

 **TurboVAC+**<sup>TM</sup>  
VACUUM FORMING MACHINE



**INSTRUCTION MANUAL**

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**meodental**  
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## 1. INTRODUCTION

MeoDental's Turbovac+™ is a multifunctional device whose applications and speed, has become indispensable in the dental laboratory and the dentist's office. It is easy to use and handle.

This manual contains all the information required to operate this machine.

Read this manual carefully to assure the correct use of the equipment and to improve its performance. This equipment has various applications and each day new techniques appear, thus increasing the range of uses. We describe below the major applications in the odontological area and reserve others for your creativity.

Taking into account that operational process of the machine is similar to all applications, we describe the Vacuum forming process in a separate chapter, Item 7, and then we present each application highlighting its particularities in Item 9.

Note that there are several types of plates made from different materials and thicknesses, each one requiring different Vacuum forming times. Therefore, the ideal point of Vacuum forming is defined by visual observation, and this technique is described together with the machine's operational process. The specification of the plate indicated for each application, as well as its ideal Vacuum forming point and finish details are given in the description of each specification.

Finally we recommend once again the importance of reading this manual since we would like you to have as many benefits as possible from the machine, benefiting from the existing advantages and creating new ones. As people say: "Make the most of it."

## 2. PACKAGING CONTENTS

01. Power cable	1 unit
02. Glass shots	250 grams
03. Allen Wrench 4 mm	1 unit
04. Plate display	1 unit
05. Cast Rack	1 unit
06. Instruction Manual	1 unit
07. Turbovac+™ 127 V or 220 V	1 unit



## 3. INSTALLING THE Turbovac+™

- The equipment must be installed on a table or flat bench in a ventilated area, free from moisture and excessive heat. Do not build-in the equipment and do not put any material between the support base and the bottom of the machine to enable air exit and motor cooling.
- Keep the equipment away from heat sources or liquids (preferably one (1) meter).
- Grounding of the equipment must comply with IEC 61140:2001 standard.
- Check the voltage before plugging the equipment. **This machine is not dual voltage; therefore, check the voltage of your machine (110/127 or 220 volts) before connecting it.**

## 4. CONDITIONS FOR IDEAL USE OF THE EQUIPMENT

- Use the equipment in a sheltered environment.
- Do not exceed the temperatures of below 5° C and above 40° C
- Maximum humidity 80%
- Altitudes up to 2000 m.
- Voltage variations allowed:  $\pm 10\%$  of rated voltage.

## 5. MAINTENANCE

- Keep the Turbovac+™ always clean and protected against moisture, most importantly the resistance located in the heating unit.
- Use only a damp cloth and mild detergent to clean the equipment.
- The resistance is a component that requires care, by no means should it get wet while heated and must not be touched with tools or metallic objects.
- In case of a damaged resistance, it should be handled only by Authorized Personnel.
- In case of a damaged power cord, replace it with a similar power cord with the same characteristics and certifications.
- Always maintain the machine column (5) oiled with white Vaseline.
- In sections 10 and 11 of this manual, there is an exploded view of the machine with its respective parts list. Use the codes and categorization of this list to order spare parts.

## 6. REPLACING THE FUSE

- 6.1. Disconnect the power cord from the outlet and the inlet connector before replacing the fuse.
- 6.2. Use a small screwdriver in the upper part hole of fuse holder cover located in the input connector (AC) forcing it out until it loosens.
- 6.3. Pull the fuse-holder set out completely and check the two (2) fuses in the support.
- 6.4. The fuse that is closer to the internal part of the receptacle is the fuse with problem and must be replaced. The other (close to the receptacle cover) is the spare fuse that will be used to replace the faulty fuse.
- 6.5. Insert the spare fuse in the place of the broken one in the receptacle and press it until it fits completely.

**NOTE: We recommend buying a new spare fuse (12A/250V for 127V machines or 7A/250V for 220V machines).**

- 6.6. Power on the equipment to make sure the replacement is placed correctly. In case the fuse presents problems again, send it to the Authorized Service to check for troubleshooting.

