

Inlay Maker™

INSTRUCTIONS FOR USE

The Microstar® Inlay Maker™ is a revolutionary investing cylinder specifically for pressing inlays and onlays. Its oval cylinder provides a one-to-one relationship between the wax pattern and pressed inlay, permitting the divested ceramic to be seated with minimal effort. Inlay Maker™ also offers the ideal temperature and expansion during bench set, pre-heating, and pressing.

Note: *The Microstar Inlay Maker is designed to provide best results using HS-PC™ Investment, a very low expansion phosphate-bonded material specifically for inlays and onlays.*



1. Lubricate the Inlay Maker using a dry Teflon/silicone spray developed specifically for the laboratory industry, such as Handler SPL 88.
Do not use Vaseline or cooking spray!
2. Sprue patterns at a 30° angle and at least 5mm from the walls of the ring.
3. **Do not dilute HS-PC™ Investment to less than 30% HS™ Expansion Liquid** to 70% distilled water (minimum 7.5mL HS Expansion Liquid + 17.5mL water per 100g bag).
4. After pouring the ring and positioning the level cap, start the timer for the bench set. Let the ring set for 15 minutes. It may be helpful to place a heavy object, such as a brick, on the level cap to provide extra compression.
5. After 15 minutes, remove the ring from the Inlay Maker and let it sit for 30 seconds. Then place the ring into the center of a pre-heated burnout furnace at 1600°F. Ideally, the ring will have been placed into the burnout furnace between 30 and 45 seconds after being removed from the Inlay Maker, as setting expansion continues to increase until the ring is loaded into the furnace.
6. If using a 100g Inlay Maker, burn out for 45 minutes. If using a 200g Inlay Maker, burn out for 60 minutes. Then proceed with the pressing cycle.
7. The 100g Inlay Maker is designed to press a **maximum of 1 unit per “wing” only. A 100g Inlay Maker can press a maximum of two inlays per pressing.**

If you have any questions, please call the Jensen Technical Department at (800) 243-2000.