

Instructions for use

General information

Wirosil® is an addition-cured two component silicone which, through its excellent dimensional stability, reproduces extremely precise master models. For optimal results, it is important to observe the Wirosil® instructions.

Using the Wirosil® duplicating flask system is highly recommended because it enables effective work and saves up to 15% silicone usage.

Processing:

1. Cut off the nozzles above the marking.

After use, always close the nozzles with the caps.

2. Mix the Wirosil® 1 and 2 components in a measuring or mixing cup in a ratio of 1:1 until showing a homogeneous color. No color reams should be seen. Observe the workable time of about 5 minutes.

3. Pour Wirosil® very gently in a thin stream between the master model and the flask border. Follow the flask manufacturer's instructions.

4. Depending on the room temperature, Wirosil® is hardened after 30-40 minutes. It is to your advantage to harden the Wirosil® form at about 60psi in the Wiropress pressure unit.

Important: The master model and the duplicating model must be made under the same pressure conditions when working with a pressure unit.

5. Gently blow with compressed air between the duplicate mould and the master model.

Then gently remove the master model.

6. Use the Wirosil® funnel former (Order No. 52067), if the casting sprues are to be laid through the duplicate model.

7. Spray Aurofilm wetting agent onto the duplicate model. Dry Aurofilm with a gentle flow of compressed air.

Important: With this technique Aurofilm has to be dried completely, otherwise formation of bubbles could occur.

8. Mix the cobalt-chrome investment material, plaster or resin for models in accordance with processing instructions and pour slowly into the mould while on the vibrator.

Important: When a pressure vessel is used, the same pressure conditions must be applied when making the master model and the duplicate model.

9. After the investment material has set, blow compressed air gently in between the master model and the duplicate mould. Gently remove duplicate model from mould.

Wirosil® data

Processing time	about 5 minutes
Setting time (22°C)	30-40 minutes
Shore-A hardness (1 hour)	17
Ductile yield	250%
Contraction (DIN 13913)	0.03%

Hints for saving material:

1. Grind down master model base to be at least 1 cm high.
2. Cut previous duplications in small pieces and place them in the base leaving sufficient space for liquid Wirosil® to bond around the model.
3. Wirosil® only needs to be poured into the flask to cover the upper edge of teeth on master model by 2mm.

Availability

Basic Assortment Wirosil® Duplicating System

1 bottle (1kg) Wirosil® 1
1 bottle (1kg) Wirosil® 2
1 Wirosil® measuring and mixing bowl
1 Wirosil® spatula
1 Wirosil® duplicating flask, large
1 Wirosil® duplicating flask, small
1 bottle (100ml) Aurofilm
1 bottle (100ml) Durofluid
1 Wirosil® processing instructions
1 instruction for use of duplicating flasks
Order No. 52000

Individual package

Wirosil® duplicating silicone
1 bottle (1kg) Wirosil® 1
1 bottle (1kg) Wirosil® 2
Order No. 52001

Large Package

Wirosil® duplicating silicone
1 tub (10kg) Wirosil® 1
1 tub (10kg) Wirosil® 2
Order No. 51995

Accessories

2 Wirosil® metering pumps for large pack
Order No. 51999
1 Wirosil® duplicating flask , small
Order No. 52072
1 Wirosil® duplicating flask, large
Order No. 52083
1 stabilizing ring with 3 inserts for flasks
small Order No. 52079
large Order No. 52084

1 bottle (100ml) Aurofilm
Order No. 52019

1 bottle (100ml) Durofluid
Order No. 52008