## 7. PROCESS

MeoDental's Turbovac+™ gives you two (2) Vacuum forming processes: Conventional and Rotative. For the operational process, follow the instructions below guided by the numbers in Figures 01 and 02.

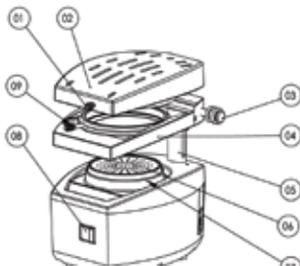


Figure 01



Figure 02

**Figure 01**

- 01 Heating unit handle
- 02 Heating unit
- 03 Plate support handle
- 04 Plate support
- 05 Column
- 06 Cast rack with cup and flat functions
- 07 Vacuum chamber
- 08 Main switch
- 09 Plate lock handle

**Figure 02**

- 10 Rotative lock screw
- 11 Lock side pins
- 12 Plate lock

## 7.1. CONVENTIONAL VACUUM FORMING PROCESS

- 7.1.1. To initiate the Vacuum forming process, the machine's power supply cable must be connected to the electrical power supply and the main switch (08) disconnected.
- 7.1.2. Through the plate support handle (03), always using both hands (one on each handle), lift the plate support (04) to near the heating unit until you hear a click, keeping it centralized and aligned with the Vacuum chamber (Image 1).
- 7.1.3. Through the handle (01), rotate the heating unit (02) 90° to the left and rotate the plate settling unit (04) 90° to the right, to facilitate the handling job of the cast rack and to fix the selected \ plate on the support (04) (Images 2 and 3).



Image 1



Image 2



Image 3

- 7.1.4. Place the cast(s) in the cast rack (06) and then place the set in the Vacuum chamber (07). The cast rack can be positioned in different ways shown below:

### CUP POSITION

Allows removing plates more easily, mainly in cases where the cast shows retentions or when stiff and/or over 1.0 mm thick plates are used.

To use the plaster cast in this position, place the cast in the cup side and fill with glass shots covering the retentive to the desired limit, then place the set in the Vacuum chamber (Images 4, 5, and 6).



Image 4



Image 5



Image 6

### FLAT POSITION

Allows a copy of the whole cast extension. For better results, cut the cast eliminating its retentions and obtaining a flat base. Do not use a high cast in this process, because there will be more distortion of the plate (Image 7).

To use the flat side of the cast rack (06), place the pattern holder in the Vacuum chamber of the machine with its mouth downwards. Then position the cast over the cast rack (Images 8 and 9).



Image 7



Image 8



Image 9



**Important:**

**Make sure the Vacuum chamber (07) is clean and free of residues for the pattern holder to seal perfectly.**

- 7.1.5. After the positioning procedure of the cast, return the plate support (04) to the central position (aligned with the motor cabinet).
- 7.1.6. For the plate positioning, rotate the plate lock handle (09) counterclockwise, to release the smaller ring of the plate settling (Image 10).
- 7.1.7. Place the plate to be molded from the frontal part of the settling unit locating a small access ramp and introducing it under the two side pins (11) (Image 11).
- 7.1.8. Place the smaller ring of the settling unit onto the plate observing the guides of the two side pins (11) and rotate them to the left by means of the plate lock handle (09) locking the plate (Image 12).



Image 10



Image 11



Image 12



**Important:**

**Maintain the whole plate support (04) held with one hand all the time to keep the set tight when fixing the plate.**

- 7.1.9. Return the heating unit (02) to the central position aligned with the motor cabinet (Image 13) and start the main switch (08), initiating the heating process. The red light of the power switch will light (Image 14).



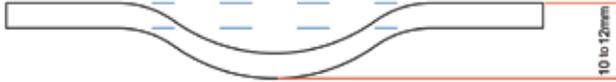
**Important:**

**Hold the Heating Unit (02) only by the heating unit handle (01). Stay close to the device while the Heating Unit is on. The material heats quickly and will become ineffective if it becomes too soft, and may damage the motor if it aspirates inside.**

#### 7.1.10. Vacuum forming Ideal Point:

Due to the existence of several types of plates (different materials and thicknesses), the ideal point of plasticization is identified by changes in the plate, not by time. It is the responsibility of each plate manufacturer to prescribe the most correct form of ideal Vacuum forming point.

