



detax

**Materials
that matter**

Detax Processing Manual

FREEPRINT[®] crown
&
FREEPRINT[®] denture flex

Bonding the printed denture teeth to the printed denture flex base.

Presentation content

1. Overview
2. Prepare crown / bridge
3. Check the fitting of denture flex base and crown / bridge
4. Bonding of denture flex base and crown / bridge
 - Bonding material
 - Process (step by step)
5. 3D Printing materials
6. Accessories

1) Presentation Overview

Follow the IFU instructions for washing the denture flex base and denture teeth with IPA.

ATTENTION

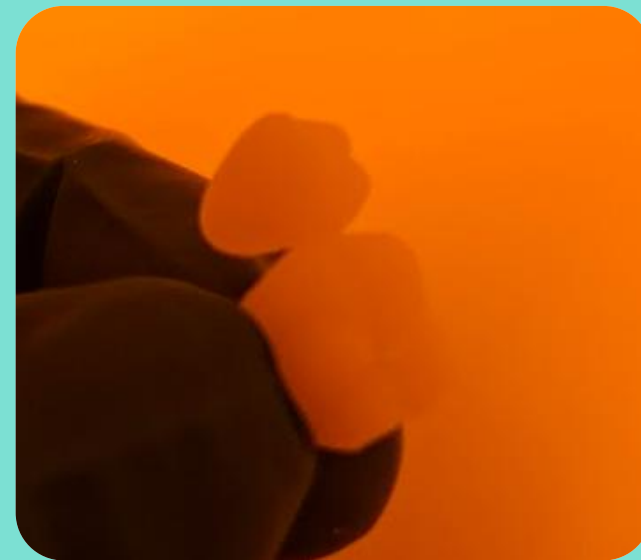
After washing, don't post-expose the uncured components.

Wear personal protective equipment when handling the uncured material.



2) Prepare crown / bridge

Remove the supports from printed part carefully



3) Check the fitting of denture flex base and crown / bridge

dx



4) Bonding of denture flex base and crown/ bridge

- Bonding material

FREEPRINT® denture flex resin is used for bonding the denture teeth.

Make sure that you use the same color which you used for printing.



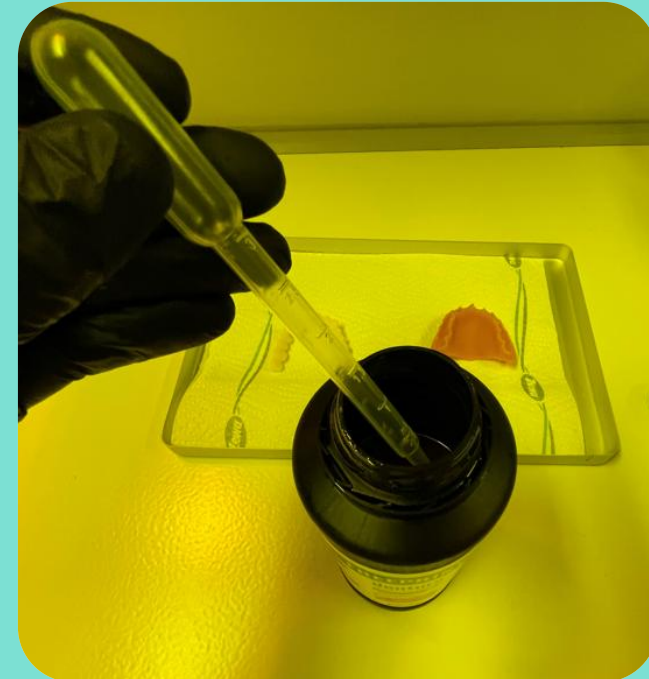
4) Bonding of denture flex base and crown / bridge

dx

- Process Step 1

Application with an application syringe

- Detax recommend an application syringe for the application of the FREEPRINT® denture flex material.
- To remove the FREEPRINT® denture resin from the bottle, Detax recommend a pipette.



