


## ***Owner & Operator's manual***

<b>Model no.</b>	<b>Voltage</b>
94-94-315	100-120 V 50/60 Hz
94-94-316	230 V 50/60 Hz

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# SAFETY



- Never operate furnace in close proximity to combustible materials or place materials on top of the furnace.
- The furnace must be electrically grounded to a three wire electrical outlet or receptacle. The electrical service provided must be a dedicated line of the proper size according to local electrical codes.
- Disconnect the line cord before attempting to service the furnace.
- Do not attempt to service the furnace until you read and understand the service manual.
- Do not operate the furnace controls with tongs or other tools; the tongs will damage the control switches.
- Do not use solvents or liquid cleaners on the control panel; they will enter the panel and damage it.
- Do not place firing trays or other hot objects directly in front of the furnace; they will melt the L.C.D.-display.
-  If the furnace is not used in the manner as specified in this manual, the protection provided by the furnace may be impaired.

## OSHA AND CALIFORNIA PROPOSITION 65: MUFFLE DUST EXPOSURE

In keeping with the policy of Elephant Dental B.V. to build safe products, comply with all National and State statutes and keep you, the valued customer informed; the services of a Certified Industrial Hygienist firm were employed to test and evaluate the lab operator's exposure to respirable refractory ceramic fiber (RCF) and cristobalite (a form of crystalline silica) present in the furnace muffle.

When it becomes necessary to replace the muffle, the person doing this work is recommended to wear a HEPA filter respirator and protective gloves as a precautionary matter.







Seal used muffle in a plastic bag and dispose of in accordance with local, state and Federal regulations.

Because this product and many similar products on the market today contain crystalline silica and ceramic fibers, it is necessary under the statutes of California Proposition 65 that Elephant Dental B.V. include the following statement:

"This product contains substance(s) known to the State of California to cause cancer."

Material Safety Data Sheets for RCF materials supplied upon request.

### SYMBOL TABLE

	- Alternating current
	- On (Supply)
	- Off (Supply)
	- Caution, Hot Surface
	- Protective Conductor Terminal
	- Caution

## FEATURES

- 125 User Programs
- 6 Pressing Programs
- Program Memory Cards (Program Backup, New Program Loading, New Firing Programs)
- Multiple Languages: Dutch, German, English
- High Performance Quartz Lined Muffle Produces a high quality, Superior Porcelain with Long Life Characteristics
- 1200°C (2192°F) Maximum; 100°C (212°F) Minimum Temperature
- Ultra Smooth Muffle Movement with Stationary Work Support
- Programmable Dry and Cooling Operations
- Fast Cool Down of the Muffle for Short Times Between Loads Gives Maximum Productivity
- Vacuum Release Programmable in Temperature or Time
- Fast Heat Rates of up to 200°C/minute (360°F/minute)
- Full Program Flexibility; Parameters Changeable During Firing Cycle
- Power Outage Return; Short Power Outages (<30seconds) Will Not Interrupt Firing Cycle Or Cause Loss of Vacuum
- Ultra Friendly User Interface
- Serial printer Port for Data Logging of Firing Programs
- Energy Saver "Idle Down Time"; Muffle closes but maintains Lo Temp
- NITE MODE: Closes muffle after a firing cycle when temperature reaches the programmed Nite Temp to reduce moisture absorption
- Easy temperature adjustment; operator reads out and adjusts calibrations from L.C.D.-display
- Agency Approval: CE
- 8 Line Graphic LCD Display With Improved Backlighting For Superb Visibility
- Display Contrast Adjustment

## INSTALLATION INSTRUCTIONS

### UNPACKING:

Carefully unpack and remove the furnace from its shipping carton. Save the carton and other packing material for future use in transporting the furnace.

Shipping damage should be reported to the carrier as soon as detected.

### LIFTING AND CARRYING:

- Get a firm footing. Keep your feet shoulder width apart for a stable base.
- Bend your knees. Don't bend at the waist.
- Grip the base of the furnace and lift with your legs.

#### **DO NOT LIFT FURNACE BY THE TOP MUFFLE ASSEMBLY!**

- Keep the load close to your body and carry the unit to the destination. Keep your back upright during lifting.