Generally speaking, the ideal point is noticed by the change in color (brightness) for more opaque plates, the plate will become bright and translucent (e.g. milky plates) or by draining the plate from 10 to 12 mm, as shown in the sketch below (e.g. crystal and soft plates).



- 7.1.11. When it reaches the ideal Vacuum forming point, lower the plate support (04), slightly touching the handles (03) with both hands (one on each side), causing the frame to close the Vacuum chamber (Image 15).



#### Attention:

Rotate the heating unit clockwise using the heating unit handle (01) immediately after the vacuum is turned on, to avoid accidents and plate blistering (Image 16).

At this moment, the Vacuum chamber (motor) is activated automatically to complete the plasticization and the heating is turned off.

- 7.1.12. Leave the Vacuum system (motor) running until you are sure that the Vacuum forming process is complete (10 to 20 seconds depending on the plate thickness). Turn the main switch off (08) and allow the pattern to cool down for approximately 60 seconds.



#### Caution:

Do not leave the motor on for over one (1) minute, while the molding plate is on the Vacuum chamber, to avoid superheating, since the motor is cooled by the air passage.

- 7.1.13. Release the plate lock rotating the plate lock handle (9) counterclockwise, remove the plate lock (12) and then the cast (Image 17).



Image 15



Image 16



Image 17

- 7.1.14. To remove the cast and finish the plate, cut away the excess material with a pair of scissors, steel or carborundum disk, depending on the stiffness and thickness of the plate.  
For stiff plates or plates thicker than 1.0 mm, we strongly recommend the use of cup cast rack for the plasticization process, as mentioned previously.  
The final finish of the edges can be made by mounted stones or rubber disks.

#### 7.2. VACUUM FORMING PROCESS USING THE ROTATIVE SYSTEM

To use the rotative Vacuum forming system that allows heating on both faces of the plates, follow the instructions below, guiding by the numbers of main components of the machine in Figure 02 of this manual.



### Attention:

The machine leaves the factory with the Plate Support locked by the rotating locking screw (10) to avoid accidental rotation when the Vacuum forming process is conventional used (heating of only one face). To unlock the rotative system it is necessary to release the locking screw (10) with a 4 mm Allen screwdriver supplied (it is not necessary to remove the screw, it is enough the loosen it) (Image 18).



Image 18

We recommend maintaining the system always locked while the machine is used conventionally, by slightly tightening the locking screw (10).



### Important:

The heating system of both plate faces is recommended only for a double sheet plate that follows the heating process according to the characteristics of the materials employed in both sheets. This information must be obtained from the plate manufacturer.

In the absence of this information, we recommend heating in three (3) phases: first the more rigid face, then the soft one (softer or rubber) and finally the more rigid face again until reaching the ideal Vacuum forming point.

- 7.2.1. After releasing the rotative system lock (10), follow the steps of the recommended Vacuum forming process to step 7.1.9 for the heating of the first face.
- 7.2.2. To heat the other side of the plate, rotate the heating unit completely to the left by the handle (01), then, rotate the plate support (04) to the right 90° until you feel a click (image 19). Only then, rotate the larger ring 180° counterclockwise until you feel another click, exposing the other side of the plate upwards (Images 20 and 21). Return the plate support (04) to the central position. Then return the heating unit (02) to the central position and wait for the time to heat this plate face.



Image 19



Image 20



Image 21

- 7.2.3 . Repeat step 7.2.2, but this time, rotate the larger ring clockwise to return the plate support (04) to the normal position and the plate to the initial position. Allow a few more seconds for the original plate face to heat.
- 7.2.4. After completing the heating, at the ideal Vacuum forming point, follow the steps of the conventional process from item 7.1.11 on, until the process is completed.



### Warning:

Never lower the plate support (04) when the larger ring is rotated 180° in the counterclockwise direction.



