

Flexident



Automatic Press with Digital Furnace



TALLADIUM

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Flexident partials and dentures are unbreakable and can be made thinner than traditional acrylic partials, providing more comfort and confidence for the patient. Flexident flexible partials have just the right degree of flexibility and will not warp or become brittle.

System Requirements

The Flexident Complete System includes a press and a mini oven that should have a separate line for an even current flow to provide uniform heating of the Flexident resin materials.

Impression and Case Planning

A mucostatic impression is required for Flexident partial dentures. With flexible partials, extra attention should be paid to tissue retention because the resin material is in a constant relaxed position.

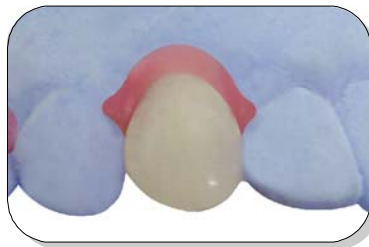
Carefully study the cast model to plan the design of the prosthesis. The ideal flexibility of Flexident resin materials allows designs that use tissue undercuts as well as a portion of the abutment teeth for retention. Planning which clasp type to use depends on the position. With anterior position esthetics is important; therefore, consider minimal coverage of the teeth. With posterior position clasps should provide utmost support and stability of the partial.

BASIC TYPE OF CLASPS

Include:



WRAP AROUND



SPUR

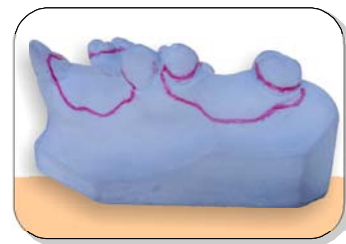
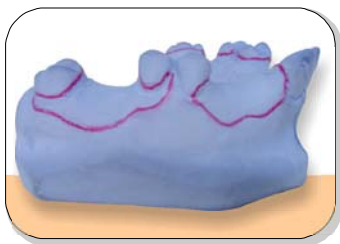


ANCHOR

I. DESIGNING THE MASTER MODEL

As always, make full use of tissue undercuts for retention.

It is recommended that red pencil is used during designing on the master model.



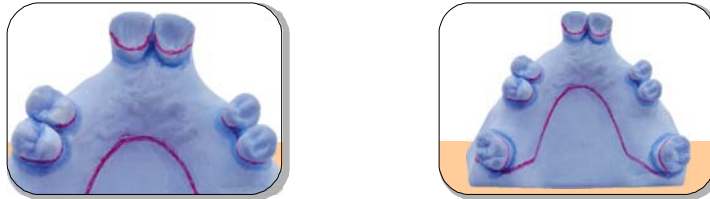
II. PREPARING THE MASTER MODEL FOR DUPLICATION

Do not over-relieve nor over-block. The only time surveying may be required is to create parallelism for a clear path of insertion for interproximal saddles, removing mesial and distal undercuts. However, when left and right interproximal saddles are to be replaced,

there won't be any need to create parallelism because the degree of flexibility of the **TALLADIUM** material allows the partial to be twisted slightly during insertion.

All undercuts that will affect the path of insertion should be blocked. However, undercuts, often on buccal and distal, should not be blocked, as these will be utilized for retention.

It is important to remember that there is no need to relieve with wax the necklines of the tissue except when there is indication of some abnormal recession or some pocket formation. If necklines are healthy, no relief with wax is necessary.



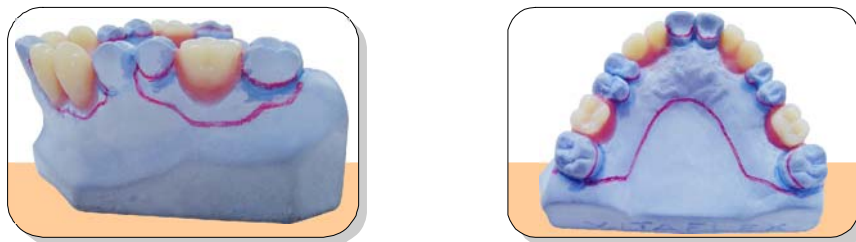
For free-end cases, be it upper or lower, it is not necessary to remove the distal undercut of the last natural tooth. For free-end saddle cases with anterior teeth replacements, undercuts in the front section should be blocked with wax. Always leave distal undercuts for retention.

