

Technical table 001 (GB) Esthetic Clasp Manufacturing Procedure

1) Fully waxed-up duplicated model

- Duplicate the master, with the metallic partial denture in position, preferably using an alginate.
- With this type of procedure the model can be made of hard conventional plaster.
- Model the wax clasp 2,5 mm thick.

2) Position of the model in the flask base

- Remove undercuts from the model.
- The plaster layer in the mold must be as high as the wax element and must not cover the clasp.
- The feeding channel is 4 mm. wide.
- Use plaster-plaster insulation for the flask before making the counter mold.

3) Open flask after wax removal

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

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

5) View of the metallic partial denture with the esthetic clasp on the master 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	02 minutes (J-100 Timer 2)
Cooling time under pressure	20 minutes (J-100 Timer 3)
Injection pressure	04 Bar (J-100)

Remove the flask only at the end of the cycle.

- Open the flask when it is at room temperature. If necessary, after 20 minutes, dip the flask into the water to cool it down.
- Conventional burs for acrylic resins can be used for the finishing process.
- To enhance polish use "Universal Polish"

