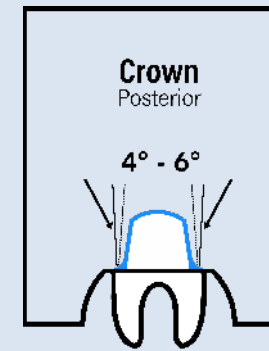


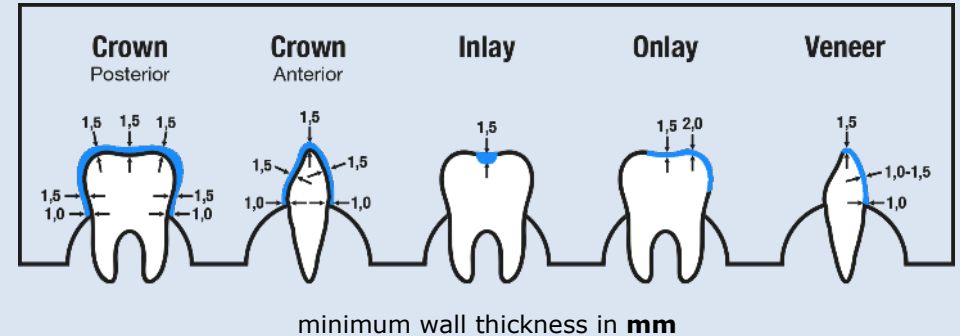
### Tooth preparation

- Make sure to create a stump with a  $4^{\circ}$  -  $6^{\circ}$  cone. Round off all the transitions within the preparation to avoid unwanted tension under the restoration material.
- Also make sure to avoid tangential, spring edge or lip preparations. Therefore, exercise special care when using instruments with a round tip and do not introduce them any further than up to half their diameter at maximum! Please note that tangential preparations are technically unfeasible and would result in too thin, i. e. instable and overcontoured, crown margins.
- The preparation limit must have a width of at least 1 mm.
- Both a shoulder preparation with rounded interior angles and a distinct chamfer preparation may be carried out. Rework the preparation margin using finishing instruments of matching shape.



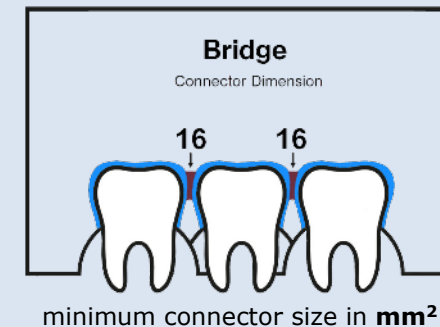
### Model the workpiece on the computer

- Permanent crowns, inlays, onlays, veneers:  
Always keep the minimum wall thickness – even after manual grinding  
(The dimensions apply also to artificial teeth and temporary crowns, inlays, onlays and veneers)



- Temporary bridges:  
Keep a connector size of at least 16 mm<sup>2</sup>

The connector area should be as large as possible.  
For physical stability, the height of the connector is more important than the width. Doubling the width results in only doubling the strength, while doubling the height results in eight times the strength.  
Oval connector areas are therefore recommended.



### Generate the printing file

Use the appropriate software "Alpha 3D" and download the required parameter set from Ackuretta's database. Deliver it in a suitable form to the printer by observing the instruction for use of the software and of the printer.

### Note

Ensure to use the appropriate version of the file!

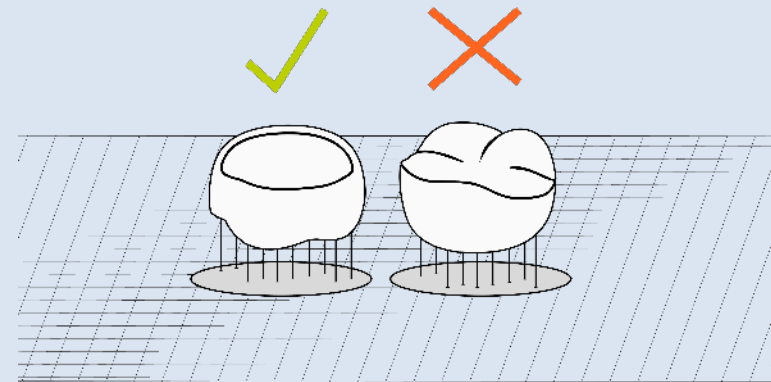
<https://ackuretta.com/pages/alpha-3d>

Also make sure that you have selected the "Resin Type" menu with "saremco print CROWNTEC".

### Useful hints

Create the supports on the occlusal surface.

With a 0.3 mm thick "Bounding Box" or also called "Base Plate" the material holds perfectly during printing and can easily be removed from the platform after printing.



**Print**

- Work as clean as possible
- Dirty trays or machines can cause deformation/discoloration
- Briefly shake the resin (1 – 3 minutes) and pour it into the tray of the printer
- Start the printing process

**Note**

Wait until a printing temperature of 35° C / 95° F is reached.



**Clean the printed job by following every step carefully**

- Clean the building platform with a suitable spatula
- Remove the building platform from the machine, place it on a cloth or paper



- Remove the printed job carefully from the platform



- Roughly snap off the supports



- Remove excessive material with an alcohol-soaked (96 %) cloth or brush
- Clean the interdental areas and the interior surfaces of the crown with a suitable alcohol-soaked (96 %) brush, until the surface is lightly matt

**Note**

Never soak the printed job into alcohol.