The shipping carton contains the following:

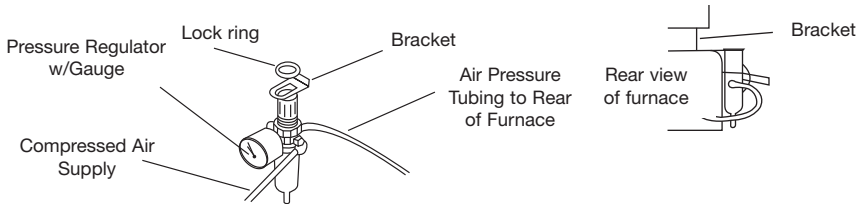
- One furnace complete with power cord
- Owner & Operator's Manual (this document)
- Door insulation
- Pressure regulator set including connectors
- Accessory set: tweezers, set of memorycards, fuse, honeycomb tray with pins and silicone hose (for vacuum pump)

## INSTALLATION INSTRUCTIONS

- Remove all packing material from in and around the furnace. The furnace should be located at least 15 cm (6") away from walls, shelves and heat sensitive materials.
- The furnace should not be located directly under shelves or other airflow restrictions.
- Furnace Connections:  
Electrical Supply: Connect the furnace to a power circuit or receptacle with an overcurrent protection (circuit breaker or fuse) rating of 15 Amps (10A for 230V model). This circuit should be a 3 wire circuit containing a ground wire and only supply the furnace.

### COMPRESSED AIR CONNECTIONS:

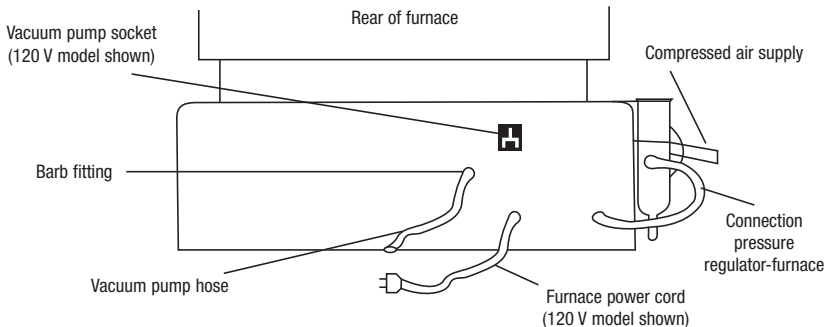
- Mount the regulator/filter assembly on the rear left side of the furnace using bracket and screws provided as illustrated below.
- Compressed Air Supply:** The pressing furnaces require a minimum of 5 Bar (75psi) to operate properly; 8 Bar (120psi) maximum.
  - Use lock ring to secure regulator/filter to the bracket.



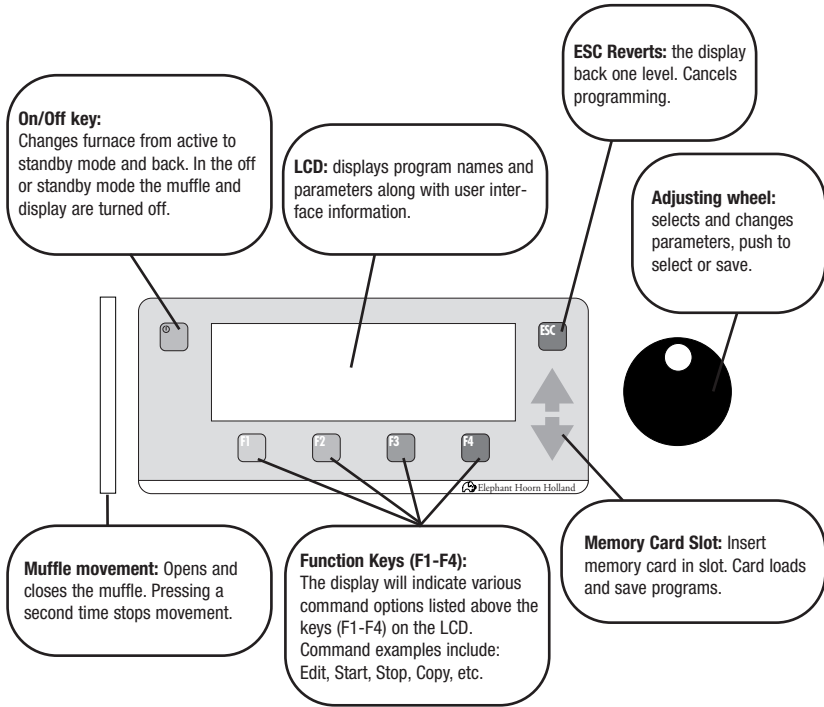
- Attach air pressure tubing from regulator to connection marked "Pressure".
- Connect compressed air line to air supply. Turn on compressed air. The pressure regulator gauge should be pre-adjusted to read 4.5 Bar. Adjust if required. If the pressure can not be adjusted to 4.5 Bar, verify that air supply is between 5 and 8 Bar.