## 8. IMPORTANT CONSIDERATIONS:

To obtain an ideal plasticization, we recommend the following considerations:

- Use a very porous plaster so that the air will pass through the cast to provide a more efficient vacuum. Avoid resin plaster.
- Leave the cast the lowest possible to avoid big plate malformation.
- When working with the flat part of the cast rack, leave the plaster cast base flat to avoid the plate aspirating the gaps between the plaster cast and the cast rack.
- Heating on both faces of the plate is ideal for Double Sheet plates but is not required when using traditional, single sheet plates.

**Double Sheet:** plates made from two (2) different types of materials. Example: plate with one rigid face and the other one soft.

## 9. MAJOR APPLICATIONS

### 9.1. BRACKET FIXATION

**INDICATED PLATES:** Soft Plate 1.0 mm / Crystal 0.3 mm

**IDEAL VACUUM FORMING POINT:** Plate draining

**FINISH:** Use cup cast rack. Cut plate with scissors.

**CONSIDERATIONS:** Position the brackets on the study cast before Vacuum forming with not very adhesive bond for easy removal with the plate after Vacuum forming. Then, proceed with the tooth repair, install plate with brackets, fastening this way all brackets at once. Remove the plate carefully with a scalpel.

### 9.2. CASKETS

**INDICATED PLATES:** Crystal 0.3 mm

**IDEAL VACUUM FORMING POINT:** Plate draining

**FINISH:** Use flat cast rack. Cut plate with scissors or scalpel.

**CONSIDERATIONS:** For increased advantage of the plate, a mould can be put on the plate holder provided that there is enough space for Vacuum forming. The mould can be supported on the plate holder on plasticine.

### 9.3. MATRIX FOR COMPOUND RESIN

**INDICATED PLATES:** Milky Plate 0.5 mm / Soft Plate 1.0 mm

**IDEAL VACUUM FORMING POINT:** Plate transparency to milky and draining to Soft.

**FINISH:** Use flat cast rack. Cut the plate with scissors or scalpel.

**CONSIDERATIONS:** Dental reconstruction should be made on the study cast with material that resists the heating temperature (plaster, resin, plasticine, teeth, artificial teeth, etc.). If wax is used, a duplication of the cast in plaster should be made because the wax melts as the machine heats. Note: Use only the indicated material (Milky plate or Soft) since other type of material may react chemically with the resin.

### 9.4. PROVISIONAL BRIDGE

**INDICATED PLATES:** Milky Plate 0.5 mm / Soft Plate 1.0 mm

**IDEAL VACUUM FORMING POINT:** Plate transparency to milky and draining to Soft.

**FINISH:** Use cup cast rack. Cut the plate with scissors or scalpel.

**CONSIDERATIONS:** Dental reconstruction should be made on the study cast with material that resists the heating temperature (plaster, resin, plasticine, teeth, artificial teeth, ect.). If wax is used, a duplication of the pattern in plaster should be made because the wax melts as the machine heats. Plasticize the new cast (rehabilitated). Note: Use only the indicated material (Milky Plate or Soft Plate), since another type of material adheres to the resin. After

Vacuum forming, remove the plate from the cast carefully and fill the plate space where the provisional bridge will be built with self-polymerizable resin, then take to the dental preparation. For use in mouth, the tray should be adapted to protect the limit of 1 and 2 teeth each side of the area and provide approximately 3 mm around the gingival margin. During the preparation, the tray may be introduced in the mouth and used as reference for the contour of the preparation. It will provide an anatomy similar to the natural teeth and convenient occlusion with the opposite arch. The correct relationship is established in the mouth and can be observed if all margins are well marked and without failures. When the resin starts to heat, the resin/tray set can be detached and re-seated so it does not polymerize on the preparations. When the acrylic is completely polymerized, remove the tray by flexing or pickling. The resulting acrylic is practically polished.

