



Technical table 007 (GB) Abutment Manufacturing Procedure

1) Master Model

- a) With this type of procedure the model can be made of hard conventional plaster.
- b) Perspective view of the wax element.

2) Wax element placed in the flask.

- a) The pins connecting the wax element to the bar are 2 mm wide and the bar is distant 3 mm.
- b) The feeding bar is 5 mm wide.
- c) The sprues are 5 mm wide.
- d) In this case the wax element has been removed, one can chose wether to put the master model into the flask.
- e) Use plaster-plaster insulation for the flask before making the counter mold.

3) Open flask after wax removal

- a) Close the still hot flask and place it on the oven centering device. Tighten the press manually.
- b) Start the melting process to pre-heat the flask.

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

5) Perspective view of "Acetal Dental®" abutment placed on the trial model

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

Melting temperature	220 ° C.
Melting time	20 minutes (J-100 Timer 1)
Heating time after injection	05 minutes (J-100 Timer 2)
Cooling time under pressure	40 minutes (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) Conventional burrs for acrylic resins can be used for the finishing process.
- c) To enhance polish use "Universal Polish"

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