




# Trouble shooting for BIOSTAR IV-VII, MINISTAR®, MINISTAR S®, TWINSTAR®

Error	Probable reason	Solution
The foils are partially burned or too soft	You entered a wrong code or heating-time for the foil.	Ensure to observe the batch specifications given in the product labelling.
Pressure moulding results are not satisfying	You entered a wrong code or heating-time for the foil.	Ensure to observe the batch specifications given in the product labelling.
No pressure build-up	When embedding the model in pellets, the model cup has not been filled up to the closing area. The material rim is pulled out of the clamping ring during thermo-forming. Please make sure that only foils with a diameter of 125 mm are used!	Fill the model cup with pellets up to the closing area. 
	Compensation ring is not straight or not running well due to debris.  <b>Maintenance hint:</b> Ensure the compensation ring is freely movable at any time when carrying out the maintenance advices given on the right.	Pull out balancing ring of pressure chamber by pressing on one side and lifting up on the opposite side simultaneously.  Remove the 4 rivets and pressure springs. Clean and grease them using vaseline and refit the ring.  
Difficulties in closing pressure chamber	Pellets on the closing area of housing/model cup rim.	Before closing the pressure chamber make sure that the closing area is clean!
Difficulties in opening pressure chamber	The different steps for opening the pressure chamber have not been carried out correctly.	After depressurisation and 5 seconds waiting time, carry out the following operations one after the other: ① Turn the locking handle 180° backwards ② Turn the bayonett closing ring to the left ③ Open the pressure chamber 