Refractory Die Material **Nori-Vest** Alumina

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

Nori-Vest Alumina is a refractory die material matched to Noritake's Cerabien porcelain which is used on all alumina substructures.
By using **Nori-Vest Alumina** with Noritake's Cerabien porcelain, combination cases (e.g., Cerabien all-ceramic crowns and refractory restorations fabricated with Cerabien) result in a perfect match.

[FEATURES]
1. High strength allows for repeated firings.
2. **Nori-Vest Alumina** is easily removed after the porcelain is baked, reducing the risk of fracturing the refractory restorations.
3. Having a low viscosity allows the refractory material to flow easily, creating smooth, bubble-free models with excellent fits.

[SPECIFICATIONS]

Mixing Ratio	6.6ml / 30g (1pk.=30grams)
Working Time	3min. at 20℃
Compressive Strength	20MPa (after 1 hour) 40MPa (after degassing)

[INSTRUCTIONS]
1. Use 6.6ml 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 and dry. Pour the material carefully using a vibrator to avoid bubbles.
3. Allow to set for one hour, remove the refractory model from the impression. Do not leave in the impression for more than 2 hours. Setting time affects both the fit and the surface texture.
4. **Nori-Vest Alumina** is a phosphate-bonded model material. The gas created by heating will adversely affect a porcelain furnace. Use of 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℃	1,080℃	30-40 ℃/min.	10-20 min.	0 kPa
0	68ºF	1,976ºF	54-72 ºF/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℃	700℃	30-40 ℃/min.	10-20 min.	0 kPa
0	68ºF	1292ºF	54-72 ºF/min.	10-20 min.	0 kPa

Porcelain Furnace Schedule

Dry-out Time	Low Temp.	High Temp.	Heat Rate	Hold Time	Vacuum Level
0	600℃	1,080℃	45-50 ℃/min.	10-20 min.	0 kPa
0	1112ºF	1,976ºF	81-90 ºF/min.	10-20 min.	0 kPa

[KIT COMPONENTS]
○1-1 Set
Powder : 30g × 33 packs (990g)
Liquid : 240ml
Syringe : 1pc.
○INDIVIDUAL ITEMS
Powder : 30g × 99 packs (2970g)
Liquid : 240ml

【 IMPORTANT NOTES 】
1. **Nori-Vest Alumina** is a refractory die material for the porcelain on alumina substructures. Do **not** use **Nori-Vest Alumina** for porcelain fused to metal, porcelain for zirconia or titanium frameworks.
2. Maintain proper degassing temperatures to avoid cracking and improper fit.
3. Silicon impression Material: The type of impression material will affect the fit. We recommend the [putty/injection] combination type impression procedure.
4. Use only special liquid as provided.
5. Measure the liquid precisely. Mix with a vacuum mixer.
6. Keep the liquid away from freezing temperatures and direct sunlight.
7. Do not inhale dust comprised of this material.
8. Avoid contact with eyes. In the event of eye contact, flush eyes with copious amounts of water.
9. Use protective eyewear.
10. **Nori-Vest Alumina** investment contains silica. Over exposure to the dust may cause delayed lung injury.

Manufactured by :
Kuraray Noritake Inc.