

VERICORE WAX MILLING DISC

Instructions for Use

Description:

Vericore Wax milling discs are available in a blue color, 98mm and 100mm diameters, and 12mm, 16mm and 20mm thicknesses. They can be milled by any milling system accepting 98mm or 100mm discs. They are made of a special burnout wax that is used to create the mold in dental casting/pressing investment. They are not indicated for intraoral use.

Nesting and Milling:

Follow the CAM software manufacturer's recommendations to achieve the most efficient nesting design for the size disc that you are milling. Use an appropriate number of sprue attachments and position them properly to ensure that the wax units stay in place during the milling process until they are intentionally removed.

Investing & Burnout Instructions:

Follow investment manufacturer's instructions for mixing and investing. Attach sprue to the wax pattern using pliable sticky wax. Spray with Whip Mix SMOOTHX Wax Pattern Cleaner. Gently blow excess cleaner from pattern. If metal ring is used,

line casting ring with a ceramic or dry paper liner positioned 6 mm short of each end. (Do not wet the ceramic liner.) Soak paper lined ring in water for a minimum of 1 minute. Then shake excess from ring before investing. Place ring onto former base. Use a vacuum mixer when mixing the powder and liquid(s) to ensure a bubble-free casting or pressing.

Burnout Benchset:

Once the mold is poured, benchset 15 minutes minimum. Trim glaze off top of mold before burnout. For best results, place in preheated oven within 30 minutes of investing. Note: Use rapid burnout method for benchset up to 1 hour. For longer than 1 hour, conventional burnout is recommended. Molds allowed to set more than 12 hours should be re-wet prior to burnout by soaking in water for 1–3 minutes.

Burnout for Phosphate Investments:

Rapid Technique (Preheated Oven): Place molds in preheated oven at alloy manufacturer's recommended temperature, up to 925° C (1,700° F)*. For higher temperatures, place molds

in oven at 925° C (1,700° F) then heat to final temperature at 14°–20° C (25°–35° F) per minute. Heat soak at final temperature for 30 minutes, add 10 minutes per additional mold.

*Note: Maximum preheat entry temperature for metal ring is 870° C (1,600° F).

Standard Technique (Cold Oven): Place molds in oven at room temperature. Heat to desired temperature at 14°–20° C (25°–35° F) per minute. Heat soak at final temperature for 30 minutes, add 10 minutes per additional mold.

Casting (Alloy): Upon removal from oven, immediately cast according to alloy manufacturer's instructions.

Pressing (Pressable Ceramics): Press according to ceramic manufacturer's recommendations. Use 200 gram mold for restorations requiring two ingots.

Divesting:

Allow metal castings and ceramic pressings to cool completely before divesting.

Other High Quality Whip Mix Vericore Milling Materials Include:



Unshaded Zirconia



Shaded and Group
Shades Zirconia



HTX Zirconia
Extra Translucent
and Group Shades



ZR PRO Zirconia
Extra Strong,
Extra Translucent



PMMA Gradient
Temporary



PMMA
Blue Burnout



PMMA
Clear Burnout



PMMA Ivory
Try-in/Burnout

