

# Pneumatic Denture Injection Machine



**User Manual:**

**Tianjin Lizhong Huier And Technology Development Co., Ltd.**

**Introduction** Our company's invisible dental machine is composed of two parts: a pressure casting machine and an automatic temperature control instrument. It has automatic temperature control, automatic temperature

keeping, and timing reminder functions, making it a necessary equipment for invisible dental processing and manufacturing.

### **Main Technical Parameters**

Voltage	AC 110/220v/50HZ ±10%
Power	400w
Heating temperature	282°C-288°C
Pressure time	7m 30s-11m
Air supply	0.4 Mpa
Weight	33 kg

### **Installation**





1. Connect the Machine to the Air Compressor
  - Connect the pneumatic invisible machine to the air compressor.
  - Adjust the pressure to 0.35-0.4MPa.
2. Place the Mold Box
  - Place the mold box on the pressure casting machine base plate.
3. Install the Heating Furnace

- Install the heating furnace corresponding to the mold box on top.
- Insert the heating furnace from front to back into the two side pillars.
- 4. Insert the Material Push Rod
  - Insert the material push rod from the front into the hole at the bottom of the heating furnace.
- 5. Place the Heating Bucket
  - Place the heating bucket into the heating furnace, and put it on top of the material push rod.
  - Add the invisible glue into the heating bucket (apply high-temperature oil to the invisible glue for easy demolding).
- 6. Connect the Wires
  - Connect the power cord to the machine.
  - Connect the heating wire to the machine.
  - Connect the thermocouple wire to the machine, paying attention to the positive and negative poles.

## Operation

## 1. Setting the Temperature



1, Press the “” button to set the temperature (the default setting is 287°C). Adjust the temperature using the “” or “” buttons, and press the “” button to confirm.

## 2. Setting the Temperature Keeping Time

The temperature keeping time is displayed on the right side of the temperature control table (the default setting is 480 seconds).

Adjust the time using the "⤴" or "⤵" buttons, and press the "↩" button to confirm.

### **3. Machine Operation**

After setting the temperature and temperature keeping time, press the power button to start the machine.

The machine will continuously heat up to the set temperature, and then start the countdown.

When the countdown is complete, the machine will alert with a sound. During the operation, the heating indicator light will be on during heating and off during temperature keeping.

### **4. Molding**

1. After hearing the beep, remove the push rod from the heating furnace.
2. Insert the top block into the machine.
3. Push down the switch and hold it until the casting process is complete.

### **5. Removing the Mold**

After molding, quickly remove the mold to prevent it from becoming difficult to handle after cooling.

**Note:** Due to differences in regional altitude and seasonal temperature, the heating temperature and temperature keeping time should be adjusted accordingly. If the product color is too deep, the heating temperature and temperature keeping time can be increased. If the product color is too light, the heating temperature and temperature keeping time can be decreased.

### **Standard Packing List**

<b>Accessory</b>	<b>Quantity</b>
Heating Furnace	1 set
Injection Mold System	1 set
Denture Flask	1 pc
Heating Charge Tube	1 set
Disposable Cartridge (Small, 8g)	1 pc
Disposable Cartridge (Big, 17g)	1 pc
Gasket (Big)	1 pc
Gasket (Small)	1 pc

### **Common Problems and Solutions**

Symptom	Cause	Solution
1. Heating indicator light is on, but the heating furnace is not heating	Heating circle is broken	Replace the heating circle
2. Heating indicator light is not on, and the heating furnace is not heating	Check if the set temperature is lower than the furnace temperature	Reset the temperature
3. Temperature display shows "----"	Thermocouple is connected reversely or broken	Reconnect or replace the thermocouple
4. Explosive molding	Inaccurate temperature sensing	Check if the thermocouple is in contact with the heating bucket

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