### ELECTRIC VACUUM PUMP CONNECTIONS:

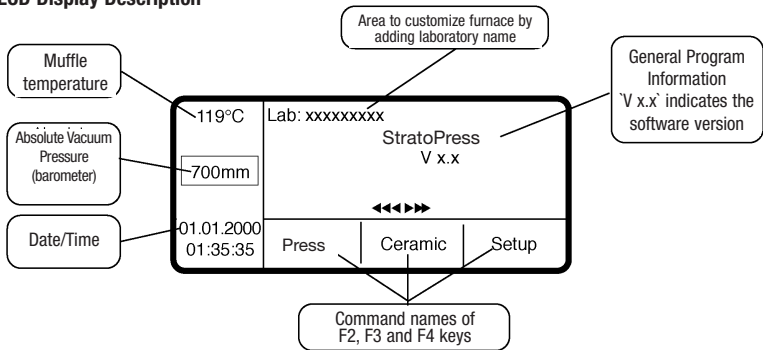
- Plug the external electric vacuum pump into the socket located directly above the furnace power cord. Customers with old vacuum pumps may require an adapter which can be obtained from Elephant Dental B.V. product service.
- Connect vacuum pump hose to barbed fitting.



# CONTROL PANEL DESCRIPTION



## LCD Display Description



# OPERATING INSTRUCTIONS

**WARNING: The furnace must be installed properly before operation. Please read and implement the installation instructions before operating.**

## GETTING STARTED:

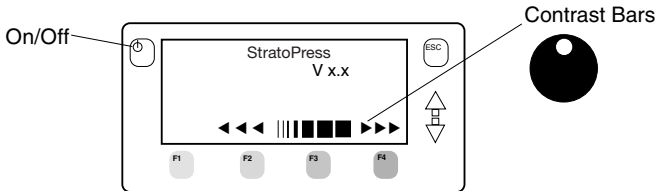
1. **FIRST TIME ONLY:** Plug the power cord to a power circuit. The furnace will go through a series of self-diagnostic tests. The sound of the plunger being activated will also be heard. The muffle will open.

**IMPORTANT! The furnace is shipped with packing material inside the muffle. Remove this material before any keys are pressed.**

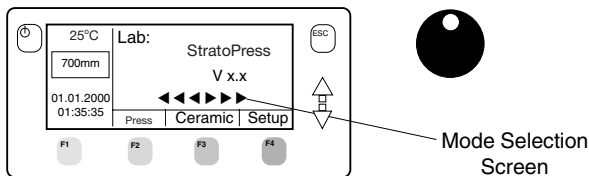
2. Install the white ceramic door insulation on the center of the machined aluminum door.

**IMPORTANT! Operating the furnace without the door insulation in place will damage the furnace!**

3. If the operation of the furnace causes the lights to "blink" or "flicker" the furnace is on the same circuit breaker or fuse as the lighting. Install the furnace on a separate circuit that is isolated from the lighting circuit.
4. Press the **On/Off** Key.

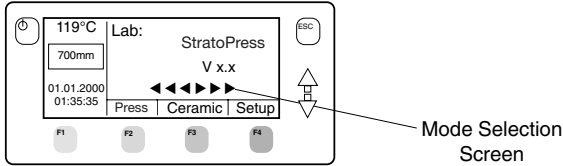


5. Display contrast may be adjusted when the Contrast Bars are displayed by rotating the adjusting wheel.
6. Press ESC after adjustment or wait 3 seconds.
7. The Mode Selection Screen is now displayed.



