
HT+ / MT



Cut-back technique
HT+ / MT / LO

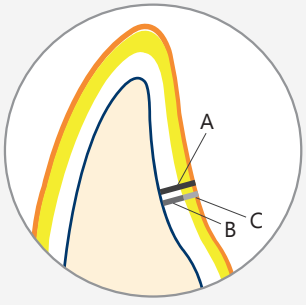


Layering technique
HT+ / MT / LO

Staining & Glazing
layering material

TIP!

Layering technique thickness



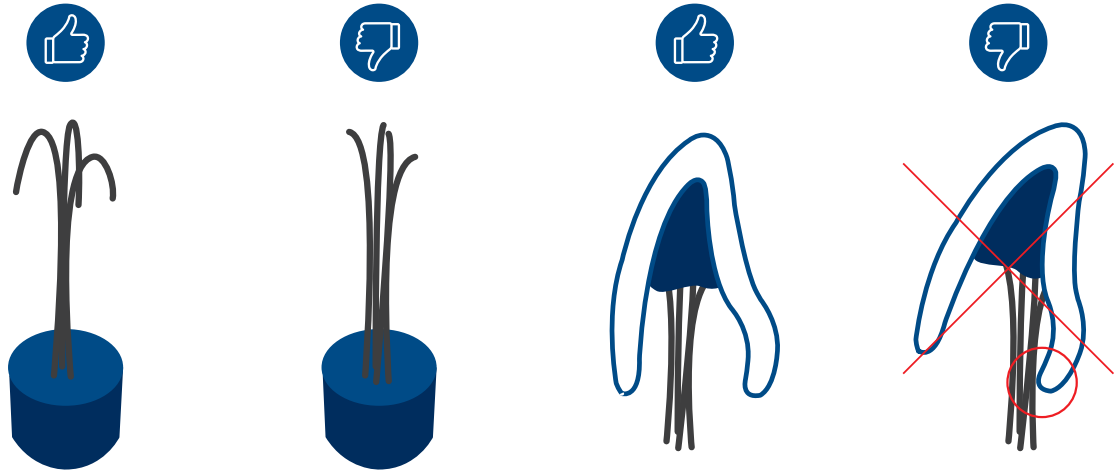
Dimension in mm

A	0.8	1.0	1.2	1.5	1.8	2.0	2.5	3.0
B	0.4	0.5	0.6	0.8	1.0	1.1	1.3	1.6
C	0.4	0.5	0.6	0.7	0.8	0.9	1.2	1.4

A : Overall thickness
B : Framework thickness
C : Layering material thickness

After contouring, sandblasting the spot with Al_2O_3 where staining procedures would be done, using 1 bar or less pressure. Apply the stain in accordance with the target shade.

11. Supporting Pins



TIP!

- Use the honey-comb firing tray and rounded supporting ceramic pins or metal pins..
- **When using, be careful that the pin does not directly touch the prosthesis.**

12. Indications / Contra-Indications

Indication

- Inlays
- Onlays
- Veneers
- Anterior Single Crowns
- Posterior Single Crowns
- 3-Unit Bridge
  *up to the second Premolar

Contraindication

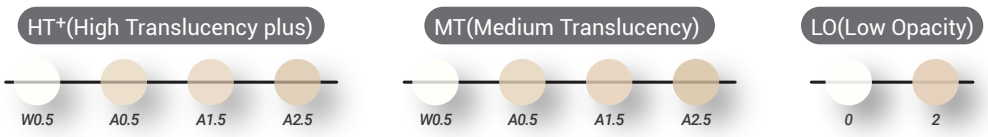
- **Very deep subgingival preparations**
- **Maryland bridges**
- **Patients with severely reduced residual dentition**
- **Bruxism**
- **Cantilever bridges**

13. Product Line-up

Product Line-up

Amber® Press Master		Dimensions (mm)	pcs / Pack
	R10	Ø12.7 x T 10	5 ingots

Available shades



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