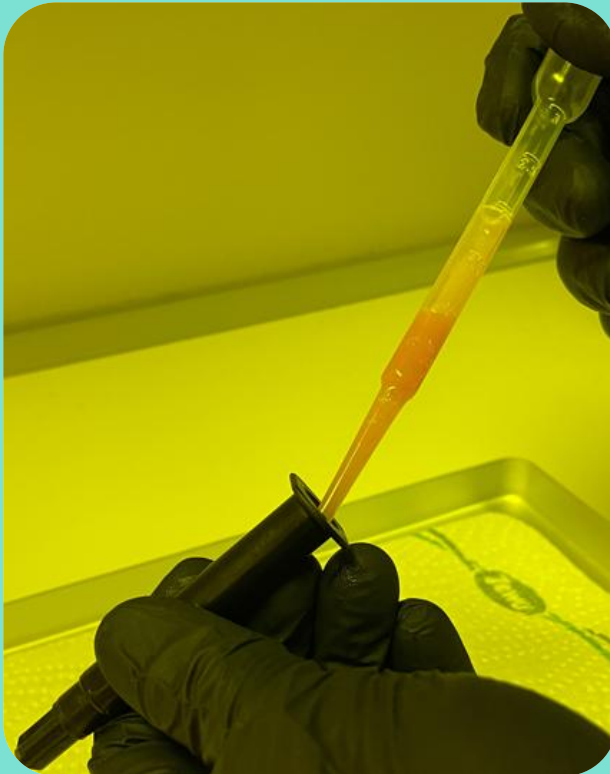
4) Bonding of denture flex base and crown / bridge

dx

- Process Step 2

Application with an application syringe

- Fill the application syringe carefully.
- After filling the syringe, remove the cap carefully.



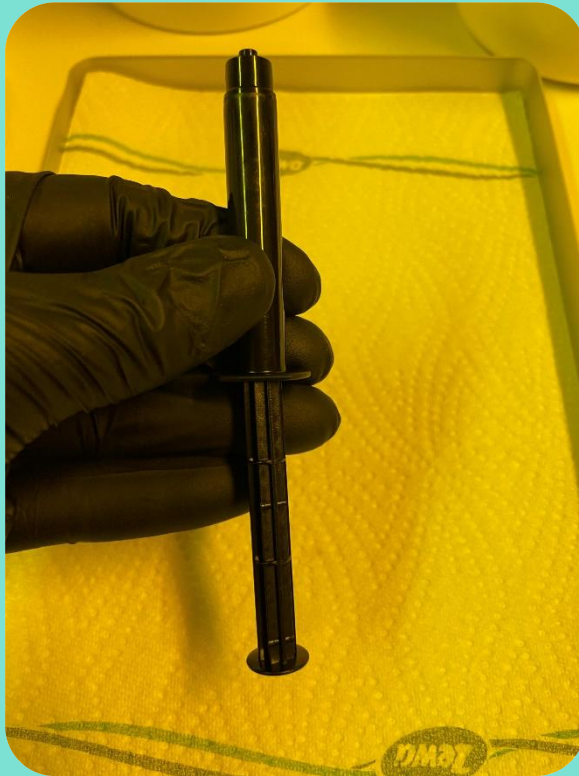
4) Bonding of denture flex base and crown / bridge

dx

- Process Step 3

Application with an application syringe

- Press the piston carefully and slowly into the syringe.
- Until a small amount of material comes out of the opening.



