

Magicast Instructions for Use

INTRODUCTION

The Magicast ring system has been developed to eliminate the problems caused by tight fitting crowns, porosity, miscasts, distortion and rough castings. It comprises three different sizes of rings, direct and indirect sprue wax patterns and wax buttons.

INDICATIONS

Production of ceramic alloy castings in either precious, semi-precious or non-precious alloys.

CONTRA INDICATIONS

Only use with an investment such as Rapicast which is able to be cast ringless without the support of a metal ring.

TYPICAL CHEMICAL COMPOSITION

37mm ring clear	Base red
50mm ring clear	Base blue
63mm ring clear	Base clear
Indirect sprue 4mm	Light red
Indirect sprue 5mm	Dark red
Direct sprue 3mm small	Light red
Direct sprue 3mm large	Dark red
Button	Dark red

WAXING-UP

Select the appropriate sprue former for the type of casting. Direct or indirect sprues may be used for single units but indirect sprues are recommended for bridge work.

Use the smaller light red sprues for high gold or heavier alloys and the larger dark red ones for high palladium and non-precious alloys. For custom sprues use the button only.

Ensure that the chosen button or sprue is firmly positioned in the selected base. If using the preformed sprues the bar, which acts as a reservoir, will be positioned automatically in the heat centre of the ring.

INVESTING

Paint the wax pattern with a surface tension reducer. Use the following number of sachets of investment for each size of ring.

37mm ring (red base)	2 x 50g/60g sachet
50mm ring (blue base)	3 x 50g/60g sachet
63mm ring (clear base)	5 x 50g/60g sachet

Use the investment in accordance with the manufacturer's instructions. Vacuum mixing is recommended for best results. Gently pour the investment into the ring with light vibration to avoid trapping air. The clear rings permit visual confirmation that the investment has fully flowed around the pattern.

PREPARATION FOR CASTING

Please refer to Investment instructions for use.

STORAGE

Store in a cool, dry place.
Waxes start to deteriorate above 25°C.

HEALTH & SAFETY

Use in a well ventilated room.
Do not inhale fumes from molten wax.

This product is specifically formulated for use in dentistry.