III. DUPLICATING THE MASTER MODEL

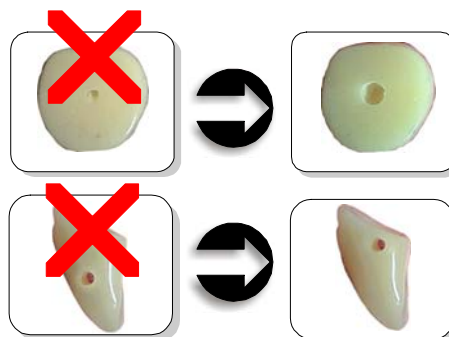


IV. SET-UP

The normal method of set-up is followed except when a tooth is to be replaced beside a tooth that will have a spur clasp. Here, one must allow a little more space at the neckline so that the resin material will have some reinforcement from the lingual to the spur.

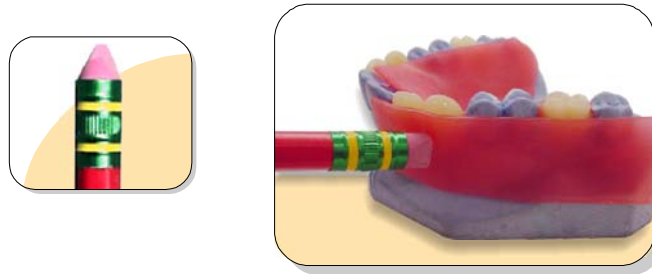


Mechanical retention of pontics (acrylic type is preferred as this follows the principle of non-breakage) is achieved using retention burs.



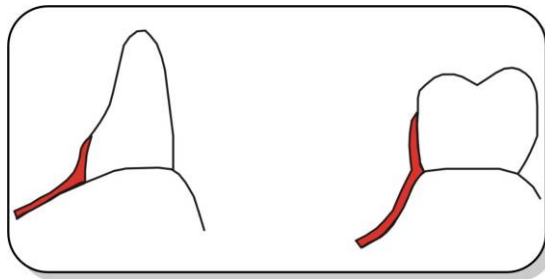
V. WAXING

With **TALLADIUM** flexible partials cases, there is thinner wax-up compared to conventional acrylic partials. Thickness needed should just be enough to provide support especially at critical junctions and connectors. **TALLADIUM** flexible partials are unbreakable with proper design and with proper processing. There should not be any bulky flanges.



Recommended thickness of the wax pattern:

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



Wax pattern should rest on the cingulum of anterior Teeth / Pontics.

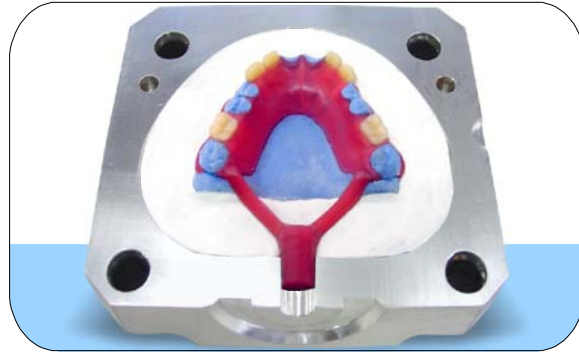
Wax pattern should include the lower 2/3 of the 3 posterior Teeth / Pontics.

VI. INVESTING THE TOP HALF OF THE FLASK

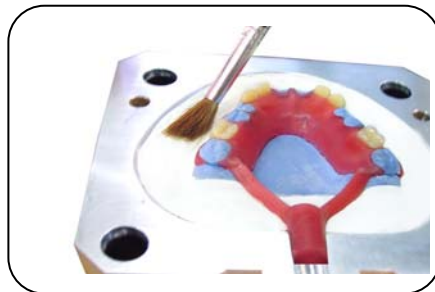


VII. SPRUNG

Sprue the case after investment has set; two sprues are normally required from the center sprue opening found at the rear of the flask to the most posterior portion of the wax-up on either side.



