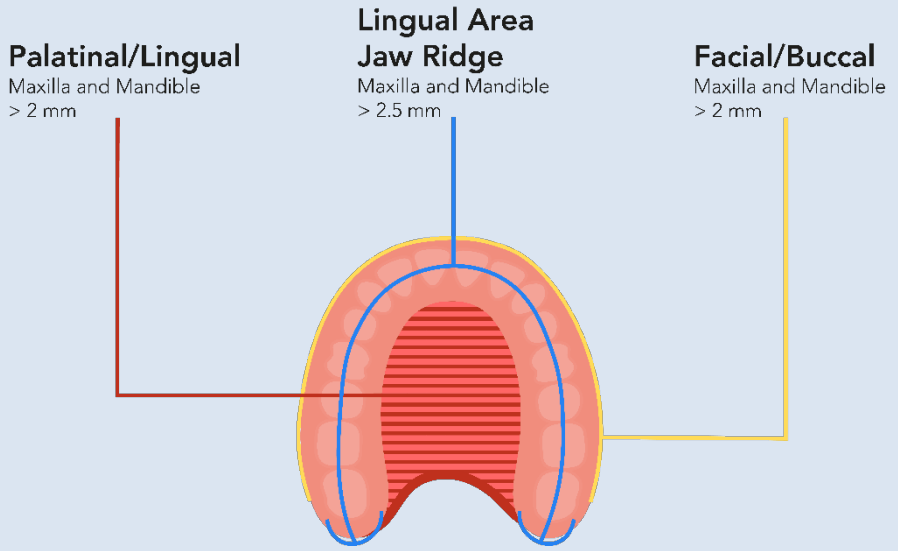
Model the workpiece on the computer

- Always keep the following minimum layer thicknesses for DENTURETEC

Area	Maxilla	Mandible
Lingual area of the jaw ridge	≥ 2.5 mm	≥ 2.5 mm
Palatinal/Lingual	≥ 2 mm (≥3 mm single arch on top)	≥ 2 mm
Facial/Buccal	≥ 2 mm	≥ 2 mm
Implant-supported full denture	≥ 2.5 mm	≥ 2.5 mm



Generate the printing file

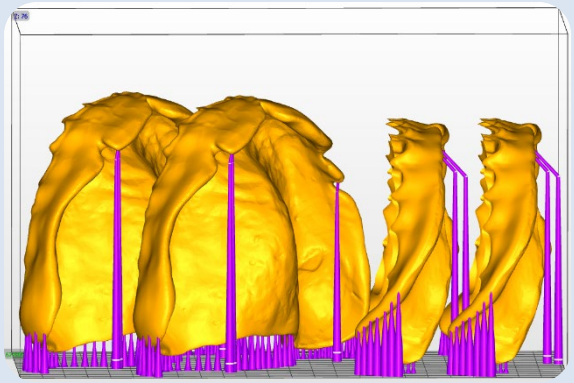
- Use the appropriate software (Composer) and download the required parameter set from ASIGA database. Deliver it in a suitable form to the printer by observing the IFU of the software and of the printer

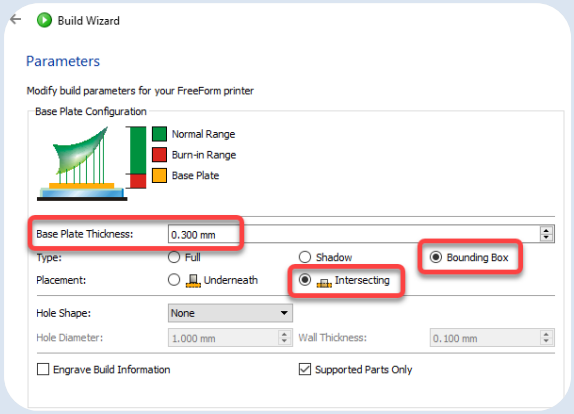
Note

Ensure the use of the appropriate ini-file version.

Useful hints

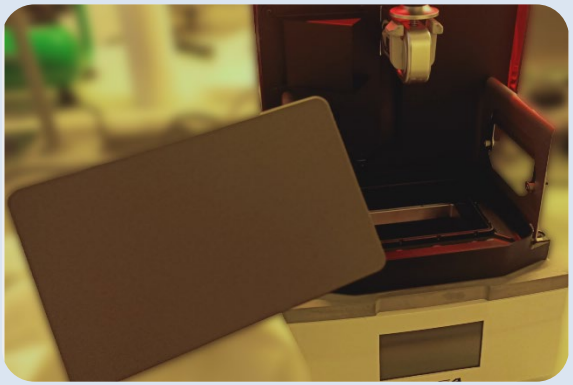
Set the prosthesis base vertically and make sure you generate enough supports.
With 0.3 mm thick "Bounding Box" also called "Base Plate" the material holds perfectly during printing and can easily be removed from the platform after printing.