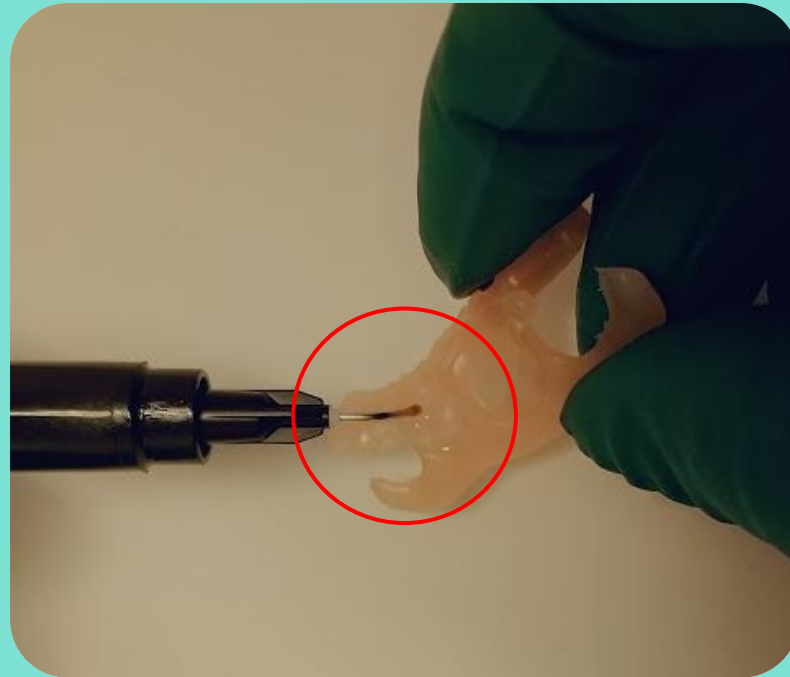
4) Bonding of denture flex base and crown / bridge

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- Process Step 4

Application with an application syringe

- Place the application needle on the syringe.
- Apply the FREEPRINT® denture flex material with the syringe into the cavities with slight pressure.



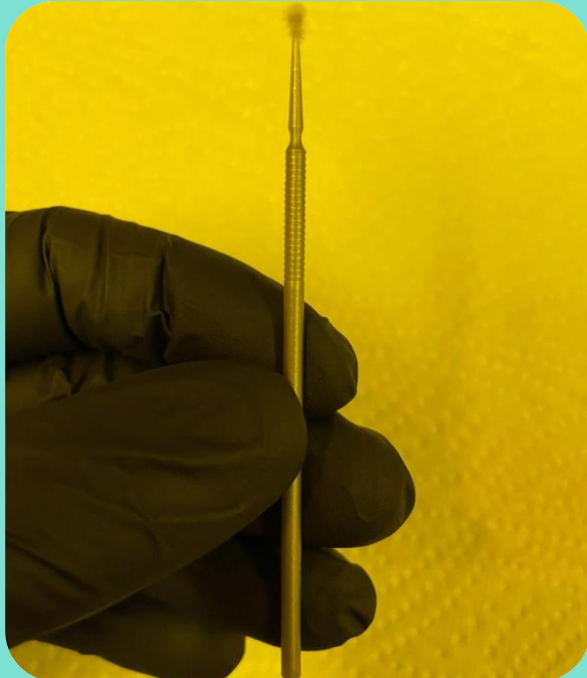
4) Bonding of denture flex base and crown / bridge

dx

- Process Step 5

Application with an application syringe

- Using a brush to remove the excess material on the cervix of the teeth.



4) Bonding of denture flex base and crown / bridge

dx

- Process Step 6

- For pre-curing, the denture (flex base and teeth) is cured with 400 flashes (Otoflash G171 N2) with nitrogen.
- Make sure you use the correct tray (UV360).



4) Bonding of denture flex base and crown / bridge

dx

- Process Step 7

Application with an application syringe

- If material needs to be applied again, you can apply it now before the final curing.
- After final use, please close the syringe with the cap.



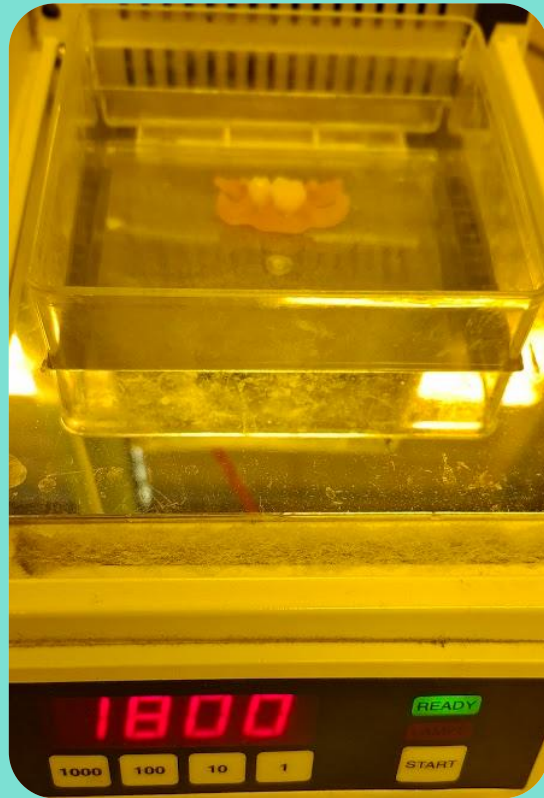
4) Bonding of denture flex base and crown / bridge

