

Finishing:

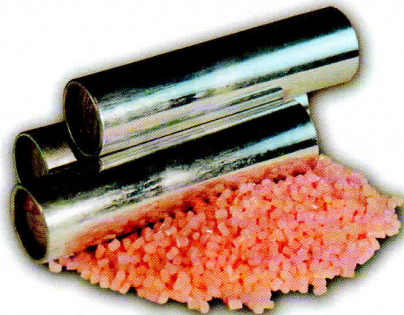
LustreFlex can be polished to a brilliant shine quickly and easily, far surpassing that of other flexible partial materials

Remove sprues and save for doing minor repairs/additions when necessary
Use the normal method of reducing and smoothing the case, and then using pumice and a rag wheel, polish to a glass-like finish

Repairs/addtions:

LustreFlex material has the ability to be added in small amounts, primarily for fixing any surface porosity

- ✓ Using a torch, heat the area to be repaired just enough to give it a wet sheen look, and also heat a used sprue until molten but not dripping
- ✓ In the presence of the flame, press the sprue to the heated area of the case quickly and pull away leaving a deposit of material on the case
- ✓ Refinish case



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INSTRUCTIONS

Pre-Injection:

RECOMMENDED THICKNESS OF THE WAX PATTERN:

1. Palatal thickness: 1.25 - 1.5
2. Buccal & Labial Flange: 1.25 - 2.0mm
3. Clasps: 1.0 - 1.5 mm (Always uniform with flange and junction)
4. Lingual Flange: 1.25 - 2.00mm
5. Lingual Major Connector (Mandibular): 1.75 -2mm

IMPORTANT:

Always use 3 sprues to ensure even injection.

Tubes should always be kept in a dry environment and should be dried to evaporate moisture prior to melting, at 60° - 80° degrees Celsius (140°-176°F) before use.

Prior to injection, the flask needs to be pre-heated for approx. 10-15 mins. at 60°-80° Celsius (140°-176°F) to allow good flow of material and even injection.

Injection:

Air Pressure should be set between 100-130 lbs.

Temperature:

**275° - 300° Celsius
525° - 550° Fahrenheit**

Times:

**Medium Tubes: 11-13 minutes
Large Tubes: 12-14 minutes**

**While the recommended temperatures and times are a good guide for most labs, the numbers may vary based on your equipment.*



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