

MiniSTAR S[®] with Scan Technology Troubleshooting & Fabrication Tips

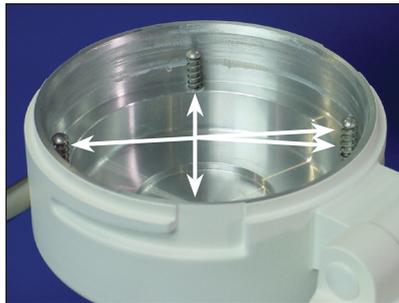
Use the following tips to address:

- Air leaks
- Poor adaptation
- Material heating unevenly
- Mounted model too high for pellet cup
- Blowouts
- Material thinning

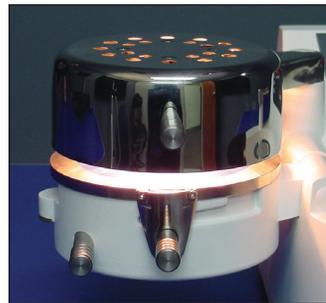
Note: The MiniSTAR S is preset at 60 psi, or 4 bars of working pressure.



If adjusting ring does not move freely, remove it and clean with a small amount of liquid dish soap, applied and removed with a soft, dry cloth.



Remove and clean the 4 pins and springs. Then lubricate with a small amount of Silicone Grease (016-021). Insert pins, springs, and adjusting ring. Depress adjusting ring once or twice to make sure it moves freely. Wipe off any excess grease with a soft, dry cloth.



Make sure the heating surface is parallel to the heating element. See **Maintenance Tips** to adjust.

Performing a Cold Test:

A. Turn unit off. Make sure platform is in place. Clamp a sheet of 2mm (or thicker) hard material onto pressure chamber. Secure clamping frame.

B. Enter 5 seconds heating time. Swing the heating element over the material to activate heat. Immediately return heating element to rest position.

C. Swing pressure chamber over the model platform. Activate air pressure.

D. If you hear a constant rush of air during pressurization, contact your customer service representative.



Remove pellets from cup. Make sure the 12 air escape holes are not plugged. **Use a .036" diameter or smaller wire to open plugged holes.**



Make sure all pellets are removed from the edge of the cup where the chamber locks into place.



Pellets should be even with the top of the pellet cup.



For **mounted models**, remove the majority of pellets, leaving only enough under the model to allow air to flow. Build up the pellets, leaving exposed only the area to be covered by acrylic material.



Great Lakes recommends all soft or semi-soft material should be formed on the platform. See photo on left: the base of the model is even and flat.

Use pellets for hard material: see photo on right.



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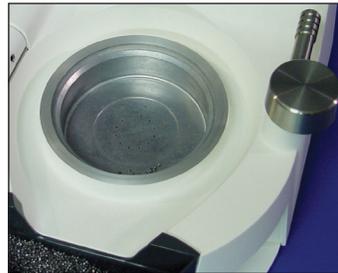
MiniSTAR S[®] with Scan Technology Maintenance Tips



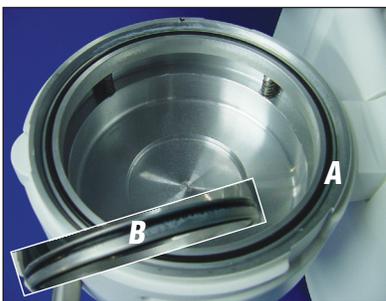
A regular maintenance schedule should be followed. Proper maintenance will assure better fabrication results. Refrain from using water in the MiniSTAR S machine. Water may cause certain components to rust or corrode. When the machine is not being used, engage the clamping frame to the chamber and position the chamber on the pellet cup. This prevents lab dust from entering the pellet cup and chamber.



Pellets will become dirty with regular use. Clean pellets by placing them in a strainer and rinsing with hot water. Spread pellets on a towel and let air dry before placing them back in the MiniSTAR S. Check pellets monthly. Discard and replace pellets in the bottom third of the cup.



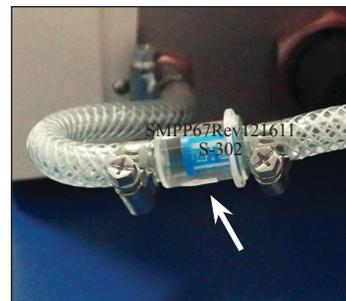
Air escape holes are present in the base of the pellet cup and should be checked monthly to ensure that they remain open. **Use a .036" diameter or smaller wire to open plugged holes.**



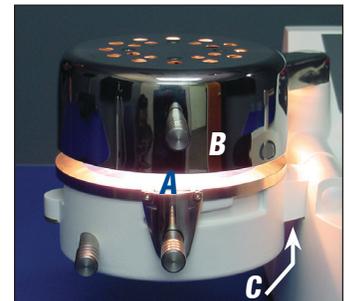
Clean and inspect top of the chamber sealing ring (A) and side gasket (B) every 4-6 months. Clean gasket with a soft cloth. Check potential gasket cuts or irregularities.



Adjusting ring should move freely in the chamber. If not, apply a thin coat of Silicone Grease (016-021) to outer ring of the chamber (A), 4 spring-loaded adjusting pins (B), and outside edge of adjusting ring (C).



Check the air filter clamped to air line monthly for discoloration and/or moisture. If replacing the filter, turn off the air source and bleed the high-pressure hose of air. Loosen clamps holding the filter and slide it off the hose. Position the new filter by referencing the arrow on the filter case toward the back of the MiniSTAR S.



The heating surface (A) should be parallel to the heating element (B). Adjust the position of the chamber by turning the screw (C) located under the chamber support frame with a small screwdriver. Clockwise adjustment of the screw lowers the chamber from the heater, counter clockwise raises the chamber closer to the heater. Check the position of the chamber when heating materials.