Print

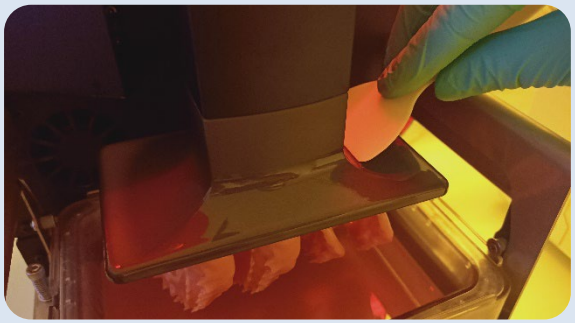
- Work as clean as possible. Dirty trays or machines can cause deformation/discoloration. Briefly shake the resin and pour it into the tray of the printer
- Start the printing process



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

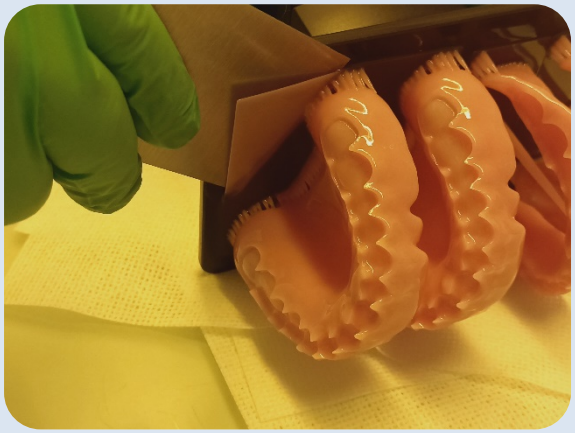
Clean the printed job by following every step carefully

- Clean the building platform with a suitable spatula

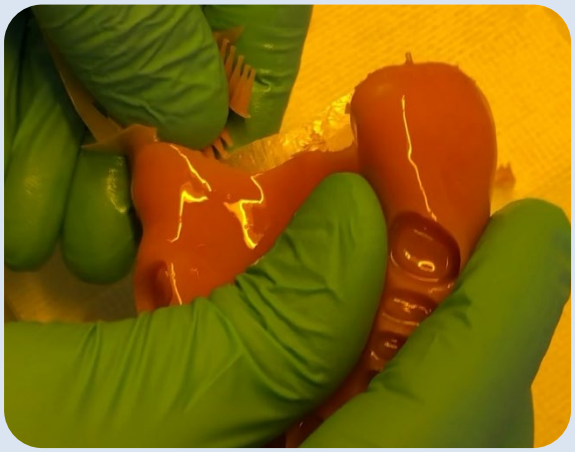


- Remove the building platform from the machine, place it on a cloth or paper

- Remove the printed object 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 all resin remains are completely removed

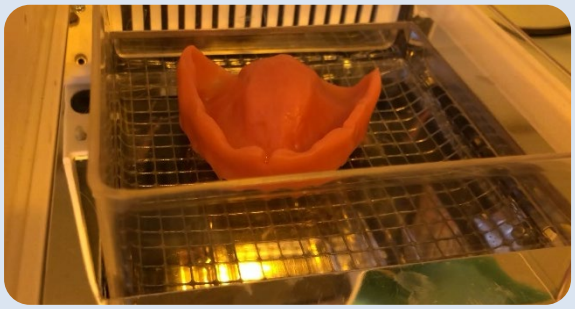
Note
Never soak the printed job into alcohol.

- Dry thoroughly with an air syringe

Finish the printed job - Cure

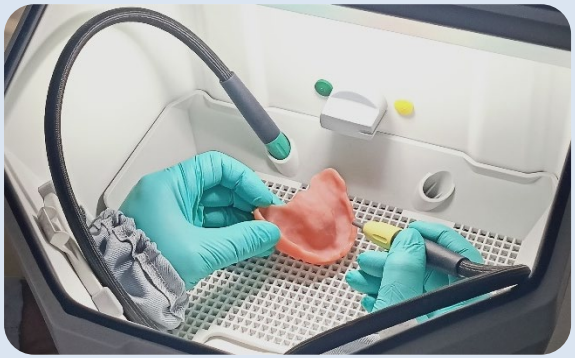
- Polymerize in an appropriate UV-light box with a wavelength of 320 – 500nm. Suggestion: "Signum HiLite Power" from Haereus Kulzer (2 x 180 s) or UV-Flash device "Otoflash G171) from NK-Optik (2 x 2000 flashes; turn objects between the exposure cycles)
- Make sure that the light device performs still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

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



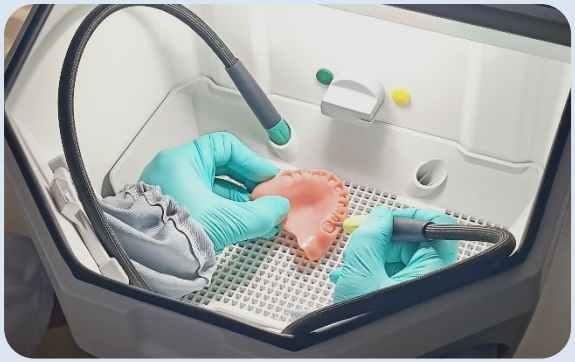
Finish the printed job – Polish

- 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
- Grind down the remaining blunt supports with a suitable cutter



Attach – artificial teeth on a denture base

- Roughen the base surface of the printed artificial teeth for e.g. by sandblasting (Al_2O_3, 110µm)



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

Alternatively, CROWNTEC or DENTURETEC 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.

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