# OPERATING INSTRUCTIONS

## Press operation



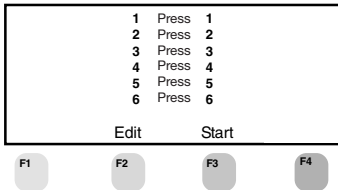
8. At the bottom of the display, 3 menu options are displayed above the function keys.

**Press (F2)**-Listing of press programs - ^ symbol is used to indicate press programs.

**Ceramic (F3)**-Listing of all the firing programs loaded into the furnace (numbered 1 thru 125).

**Setup (F4)**-Support operations such as set time/date, set nite mode temperature, language selection and memory card operations. (See "Setup", ceramics programs)

9. Pressing "Press" key (F2) displays a list of the 6 press programs. The highlighted name "Press" can also be activated by pressing the **adjusting wheel**.



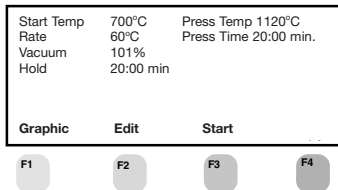
10. At the bottom of the display, 2 new menu options are displayed above the function keys.

**Edit (F2)**-Activates the edit mode to view or change parameters.

**Start (F3)**-Starts the program selected by the cursor.

11. Pressing Edit displays a list of all program parameters of the selected program.

12. Turn the adjusting wheel to scroll thru the listed programs.



13. At the bottom of the display, 3 menu options are displayed above the function keys.

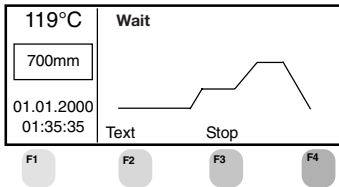
**Graphic (F1)**-Displays a graph with associated data for a selected program.

**Edit (F2)**-Adjusts the currently selected parameter. (See "Programming").

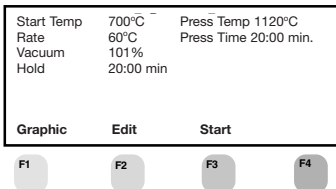
**Start (F3)**-Starts the firing program.

# OPERATING INSTRUCTIONS

14. Pressing “Start” (F3), the display changes to the graphic mode display. The Start function key is replaced with Stop. The furnace is now instructed to heat to the “Start Temp”. Once this temperature is reached, a constant beeping will sound to alert the operator that the StratoPress is ready and the actual pressing firing cycle can begin.



15. Load the press ring, pellets and plunger onto the positioning ring.
16. Press the “**Start**” (F3) key again to activate the pressing firing cycle.  
 Note: If the “**Start**” key is not pressed a second time within 10:00 minutes, the muffle temperature will be controlled at 400°C, (the cycle is aborted).
17. After the muffle closes, the vacuum pump will turn on if vacuum is requested during this firing cycle.
18. Pressing Text switches from Graphic Mode to Text Mode, as shown below. (See Programming)

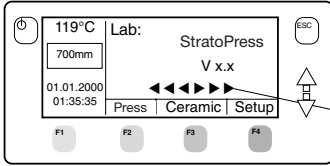


Press Mode Parameter Table

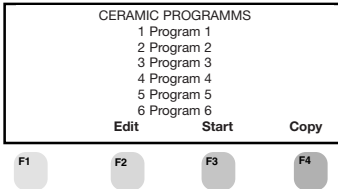
Parameter	Description	Programming Range & Resolution
Start Temp	Firing cycle starting temperature	100 - 800°C in 1°C
Rate	Time to bring press ring to the press temp	1°C - 200°C/min. in 1°C/min.
Vacuum	Vacuum pump operation (The displayed value is absolute pressure inside the chamber)	0% - no vacuum during cycle 50 - 100% - vacuum level in 5% 101% - pump stays on continuously
Press Temp	Temperature for the hold/press time	400 - 1200°C in 1°C
Hold	Time to hold Press Temp	00:00 - 59:59 min. in 0:01 min.
Press Time	Time to press ring	00:00 - 59:59 min. in 0:01 min.