#### 9.5. MOUTH GUARD

**INDICATED SPLINTS:** Soft Plate 2.0 mm for Splint, Soft Plate 3.0 mm for Oral protector

**IDEAL VACUUM FORMING POINT:** Splint draining

**FINISH:** Use cup cast rack. Cut excess with scissors or scalpel.

#### 9.6. SPLINT (BRUXISM)

**INDICATED SPLINTS:** Crystal 1.0 / 1.5 / 2.0 mm

**IDEAL VACUUM FORMING POINT:** Splint draining

**FINISH:** Use cup cast rack. Cut excess with steel disk or carborundum. Edge smoothing with mounted stones.

**CONSIDERATIONS:** Occlusal adjustment to be made on a semi-adjustable articulator using adherent material (auto-polymerizable acrylic resin) and wearing out the splint if necessary.

#### 9.7. BASE SPLINT

**INDICATED SPLINTS:** Crystal 1.0 / 1.5 / 2.0 mm

**IDEAL VACUUM FORMING POINT:** Splint draining

**FINISH:** Use cup cast rack. Cut excess with steel disk or carborundum. Edge smoothing with mounted stones.

#### 9.8. INDIVIDUAL TRAYS

**INDICATED SPLINT:** Crystal 1.0 / 1.5 / 2.0 mm

**IDEAL VACUUM FORMING POINT:** Splint draining

**FINISH:** Use cup cast rack. Cut excess with steel disk or carborundum. Edge smoothing with mounted stones.

**CONSIDERATIONS:** The cable can be made in three (3) ways –

a) Shape plasticine to form the cable you wish over the plaster pattern. In this case, place the cable in the vertical position and soon after Vacuum forming (before the material cools down) shape the cable to the desired position. **CAUTION:** Do not burn your fingers.

b) Shape a short U hook with a lead wire or wire and fix it on the plaster pattern. To fix it, open two holes in the cast in the lead wire or wire diameter. Place the hook in the vertical position and after Vacuum forming (before the material cools down) bend the cable to the desired position.

c) Add a small amount of auto-polymerizable acrylic resin in the shape of a rod over the ready splint.

**NOTE:** In cases (a) and (b), the Vacuum forming is made directly on the pattern and the cable so that the cable becomes part of the tray.

## 9.9. TRAYS FOR HOME TEETH WHITENING

**INDICATED SPLINTS:** Crystal 0.3 mm / Soft Plate 1.0 mm

**IDEAL VACUUM FORMING POINT:** Splint draining

**FINISH:** Use flat cast rack. Cut with scissors or scalpel.

**CONSIDERATIONS:** There is no need of relief, however, if you wish, the relief can be made by painting with nail enamel the metal surface of the cast where the bleaching gel will be applied.

## 9.10. STUDY CAST PACKAGING (FILE)

**INDICATED SPLINTS:** Crystal 0.3 mm

**IDEAL VACUUM FORMING POINT:** Splint draining

**FINISH:** Use flat cast rack. Cut with scissors or scalpel.

## 9.11. SURGICAL GUIDE

**INDICATED SPLINTS:** Crystal 1.0 / 1.5 / 2.0 mm

**IDEAL VACUUM FORMING POINT:** Splint draining

**FINISH:** Use cup cast rack. Cut excess with steel disk or carborundum. Edge smoothing with mounted stones.

**CONSIDERATIONS:** After making the splint, mark the surgical points of interest, based on the study cast, consequently the splint is pierced at the marked points.

