

Flexible Denture Injection System



User Manual:

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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

Power Source: AC110V 60Hz / AC220V 50Hz

Rated Power: 350W

Packing size: 40x32x60cm, Net weight: 30Kg





Installation

- 1, Fix the pressure casting machine part to the workbench, and tighten the three force bars accordingly.
- 2, Place the mold box on the pressure casting machine base plate.
- 3, Place the heating bucket into the heating furnace in the temperature control box, and put the invisible glue into the heating bucket (it is recommended to apply high-temperature oil to the invisible glue for easy demolding).

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

After hearing the alert sound, remove the material push rod from the heating furnace, and place the mold box on top.

Move the heating bucket with the invisible glue to the mold box, and rotate the three force bars to complete the molding.

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 furnace is not heating	Heating circle is broken	Replace the heating circle

Symptom	Cause	Solution
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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