

# OXYPLUS™ INVESTMENT & LIQUID



## Ideal for Casting Low Expanding Printed Patterns or Traditional Wax Patterns

An oxyphosphate dental investment and liquid combination that provides easy removal. Provides smooth castings with a short working time. Used for making refractory models for waxing and casting precious and nonprecious, high temperature alloys for partial denture frames.

## Ratios

When making the refractory model, Oxyplus liquid is recommended at a diluted ratio of 3 parts deionized or distilled water to 1 part Oxyplus liquid by volume. Oxyplus liquid ratios will need to be slightly adjusted based on your geographical location and/or climate conditions.

Please note:

- More Oxyplus liquid = more expansion for looser fitted castings
- Less Oxyplus liquid = less expansion for tighter fitted castings

*When investing the outer mold, Oxyplus investment is mixed with deionized or distilled water only. Do not use Oxyplus liquid.*

## Duplicating the Gypsum Master Model

1. Soak the master model in water for 30 minutes (or 2 minutes under vacuum) to remove any air from the gypsum model.
2. Blow off any excess water from the model and place the model into a duplicating flask.
3. Pour in Multiflex™, Uniflex™, Perfex®, or Instaflex™ Concentrate duplicating material from your hydrocolloid conditioning unit.
4. Once filled, place the duplicating flask into a chilled water bath, covering only the bottom of the flask and not the sides.
5. As the duplicating material starts to cool and set up, it will pull toward the cold water, which will cause it to pull tightly over the master model for an exact duplication.
6. Let set for 30 minutes, then remove the master model and allow the duplicating material to bench set to reach room temperature before pouring in Oxyplus investment.

## Making the Oxyplus Refractory Model

	Mechanical Mix	Hand Mix
<b>Powder</b>	200g	200g
<b>Diluted Oxyplus Liquid (3 to 1 Ratio)</b>	25 ml (18.75 ml distilled water to 6.25 ml Oxyplus liquid)	25 ml (18.75 ml distilled water to 6.25 ml Oxyplus liquid)
<b>Mix Time</b>	60 seconds under vacuum	90 seconds

1. Place impression on vibrator and fill the impression with the mixture while vibrating.
2. Remove from vibrator and allow to harden for 30 minutes.
3. Remove the model, trim and dry for 45 minutes at 375-425 °F (190-218 °C).
4. Follow the application instructions for an R&R Rosin Dip and dip the model.



## RANSOM & RANDOLPH

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Made in the USA

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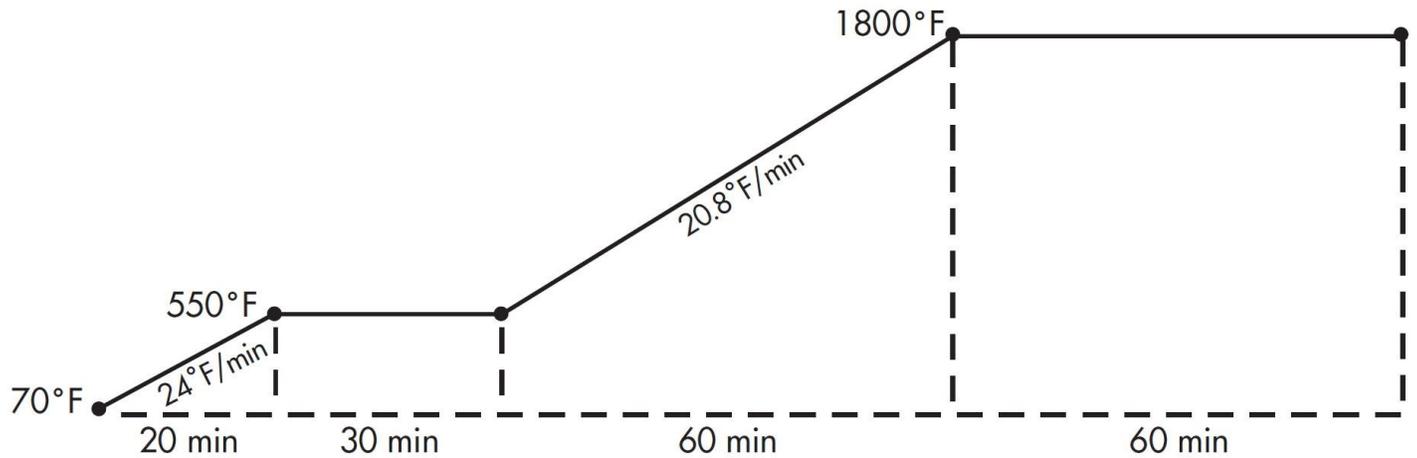
## Investing the Model (Outer Mold)

	Mechanical Mix	Hand Mix
Powder	600g	600g
Deionized or Distilled Water	70 ml	73 ml
Mix Time	60 seconds under vacuum	90 seconds

1. Place the ring on the vibrator and pour the mixed investment into the ring until the wax-up is covered.
2. Vibrate the mix back out of the ring until there is a bubble-free thin coating covering the wax-up.
3. Once a bubble-free thin coating is achieved, vibrate the mix back into the ring until filled.
4. Remove immediately from vibrator.
5. Bench set for 60 minutes.

## Burnout

From	To	In	Hold	Raise To	In	Hold
70 °F (21 °C)	550 °F (290 °C)	20 min	30 min	1800 °F (982 °C)	60 min	60 min



## Technical Tips

For additional information and recommendations, refer to the Dental Investment Defect Analysis Guide Technical Tip available for download at [www.ransom-randolph.com](http://www.ransom-randolph.com).

## Storage

Keep container closed when not in use. Store in a cool dry area.

## Safety

**Liquid:** Warning. Portions of the amorphous silica may be converted to crystalline silica (cristobalite) when subjected to higher temperatures (1700°F/927°C). May cause damage to organs/kidneys through prolonged or repeated exposure. Causes



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serious eye irritation. Do not breathe dust or mist. Get medical advice/attention if you feel unwell. See SDS for more information.

**Investment:** Danger. Contains crystalline silica. May cause cancer by inhalation. Causes damage to lungs through prolonged or repeated exposure. Obtain special instructions before use. Do not handle until all safety precautions have been read and understood. Get medical advice/attention if you feel unwell. See SDS for more information.

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