## 9.12. FLUORIDATION TRAYS

**INDICATED SPLINTS:** Crystal 0.3 mm / Soft 1.0 mm

**IDEAL VACUUM FORMING POINT:** Splint draining

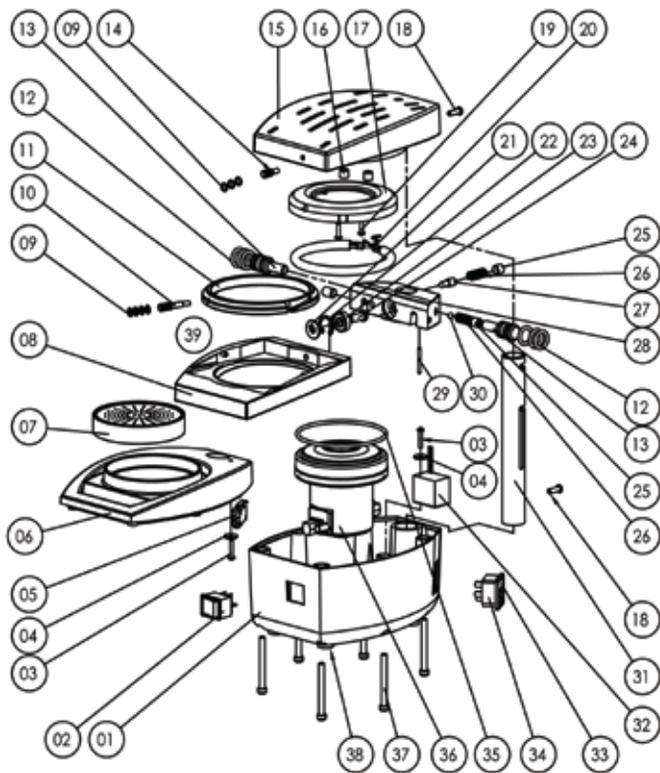
**FINISH:** Use cup cast rack. Cut the excess with scissors or scalpel.

**CONSIDERATIONS:** The relief can be made in two ways:

a) Painting with nail enamel the dental surface of the model where the fluoridated gel will be applied.

b) Putting 2 mm foam over the dental surface of the model and Vacuum forming this set (tray + foam). The foam will adhere to the splint after the plasticization.

## 10. EXPLODED VIEW



# 11. PART LIST

ITEM	QTY	CODE	DESCRIPTION
01	1	FINV0861	Motor Envelope
02	1	CINT0507	ON/OFF Key
03	2	CPAR1149	Mitroplastic screw Ø3.5 x 16
04	2	CARR0858	Washer Ø5x Ø12x1.2
05	1	CMCRO057	Microswitch
06	1	FTAP0826	Motor cover
07	1	FPTM0858	Cast Rack
08	1	FANE0823	Larger Ring Rotary
09	7	CORI0049	O'ring ORI-10
10	1	CCAB1274	Small ring lock pin
11	1	FANE0825	Small ring
12	6	CORI1224	O'ring ORI-208
13	2	CCAB1275	Larger ring cable
14	1	CCAB1276	Resistance Envelope Cable
15	1	FINV0822	Resistance Envelope
16	2	CISO1256	Resistance Reflector Insulator
17	1	FREF0842	Resistance Reflector
18	2	CPAR1264	Convex Head Allen Screw M5x20
19	2	CPAR0541	Convex Head Phillips Screw M4x16
20	1	CRES1227	Carbon resistance Ø10x Ø120 450W (**)
21	1	FESPO841	Rotative Element Spacer
22	1	CANE1229	Roll Ring DIN72-122 X 1
23	1	CROL1225	Rotative Element 608ZZ
24	1	FEIX0840	Rotary Bearing Shaft
25	2	CPAR155	Headless screw M10x10
26	2	CMOLO047	Steel Spring
27	1	FPIN0856	Rotative Pivot Lock Pin
28	1	FPIV0824	Larger Ring Rotary Pivot
29	1	FPIN0429	Endless pin
30	1	CESFO347	Sphere Ø1/4"
31	1	FCOL0855	Column
32	1	CMIN0603	Motion work
33	1	CFSV1192	Fuse 5x20mm ( 12A.250V) (**)
34	1	CTOM1261	Socket with fuse holder 6200.42/25
35	1	CORI1130	O'ring ORI-241
36	1	CMOTO085	Universal Motor 1000W (**)
37	6	CPAR1254	Convex Head Phillips Screw
38	5	CBOR1262	Rubber Foot
39	1	CPAR0713	Headless Allen Screw
40	1	CCELO498	Electric Cable 3x0.75 (2P+T)

Obs; (\*\*)

