

Read the instruction carefully,
and keep it for future reference.

Refractory Die Material **Nori-Vest**

[FEATURES]

1. It has a sufficient strength to easily withstand baking and build-up.
2. Nori-Vest is easy to remove after the porcelain is baked, reducing the risk of breaking inlays.
3. The mixed material flows easily, filling all the detail in the impression.
4. The fit is excellent.

[SPECIFICATIONS]

Mixing Ratio	6ml / 30g (1pk.=30grams)
Working Time	3min. at 20°C
Compressive Strength	24MPa (after 1 hour) 48MPa (after degassing)

[INSTRUCTIONS]

1. Use 6 ml of liquid for each 30 gram package of powder. Mix in a vacuum mixer for 40 seconds. Measure the liquid accurately, since the mixing ratio affects the fit.
2. Apply a wetting agent (e.g., Noritake Wax Cleaner) to the impression. Pour the material carefully with a vibrator to avoid bubbles.
3. Wait at least one hour, then remove the refractory model from the impression. Curing time affects both the fit and the surface texture. Do NOT remove the model prematurely. Also, do not wait for more than a few hours.
4. Nori-Vest is a phosphate based model material. The gas created by heating it will adversely affect a porcelain furnace. Using a burnout furnace is recommended.

a) Using a Burnout Furnace only

Dry-out Time	Low Temp.	High Temp.	Heat Rate	Hold Time	Vacuum Level
0	20°C	1,080°C	30-40 °C/min.	10-20 min.	0 kPa
0	68°F	1,976°F	86-104 °F/min.	10-20 min.	0 kPa

- b) Using both a burnout and a porcelain furnace.
First use the burnout furnace, then use the porcelain furnace.

Burnout Furnace Schedule

Dry-out Time	Low Temp.	High Temp.	Heat Rate	Hold Time	Vacuum Level
0	20°C	700°C	30-40 °C/min.	10-20 min.	0 kPa
0	68°F	1292°F	86-104 °F/min.	10-20 min.	0 kPa

Porcelain Furnace Schedule

Dry-out Time	Low Temp.	High Temp.	Heat Rate	Hold Time	Vacuum Level
0	600°C	1,080°C	45-50 °C/min.	10-20 min.	0 kPa
0	1112°F	1,976°F	113-122 °F/min.	10-20 min.	0 kPa

[KIT COMPONENTS]

- 1-1 Set
 - Powder : 30g × 33 packs (990g)
 - Liquid : 200ml
 - Syringe : 1pc.
- Big Set
 - Powder : 30g × 99 packs (2970g)
 - Liquid : 200ml × 3 bottles
 - Syringe : 1pc.

[IMPORTANT NOTES]

1. The degassing temperature affects the fit of restoration. Also improper degassing temperatures can cause cracking of the porcelain during baking.
2. Silicon impression Material: The type of impression material will affect the fit. We recommend the (putty/injection) combination type impression procedure.
3. Use only the provided special liquid to mix the material.
4. Measure the liquid precisely. Mix with a vacuum mixer.
5. Keep the liquid away from freezing temperatures and direct sunlight.
6. Do not inhale dust comprised of this material.
7. Avoid contact with eyes. In the event of eye contact, flush eyes with copious amounts of water.
8. Use protective eyewear.

Manufacturer :
Kuraray Noritake Dental Inc.