# OPERATING INSTRUCTIONS

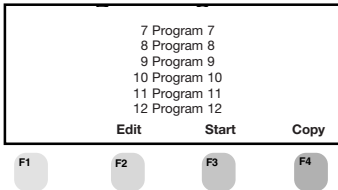
## Ceramic operation



1. Pressing “Ceramic” key (F3) displays a list of the first 6 programs. The highlighted name “Ceramic” can also be activated by pressing the adjusting wheel. The muffle temperature is controlled at the Lo Temp of the selected program. See display figure on next page of the program listing screen.



2. Turning the adjusting wheel again will display additional groups of programs, 6 at a time.



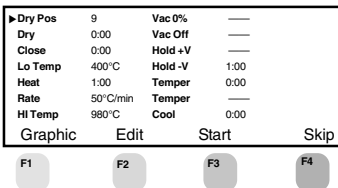
3. At the bottom of the display, 3 new menu options are displayed above the function keys.

**Edit (F2)**- Activates the edit mode.

**Start (F3)**- Starts the program selected by the cursor. The Start function key is replaced with Stop. The display changes to the graphic mode display, as shown below.

**Copy (F4)**- Copies current program parameters into new program number. See #13 for details.

4. Pressing Edit displays the screen below.



5. Turning the adjusting wheel moves the cursor to a new parameter.

6. Pressing the wheel selects the parameter for editing.

7. Turning the wheel again will change the value. Repeat steps 4 thru 6 for each parameter.

8. Turning the adjusting wheel counterclockwise past the first parameter (Dry Pos) will activate the program name editing. The program name is entered by alternately pressing the Set >> (F3) and <<Set (F2) keys to select a location and turn the wheel to select a letter, number or character. When complete the name is saved by pressing the **Save (F1)** key.

# OPERATING INSTRUCTIONS

9. At the bottom of the display, 4 menu options are displayed above the function keys.

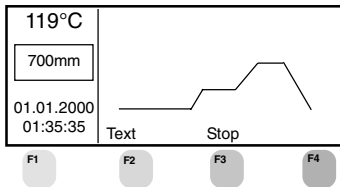
**Graphic (F1)**- Displays a graph with associated data for a selected program.

**Edit (F2)**- Activates the edit mode similar to steps 4 thru 6 above. In this case, turning the adjusting wheel adjusts the currently selected parameter. Pressing Save (F1) stores the current parameter value.

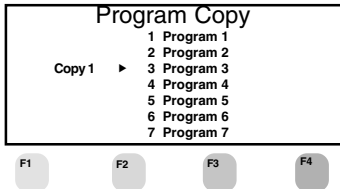
**Start (F3)**- Starts the firing program. The display changes to the graphic mode display. The Start function key is replaced with Stop.

**Nite (F4)**- Also starts the firing program, but automatically enter Nite Mode after the completion of the firing cycle. The muffle stays open until the Nite Temp (see “Setup”) has been reached, then closes.

10. Pressing Start (F3) starts the firing program and switches the screen to the graphic mode display, as shown below.



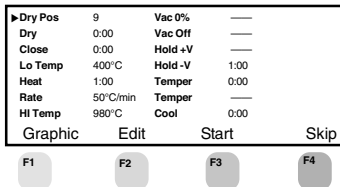
11. Pressing Text switches from Graphic Mode to Text Mode, as shown below.



12. After the program reaches Lo Temp the function key Skip (F4) is shown. Pressing this key will advance the firing cycle to the next segment (Heat goes to Rate, Rate goes to Hold, etc.).

## ADDITIONAL OPTIONS:

13. Copy (F4) on the program listing screen allows the user to copy a current program parameter to a different location.



14. Select a program from the program listing screen.

15. Press the Copy (F4) key. Rotate the wheel until the “Copy to” location is selected by the cursor. Press the wheel again and the program will be copied to this location.