1- PART -# 20 - CODE- CRES1227- FOR 110/127V MACHINES  
CODE- CRES1228 - FOR 220/240V MACHINES

1- PART -# 36 - CODE- CMOTO085- FOR 110/127V MACHINES  
CODE- CMOTO084 - FOR 220/240V MACHINES

1- PART -# 33- CODE- CFSV1192- FOR 110/127V MACHINES  
CODE- CFSV1191 - FOR 220/240V MACHINES

1- PART -# 32 - CODE - CMIN0603 - ONLY FOR "CE" MACHINES

## 12. TECHNICAL SPECIFICATIONS

<b>Source:</b>	127V or 220Vac 50 / 60 Hz
<b>Consumption:</b>	750 W Average
<b>Heating Power:</b>	450 W
<b>Motor Power:</b>	1000 W
<b>Dimensions (WxDxH):</b>	180x230x290 mm (w/o packaging) 200x250x300 mm (w/ packaging)
<b>Weight:</b>	4.500 Kg (w/o packaging) 5.600 Kg (w/ packaging)
<b>Pollution Degree:</b>	2
<b>Protection Degree:</b>	IPX1 (Protected against spatter)
<b>Noise Level:</b>	Motor 70/90 dB @ 0.50M

## 13. WARRANTY TERMS

Meodental Ltd. grants one (1) year warranty for the Turbovac+™. This warranty comprises any and all manufacturing defects provided by repairing the product and subject to the following requirements:

- a) That the product has been used properly in accordance with the instructions provided. We remind that the Turbovac+™ must be handled, transported and stored carefully. Falls or hits as a result of misuse will result in an invalid warranty.
- b) The complaint must be followed by the invoice.

**To take full advantage of this warranty, the consumer should ship the product at his costs (freight on the owner's account) to Meodental Ltd. Please contact via the following address:**

**Home Page:** [www.meodental.com](http://www.meodental.com)

**E-mail:** [info@meodental.com](mailto:info@meodental.com)

**Or through your local distributor.**

We remind that this machine is not dual voltage, therefore, check the voltage of your machine (110/127 or 220 volts) before putting it to work.

The warranty does not cover damages from incorrect connection.

Servicing on the machine can only be made by expert personnel.

Any improper change will result in an invalid warranty.

In case of return of the equipment to the Servicing, make sure the machine is duly packed to avoid damages from falls during transportation.

**The information in this manual is subject to change without prior notice.**

**Excluded from this warranty are eventual defects resulting from natural wear of the product, as well as damages caused during transportation, both out and in.**

## 14. TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	SOLUTION
Device won't start, general switch off.	Device is without energy.	Check electric network, power cable and protection fuse.
General switch is on but heating is inoperative.	Resistance is burned.	Replace resistance, contact Servicing.
Heating is normal but motor won't start.	End of course pin (29) is imperfect.	Replace pin (29) or adjust.
General switch is on, but heating and motor are inoperative.	Internal wiring with problem.	Contact Servicing.
Suction is weak, Vacuum forming insufficient or without defined contours.	Check if the Vacuum chamber holes are free.	Clean holes with a Ø1 mm metallic pin.
	Check type of plaster.	Do not use resin plaster.
	High cast rack.	Use the cast rack on the cup side or cut away the cast.
	Cast rack (7) damaged.	Replace the cast rack (07).
Rotary movement of fixation unit of splints is locked.	Rotative lock screw (39) tight.	Loosen the screw (39) with a 4 mm Allen screwdriver supplied with the equipment.
Rotary movement of fixation unit of splints is locked.	Rotative pivot lock (27) out of adjustment.	Adjust the pin (27) tightening or loosening the screw (25), guide by the exploded view.
Vertical movement of fixation unit column of splint is very hard.	Column badly lubricated.	Oil the column with Vaseline.
Fixation unit of splint does not stop at heating point.	Lack of adjustment on the steel spring (26).	Adjust the screw (25) guiding by the exploded view. This adjustment should preferably be made by a technician.
Motor cabinet (01) very hot.	Machine continuously operating for long time.	Let the machine cool down for 30 minutes and return the work.
	Motor ventilation obstructed.	Verify that there are no obstructions between the support base and the cabinet bottom.
Splinter looses from fixation unit at the moment of Vacuum forming.	Insufficient tightening of splinter through locking ring (11).	Force tightening a little more and check the splinter thickness, the machine accepts splinters from 0.30 to 4.00 mm thick.

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