Apply thin layers of tinfoil substitute on the entire stone surface



VIII. INVESTING THE TOP HALF OF THE FLASK

It is necessary to point out that one should use the proper tinfoil substitute to cover the surface of the stone in the bottom half of the flask. And always let the tinfoil substitute dry completely. **DO NOT OVER TIGHTEN THE SCREWS.**



IX. BOIL OUT

Follow standard boil out procedures for making removable partial dentures.

- After the stone has set, the flask is placed in a hot water bath for 6 to 10 minutes
- When the two halves of the flask have been opened, wash out the wax to make sure all residues are eliminated.
- Let the two halves cool, making sure all the steam has evaporated from the flask
- Apply thin layers of tinfoil substitute or Magic Sep on the entire stone surface.
- Allow to dry completely. *(Do not apply the release agent on inner surfaces of the teeth as this will create a gap between the teeth and resin material.)*

Close the two halves of the flask that have cooled down. Tighten the bolts securely in preparation for injecting.



X. INJECTING THE FLEXIDENT

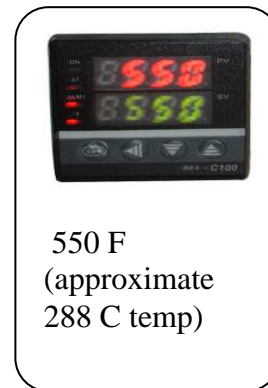
Pre-injection: Tubes containing resin materials should be dried for at least 2 to 4 hours, at approximately 40 degrees Centigrade.

Set the furnace to 550°F (288°C)

Position the flask into the slot of the presser.



Spray with the provided Flexident mold release the inside and outside of the cylinder provided. It is important to take note that cylinder should always be allowed to warm up in between cycles, for at least 10 minutes before resin materials in tubes are placed inside the cylinder for melting.



Then spray a brass disc with the FLEXIDENT mold release spray provided, before inserting the disc into the cylinder against the end of the tube containing the resin materials. Let the resin material melt (plasticize) in the furnace, for approximately:

9 minutes for 8 to 9 grams (small-sized tubes),

11 minutes for 16 to 18 grams (medium-sized tubes),

15-16 minutes for 24 to 27 grams (large-sized tubes)



Then push lever forward to inject. After 1 to 2 minutes, pull lever back and remove the flask and cylinder from the presser.



Use the Knock-out Punch to release the Tube from the Cylinder

Open the Flask

Finishing

- Cut off the sprue with a cut-off disc
- Complete as much pre-finishing and over-all reduction of the palatal area and lingual connector while the case is still on the duplicate model
- Lift the case with a flat hand instrument
- Trim the edges of the case with a grinding wheel.
- Avoid overheating the resin material of the case during finishing
- Smooth case prior to polishing with the Smooth Gray or Red-flex (brown rubber) wheels



Once the sprue junction on the lingual and palatal surfaces is reduced, lift the case off the model with a knife or other flat instrument. Clean the tissue surface with a small stiff bristle brush.

Polishing

- Apply Tripoli compound with a dry rag wheel to produce a smooth but dull-looking finish
- Constantly wet the case with water to avoid excessive build-up of heat
- Remove the oil residue from the Tripoli compound with the B-20 brush
- Use the B-20 brush to remove accumulated debris in the interproximal areas
- Rinse the case before applying a polishing compound such as Kenda[®] with a dry rag wheel to produce a higher luster.
- Use a low speed lathe machine with a light touch and always move the case against the rag wheel, in only one direction.

Packaging the Flexident Case for the Patient

- Follow standard disinfecting procedures
- Place the case in the Flexident bag with water and seal

Special Instructions for Flexicryl[™]

- Keep tube dry at 122-140°F / 50-60°C at all times, or at least 1-2 hour prior to injection
- Place tube in the cylinder for 15-16 minutes at 550°F (288°C) to melt the materials
- Inject when flasks are still hot (*gloves are needed*)
- If necessary, the six anterior pontics may need a cold cure acrylic mask if too transparent
- Proceed with finishing and polishing, same as that of conventional acrylic. No special burs or instruments are needed.