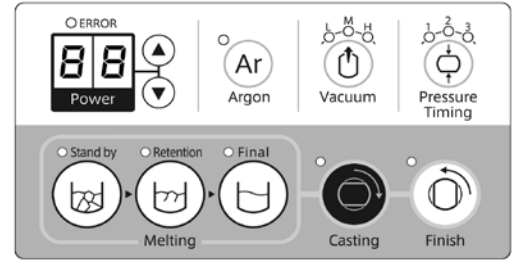


1. Semi/Non-Precious
(PALLADIUM MORE THAN 30%)



① Crucible

Place a **Ceramic crucible**. Then place the melting outlet of crucible

② Vacuum level set L / M / H

Set the vacuum level to **M**. Level of L is for Silver alloy

③ Pressure timing set 1 / 2 / 3

Set the pressure timing to **1** for Co-Cr alloy and **2** for Ni-Cr alloy

④ Alloy Putting

Put the alloy

⑤ Casting Ring set

Set a burned-out casting ring without gap between melting outlet and the casting ring. Close the lid

⑥ Argon Injection

Press **[Ar]** to repeat twice to create a vacuum and inject an argon gas.

⑦ Melting

Press **[Stand by]** after the gauge reaches 0.1

⑧ Vacuum stage

When alloy is melted, Press **[Ar]** button to vacuum

⑨ Casting

When the gauge drops to -0.05, Press **[Final]** then immediately Press **[Casting]**

⑩ Finish

Press **[Finish]** after display shows 1.2