dx

- Process Step 8

For final curing, the denture (flex base and teeth) is cured with 2 x 1800 flashes (Otoflash G171 N2) with nitrogen.

Between the 2 curing cycles, please turn the denture flex around.



4) Bonding of denture flex base and crown / bridge dx

- Process Finish

Finishing after light curing



Interdental fine finishing

- If necessary, the excess FREEPRINT® denture flex resin can be grinded off in the interdental area using a diamond disc or a separating disc.

Grinding in the occlusion

- Place the denture on the model and check the centric, protrusion, retral movements and sideshift in the articulator - the occlusion is successively grinding according to the grinding rules.

Polish

- Smoothing the surface of the denture before polishing can be done classically with sandpaper strips.
- The polishing of the denture is done at the polishing unit from coarse to fine: 1. brush/pumice, 2. brush/polish and 3. buff/polish.

Cleaning

- Clean the denture in the cleaning liquid in the ultrasonic unit for max. 1 min.
- It is possible to use a toothbrush and a steam jet for cleaning.

5) 3D Printing materials



FREEPRINT® crown

- FREEPRINT® crown A1 500 g 02372 1.000 g 02376
- FREEPRINT® crown A2 500 g 02378 1.000 g 02415
- FREEPRINT® crown A3 500 g 02417 1.000 g 02446
- FREEPRINT® crown A3,5 500 g 04709 1.000 g 04708
- FREEPRINT® crown B1 500 g 02481 1.000 g 02519
- FREEPRINT® crown B3 500 g 02645 1.000 g 02758
- FREEPRINT® crown C2 500 g 02766 1.000 g 02782
- FREEPRINT® crown D3 500 g 02783 1.000 g 02825
- FREEPRINT® crown BL 500 g 02845 1.000 g 02884



FREEPRINT® denture flex

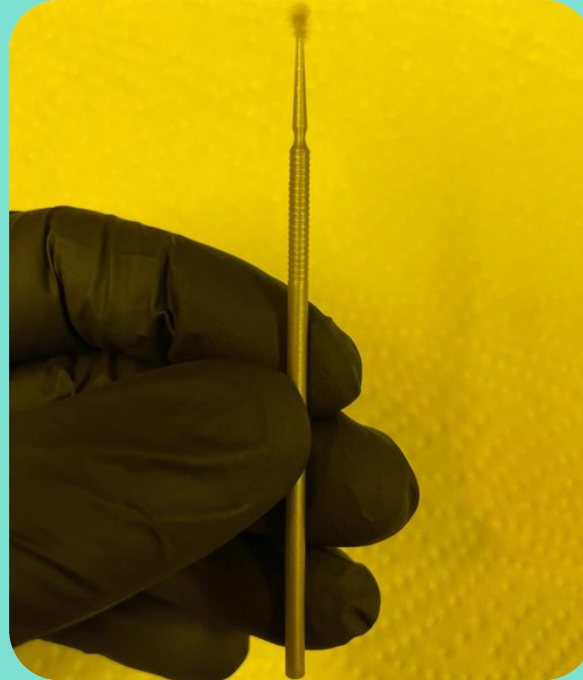
- FREEPRINT® denture flex pink-transparent 1.000 g 04625
- FREEPRINT® denture flex clear 1.000 g 04626

6) Accessories

- 04757 Bonding Set black 3 ml, 5 x application syringes incl. cap, 20 x application needles



- 02715 smartbrush, pack of 100 pcs.



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Thank you for your attention

support@detax.de

detax GmbH
Carl-Zeiss-Str. 4
76275 Ettlingen, Germany
detax.de

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