BegoForm®

Refractory die material for inlays, onlays and facets of ceramic

- Stump material developed on phosphate basis
- The stumps are extremely resistant to edge tear, are smooth and accurate
- Specific ceramic compounds of well-known manufacturers are suitable for inlays, onlays and facets

Partners in Progress

BEGO

Working instructions

1. Duplicating with Wirosil®

Form a wax plate of a thickness of approx. 2 cm. Press the basis of the original stump (for example Pin) into the wax, but not more than 3 mm below the preparation limit.

1.1 Cut a paper sleeve to correspond to the requested height, and stick together. Now put it over the stump and fix by wax.

1.2 Mix and fill the Wirosil® duplicating silicone according to the instructions. Then harden in the pressure unit at 4–6 bars or in the air for 30 minutes. Using a pressure pot provides a higher security.

Important: If the Wirosil® mould sets in the pressure unit, the stump as well has to set in the pressure unit under same pressure. Then remove wax and separate stump from the duplicating form.

2. Production of a BegoForm® stump

- Pay attention to the processing time: at 20 °C approx. 3 minutes
- Mixing ratio: 100 g / 18 ml
- Concentration of mixing liquid: 50 % BegoForm® mixing liquid / 50 % distilled water (see table).

Concentration of mixing liquid		
Mixing ratio 100 g / 18 ml		
BegoForm®	30 g (= 1 bag)	
BegoForm® mixing liquid	2,7 ml	
Aqua dest.	2,7 ml	

2.1 Spray the Wirosil® duplicating mould with Aurofilm preparation liquid, and blow carefully dry.

2.2 Put the BegoForm® liquid in the mixing bowl, add BegoForm® and mix briefly on the vibrator using a spatula. Then mix by machine under vacuum (EasyMix mixers) for 1 minute or manually with a spatula for 2 minutes.

2.3 Pour mixed BegoForm® in the Wirosil® duplicating mould on the vibrator. Allow filled Wirosil® duplicating mould to harden in the pressure unit at 4–6 bars or in the air for 45–60 minutes.

Important: If the Wirosil® mould sets in the pressure unit, the stump as well has to set in the pressure unit under same pressure.

Remove the BegoForm® stump from the Wirosil® duplicating mould.

3. Preparation of the BegoForm® stump

3.1 The BegoForm® stump has to be dried on the reeled-out burning table of the burning furnace for 10 minutes.

3.2 Preheat the BegoForm® stump in the ceramic furnace or preheating furnace at 650 °C for 15 minutes. Then heat to 1,000 °C under vacuum and maintain final temperature for 10 minutes.

3.3 Allow the BegoForm® stump to cool down in the air. Then mark the preparation limits using the BEGO contour pencil. The marks will be heat-proof and well visible still after firing.

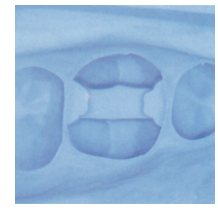
4. Application and firing of ceramic compounds

4.1 Soak the BegoForm® stump before each operation. Dab excessive liquid by using a cellulose cloth. Application and firing of the ceramic compounds are made as per instructions of the manufacturers of the ceramic compounds.

5. Removal of the BegoForm® stump

After the last firing blast out the BegoForm® stump with the help of the precision blaster (Duostar or EasyBlast) using Perlablast® micro at a pressure of up to 2 bars.

The preparation of the MOD inlay without thin terminal borders. The minimum thickness of the ceramic layer has been considered as well. This precision model is made of BegoStone plus.



Due to its high dimensional stability the addition cured two-component silicone Wirosil® exactly reproduces the preparation.

The high refractability of the BegoForm® stump being true to the original enables the direct fusing of the ceramic compounds to the stump.

The preparation limit must be clearly visible. It is marked by a fireproof line using the BEGO contour pencil.

The ceramist may be satisfied: Here the successful inlay impressive by its naturalness.

The inlay has a perfect marginal adaptation and can be inserted with safe conscience.

BegoForm®	
Physical data	**Standard values**
• Colour	white
• Processing time at 20 °C	approx. 3 min.
• Initial set (Vicat test) at 20 °C	5 min.
• Setting time	45–60 min.
• Setting expansion	0,6 %
• Thermal expansion	1 %
• Hardness after 1 hour	200 [MPa]
Availability	
• 1 carton = 1.2 kg = 40 bags of 30 g each 250 ml BegoForm® mixing liquid, 1 metering syringe	REF 52785

Warranty: Whether given verbally, in writing or by practical instructions, our recommendations for use are based upon our own experience and trials and can only be considered as standard values. Our products are subject to a constant further development. Therefore alterations in construction and composition are reserved.

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