**Freshly printed**

**Surface:** glossy  
**Inside:** glossy



**Not enough cleaned**

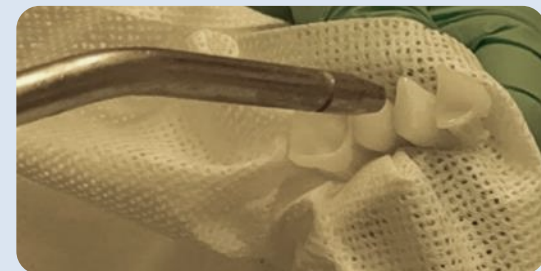
**Surface:** slightly matt  
**Inside:** glossy



**well cleaned**

**Surface:** slightly matt  
**Inside:** slightly matt

- Dry thoroughly with an air syringe

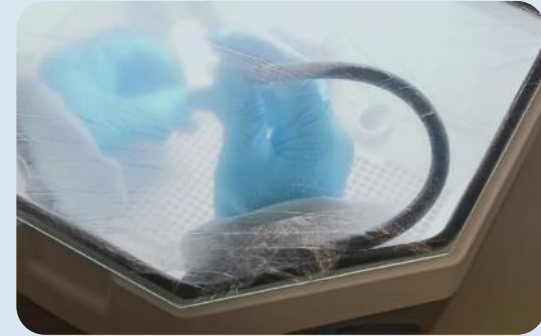


**Optional step**

Carefully sandblast the printed part surfaces to remove the remaining coating using a sandblaster with polish blasting material 50 µm at a maximum blasting pressure of 1.5 bar.

**Note**

Take care to avoid any deformation or damage of the printed job.



**Optional step – Individualization of the crown or tooth**

Apply intensive colors e.g. *els paintart* from SAREMCO.





### Finish the printed job - Cure

- Polymerize in an appropriate UV-light box with a wavelength of 320 – 500nm
- Make sure that the light device performs with the adequate light-power
- Recommendation (turn objects between the exposure cycles):
  - Haereus Kulzer "Signum HiLite Power" (2 x 180 s)
  - NK-Optik UV-Flash device "Otoflash G171" (2 x 2000 flashes)
  - Ackuretta "Curie" (2 x 3 minutes)

### Note

To achieve the desired material properties, biocompatibility and final shade, post-curing of the completely dried and cleaned job is necessary.

### Useful hint

Speed up the color finalization by placing the printed job into boiling water (100 °C) for 2 minutes after post-curing.

Additionally, the printed job can be cured from each side 2 x 20 seconds with a hand polymerization lamp at maximum power (e.g. with Bluephase® G2).



### Finish the printed job – Polish

- Work out the restoration with 40 $\mu$  and 12 $\mu$  diamond burs
- Polish to a high gloss using polishing brushes, polishing discs, strips or silicone polishers



**Attach – permanent crowns, inlays, onlays or veneers to the tooth**

- Roughen the inside of the printed job by sandblasting with an abrasive ( $Al_2O_3$ , 110 $\mu$ m)
- Then, fix it definitively with an appropriate composite cement material. Panavia V5. (Kuraray) and Variolink (Ivoclar) are recommended

**Note**

Zinc-phosphate cements as well as glass-ionomer-cements are only of limited suitability due to their opacity.



**OR**

**Attach – temporary crowns, bridges, inlays, onlays or veneers to the tooth**

Attach the finished temporary prosthesis with a commercially available provisional cement.



**OR**

**Attach – artificial teeth on a denture base**

- Roughen the base surface of the printed artificial teeth for e.g. by sandblasting ( $\text{Al}_2\text{O}_3$ ,  $110\mu\text{m}$ )



- Apply a primer and a bonding material, insert in the prosthesis according to the natural shape and polymerize

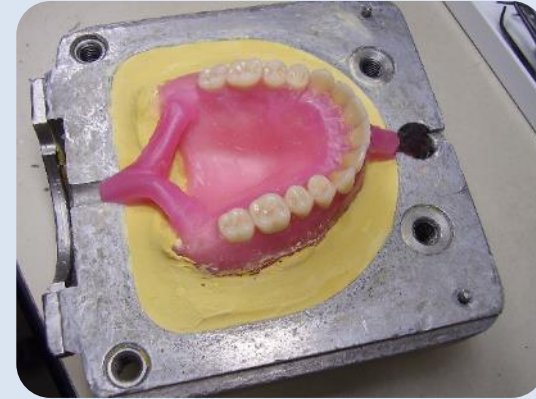
Alternatively, CROWNTEC can also be used directly as bonding material. Put a small amount of material with a brush on the roughened teeth-surface of the artificial tooth, put it into the prosthesis, eliminate any excess material and light-cure it from all sides for at least 20 seconds.



**or**

**Attach – artificial teeth in a denture base (classical manufacturing)**

Use a classical manufacturing procedure like the pouring method with cold cure resin after roughening the teeth.



[https://de.wikipedia.org/wiki/Datei:Making\\_of\\_complete\\_denture\\_04.JPG#filelinks](https://de.wikipedia.org/wiki/Datei:Making_of_complete_denture_04.JPG#filelinks)

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