# **Pneumatic Denture Injection Machine**



**User Manual:** 

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

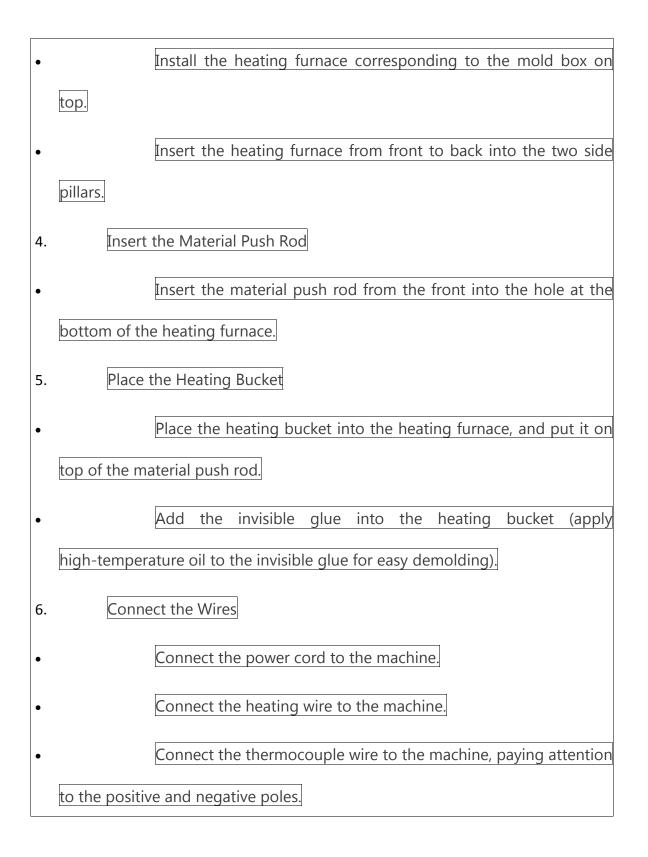
**Introduction** Our company's invisible dental machine is composed of two parts: a pressure casting machine and an automatic temperature control instrument. It has automatic temperature control, automatic temperature keeping, and timing reminder functions, making it a necessary equipment for invisible 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



#### Operation

#### 1. Setting the Temperature



1, Press the " $\bigcirc$ " button to set the temperature (the default setting is 287°C). Adjust the temperature using the " $\approx$ " or " $\approx$ " buttons, and press the " $\bigcirc$ " 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 " $\approx$ " or " $\approx$ " buttons, and press the " $\bigcirc$ " 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**

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

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