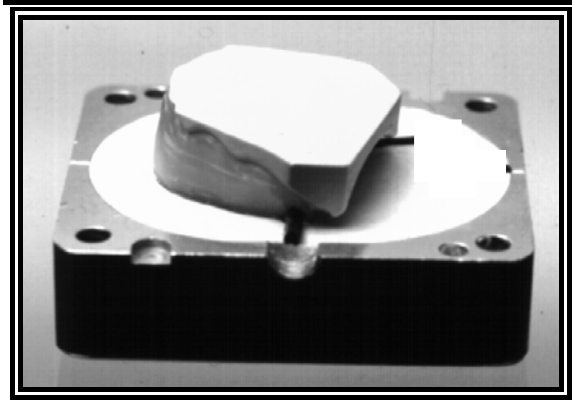

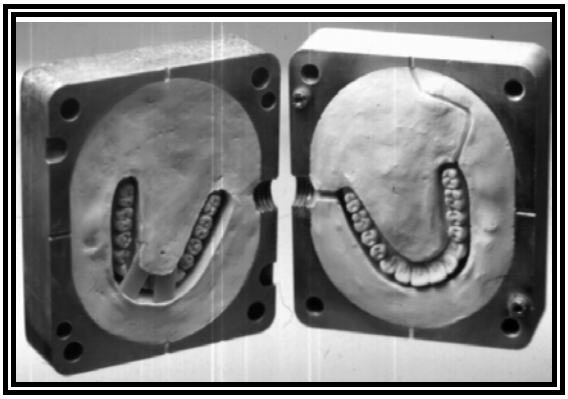

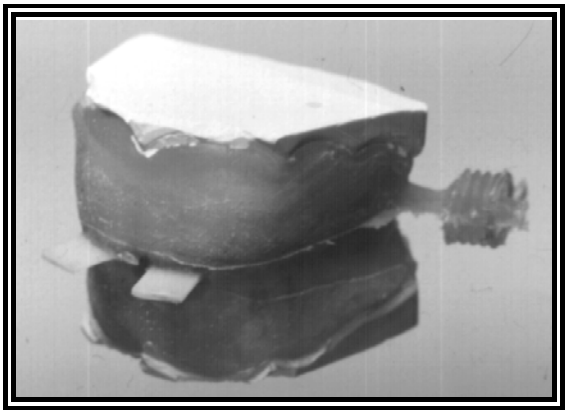

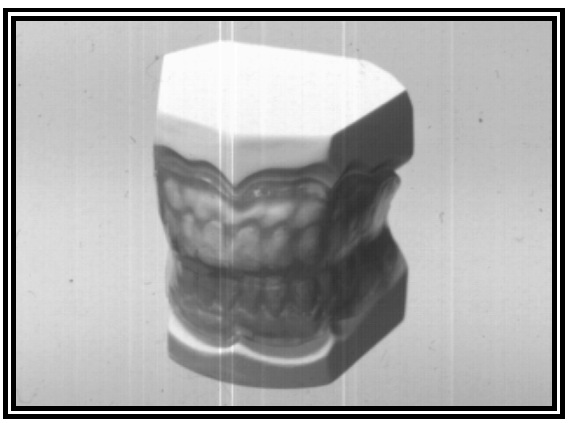

Pressing Dental®

Technical tables 010 – 011 (GB)
Positioner and Gum-Shield Manufacturing Procedure

1) Fully waxed-up duplicated models.

a) Duplicate the master models preferably using a type of silicone consisting of two components (possibly an alginate).
b) With this procedure the duplicated model can be made of hard conventional plaster.
c) Spread the photopolymerizable "Gyplux" on the whole surface to be covered by the wax.

2) Position of the models in the flask base

a) The mold plaster must cover the lower model completely thereby blocking the spacers suitably arranged for respiration.
b) Sprues:
1st option - one single 4 mm. wide sprue and a 1,5 mm. wide outlet channel placed at the other
2nd option - Two 4 mm. wide sprues on the trigones and a 1,5 mm. wide outlet channel placed vestibularly in line with the central incisors.
N.B. In both cases there must be a zig-zag outlet channel.
d) Use plaster-plaster insulation for the flask before making the countermold

3) Open flask after wax removal

a) Close the flask at room temperature.
For type 80, position the flask using an oven centering device with an insulating thickness.

4) Pressure-injection finished positioner removed from the flask.

5) The positioner on the master models.

Pressing® Mod. J-100 must be programmed as follows:

Melting temperature	**165 °C. (type 80)**
Melting time	**20 Min. (J-100 Timer 1)**
Heating time after injection	**00 Min. (J-100 Timer 2)**
Cooling time under pressure	**20 Min. (J-100 Timer 3)**
Injection pressure	**04 Bar (J-100)**

Remove the flask only at the end of the cycle.

a) Open the flask when it is at room temperature.
b) First use abrasive paper and/or silicone burrs to finish the product and then just feltsPolyflex with "Corflex® Polish".
c) "Corflex® Brilliant" provides an enhanced shining effect.

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Cod. T.T. Corflex Orthodontic 80 010-11 / 0