## OPERATING INSTRUCTIONS

CERAMIC MODE PARAMETER TABLE		
Parameter	Description	Programming Range and Resolution
Dry Pos	Muffle position at start of program	0 - 9 (0 = closed)
Dry	Time to dry the work at the dry position	00:00 - 59:59 min. in 0:01 min.
Close	Closing time of muffle in steps	00:00 - 59:59 min. in 0:01 min.
Lo Temp	Firing cycle starting temperature	100 - 800°C
Heat	Time to bring work to the Lo Temp	00:00 - 59:59 in 0:01 min.
Rate	Change in temperature per min.	1°C/min. - 200°C/min. in 1°C
Hi Temp	Hold temperature of the firing cycle	400 - 1200°C in 1°C
Vac %	Vacuum pump operation (The displayed value is absolute pressure inside the chamber)	50-100% - Pump is on until specified value is achieved in 5% 101% - Pump stays on continuously 0% - Pump off
Vac On	Temperature at which vacuum is pulled	100 - 1200°C in 1°C
Vac Off	Temperature at which vacuum is released	100 - 1200°C in 1°C
Hold +V	Time to hold end temp with vacuum	00:00 - 59:59 min. in 0:01 min.
Hold -V	Time to hold end temp without vacuum	00:00 - 59:59 min. in 0:01 min.
Temper	Time holding at temper temperature	00:00 - 59:59 min. in 0:01 min.
Temper	Tempering temperature	100 - 1200°C in 1°C
Cool	Opening time of muffle in steps	00:00 - 59:59 min. in 0:01 min.

# PROGRAMMING

Several different methods are available for loading programs into the furnace:

- New programs can be entered manually (See Edit below)
- Existing programs can be copied to a new location and edited

## Edit New Programs


To name a program:

1. Press **Ceramic** key
2. Turn adjusting wheel to the desired program number
3. Press Edit key
4. Turn adjusting wheel counter clockwise (CCW)
5. A cursor blinks in the name field
6. Press the function key **>>Set>>** to advance the cursor to the first letter position
7. Turn the adjusting wheel either direction to display letters and symbols. Choose one.
8. Press **>>Set>>** advances the cursor to the next character position. Up to 14 character can be written.
9. Press **<<Set<<** to move back a position to change previous characters
10. Press the function key **Save (F1)** to store the program name
11. Pressing the **ESC** key aborts the program name editing and place the cursor **▶** at the fourth program parameter

## To edit program parameters:

1. Turn the adjusting wheel in the clockwise (CW) direction to move the cursor to select a parameter for editing
2. Press the adjusting wheel once a parameter has been selected
3. Turn the adjusting wheel clockwise (CW) direction to increase and (CCW) to decrease a parameter value
4. Press the adjusting wheel to store the parameter or use the function key Save
5. Pressing the **ESC** key aborts the parameter editing and returns the cursor to the current parameter

## Using Memory Cards:

- Backup Card:  
To start a firing program from a memory card select the **Mode Selection** Screen and insert a previously loaded Backup card. The function key **"F2"** shows **Card** . Press this function key to view or run programs stored on the card. Back-up and Memory Card programs may also be copied to the StratoPress (See **"Setup & Maintenance"** for transferring programs to and from cards). Card programs cannot be edited, but all other functions are the same as **Choice/Ceramic** mode.
- Preprogrammed Card with reference program (Read Only)

Cards are available which contains all ceramic programs stored in the StratoPress.

## SETUP

The **Setup** screen provides operator access to a number of furnace controls and features. The **Setup mode** is accessible from the mode selection screen.

1. Press **Setup (F4)** key
2. Turn adjusting wheel clockwise to move the cursor to an operation

Press the adjusting wheel to select the operation.

**Clr Special:** Memory clear of special programs


**Idle Time:** Muffle comes down automatically after count down (0:00 disables function)

**Nite Temp:** Idle temperature of the muffle between firing programs. Range: 100-800°C.

**Calib Temp:** Adjustment to furnace temperature calibration. Range is + 30°C to -30°C. Factory setting is 0. The value added / subtracted from 960°C (silver melting temperature).

**Set/Clear Choice:** Select a Favorite program to be listed separately. Clear the choice status of a program.

**Date/Set Time (date):** Turn the adjusting wheel to change the value and push to advance to the next number in time and date display.

**Lock Prog:** Locks or unlocks the program editing operation. To activate this feature push the adjusting wheel and dial a code between 1 and 1200. Press the adjusting wheel and a locked symbol (  ) will appear. To unlock the edit function repeat the procedure and dial the previously entered code.

**Edit Lab Name:** Turn the adjusting wheel to Lab Name and push the wheel. The name of the company can be written. It then will be displayed at the "Select Mode" screen. (See "**Edit a Program Name**", pg. 9)


**Set English, Set Hollands, Set Deutsch:**


Changes the furnace parameter words to the selected language. The cursor  on the right side points to the current selection.

**Start Vac Purge:** Automatic muffle clean cycle with vacuum.

**Start Air Purge:** Automatic muffle clean cycle without vacuum.

**Card to Program Transfer**


 **>>> Prog:** Loads the memory card programs into the StratoPress. To download from the card to the StratoPress:

1. Select **Setup** from **Mode Selection** Screen
2. Insert Card
3. Move cursor to " **to Program**", push wheel
4. Move cursor to first program to be transferred, push wheel
5. Turn wheel clockwise until all programs to be transferred are selected, push wheel
6. Turn wheel to desired # , push wheel (programs are automatically transferred)  
(Note: **Existing programs will be overwritten**)

## SETUP

### Program to Card Transfer

**Prog >>>**  : User can store up to 40 selected programs from the StratoPress Backup card:

1. Select Setup from Mode Selection Screen
2. Insert Card
3. Move cursor to **“Program to  ”**, push wheel
4. Move cursor to first program to be transferred, push wheel
5. Turn wheel clockwise until all programs to be transferred are selected, push wheel
6. After the programs are downloaded, the current date/time is written on the card  
(Note: Only a **“Backup”** card will accept programs)

### Delete Card Programs

**Clear:** Erases all programs contained on the “Back Up” card.

1. Turn the adjusting wheel to delete and press the wheel. On the left most “Function Key” the word **“Delete”** will appear.  
Press this key to delete all programs from the card. The card is now ready to accept up to 40 programs.

# MAINTENANCE

## General

Maintenance and care includes work which ensures perfect operational reliability of the StratoPress.

The internal lift motor and other parts are maintenance-free.

- ⚠️ Prior to cleaning, the unit must be **switched off and unplugged**.
- ⚠️ When cleaning the unit make sure that no moisture can penetrate into the unit. In this way you avoid short circuits which may result in the breakdown of the unit or other hazardous conditions.
- ⚠️ Do not open the unit. Hazardous voltages have been applied in the unit. Repairs must only be performed by authorized service technicians (call Elephant Dental B.V., department: Technical Support Equipments.)
- ⚠️ Manipulations of the unit reduce the operational reliability and include the risk of damage to persons or materials.
- ⚠️ Depending on the frequency of use, it is recommended to calibrate the furnace at least once a year. For instructions for manual calibration, please visit our website (Downloads/Instructions for use/Consumables/Instructions for a manual calibration).
- ⚠️ User has the responsibility for carrying out appropriate documentation if a hazardous material is spilt on or inside the equipment.
- ⚠️ Before using any cleaning or decontamination method except those recommended by the Elephant Dental, B.V., user should check with Elephant Dental, B.V., that the proposed method will not damage the equipment.

## Replacement Fuses:

Receptacle: F250 V, 10A (230 V only)

PCB-F1: F250 V, 1.0A

## MAINTENANCE

In the event the microprocessor detects a malfunction the display shows an error window with a brief description and Err number. Except for vacuum and motor lift errors the StratoPress aborts the firing cycle, the power relays open, an acoustic warning signal can be heard and the operator must unplug the unit from the AC line.

- **No Temp Signal (Err 1)**  
The thermocouple is open
- **Temperature too high (Err 2)**  
The thermocouple reading is above 1210°C
- **No Temp Increase (Err 3)**  
A thermocouple was installed with the wrong polarity (backwards)
- **Triac Shorted (Err 4)**  
The muffle current sensor detected no current control (always on)
- **Muffle Open (Err 5)**  
The muffle current sensor detected no current
- **No Vacuum (Err 6)**  
The vacuum sensor reading does not change:
  - Check hose, electrical pump connections
  - Check proper door closure
- **Low Vacuum (Err 7)**  
The vacuum level achieved is not acceptable for porcelain firing:
  - Check pump performance
  - Check proper door closure
- **Motor too Slow (Err 8)**  
The muffle travel took longer than 12 seconds:
  - Check for excessive friction or interference
- **Motor: No Signal (Err 9)**  
The motor position sensor reads outside its operating range
- **Wrong Card**  
Only StratoPress cards are valid, cards from other furnaces do not work
- **Read Only**  
This card can not be written to

# SPECIFICATIONS

## OPERATIONAL SPECIFICATIONS

- Temperature Accuracy: +/- 3°C (+/- 5.5°F) at steady state
- Muffle Temperature Uniformity: +/- 5°C (+/- 9°F) at steady state

## ELECTRICAL

Voltage Ranges: 230V 50/60Hz  
 Currents: 7.2 Amps @ 230V  
 Wattage: 1740 Watts with pump max.

Watts to Maintain 1000°C: less than 400 Watts, muffle closed, no vacuum pump

## MECHANICAL

Exterior Dimensions: See Outline Drawing below. Height w/Thermocouple: 38.1mm (1.5")  
 Interior Muffle Dimensions: Furnace Weight: 25 Kg (47lbs)  
 Diameter: 102mm (4") Shipping Weight: 30 Kg (57lbs)  
 Height: 63.5mm (2.5")

## ENVIRONMENTAL

Ambient Operating Temperature: 5 - 40°C (41°F - 104°F)  
 Relative Humidity: Maximum 80%, non-condensing

Conforms with the basis requirements of the following EC guidelines:

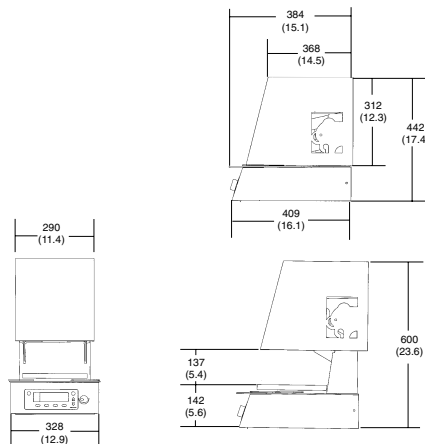
- Low Voltage Directive 73/23/EEC  
 with 1. Modification 93/68/EEC
- EMC - Electromagnetic Compatibility 89/336/EEC  
 with 1. Modification 92/31/EEC  
 2. Modification 93/68/EEC

The following harmonized standards were applied:

- EN 61010: 2001 (Safety)
- EN 61010: 1992 + A1: 1996 (Safety)
- EN 61326: 1998 (EMC)

## OUTLINE DRAWING

mm (in)



## ACCESSOIRES

### DESCRIPTION

Strato Vacuum Pump 230V

Door Insulation Packaged

Tweezers

Honeycomb tray with pins

Accessory set, complete

Pressure regulator set, complete

Owner & Operator's manual

## PRODUCT SERVICE

Elephant Dental B.V.  
Verlengde Lageweg 10  
1628 PM Hoorn  
The Netherlands

Tel.: +31 229 25 90 00

Fax: +31 229 25 90 99

## WARRANTY

**WARRANTY:** Except with respect to those components parts and uses which are hereinafter described, Elephant Dental B.V. warrants this furnace to be free from defects in material and workmanship for a period of one year from the date of sale. Elephant Dental B.V.'s liability under this warranty is limited solely to repairing or, at Elephant Dental B.V.'s option, replacing those products included within the warranty which are returned to Elephant Dental B.V. within the applicable warranty period (with shipping charges prepaid), and which are determined by Elephant Dental B.V. to be defective. This warranty shall not apply to any product which has been subject to misuse; negligence; or accident; or misapplied; or modified; or repaired by unauthorized persons; or improperly installed.

**INSPECTION:** Buyer shall inspect the product upon receipt. The buyer shall notify Elephant Dental B.V. in writing of any claims of defects in material and workmanship within thirty days after the buyer discovers or should have discovered the facts upon which such a claim is based. Failure of the buyer to give written notice of such a claim within this time period shall be deemed to be a waiver of such claim.

**DISCLAIMER:** The provisions here-in stated Elephant Dental B.V. sole obligation and exclude all other remedies or warranties, expressed or implied, including those related to MERCHANTABILITY and FITNESS FOR A PARTICULAR PURPOSE.

**LIMITATION OF LIABILITY:** Under no circumstances shall Elephant Dental B.V. be liable to the buyer for any incidental, consequential or special damages, losses or expenses.

**LIMITATION OF ACTIONS:** The buyer must initiate any action with respect to claims under the warranty described in the first paragraph within one year after the cause of action has accrued.

# Elephant



dental health products

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