

## 隐形义齿胶


### FlexSoft Partial Dentures





The alternative to conventional Partial Dentures ;  
Flexible . Soft. Easy-to-finish. Easy-to-polish  
弹性好, 易成型, 易抛亮, 美观大方。



编号 No.	规格 Spec.
D2	Crystal ; 18 gs
C1	Ligth Pink ; 9 gs
C2	Ligth Pink ; 18 gs
B1	Standard Pink ; 9 gs
B2	Standard Pink ; 18 gs
A1	Deep Pink ; 9 gs
A2	Deep Pink ; 18 gs
For bulk pak of 1 kilo.	
C3	Ligth Pink ; 1000 gs
B3	Standard Pink ; 1000 gs
A3	Deep Pink ; 1000 gs

 Crystal (D)  
(透明)

 Light pink (C)  
(浅粉红)

 Standard pink (B)  
(粉红)

 Deep pink (A)  
(深粉红)



### Instructions for Use

Suitable for: Partial and complete dentures, occlusal splints and nightguards.

Not Suitable for: Small unilateral restorations.

Warnings: Use eye protection and heat-resistant gloves when injecting.

Use proper ventilation, vacuum system and masks when grinding prosthodontic resins.

Precautions: Cartridge must be injected within 1 hour of opening the foil pouch.

#### I. PREPARING THE MASTER MODEL FOR DUPLICATION

All undercuts that will affect the path of insertion should be blocked-out with wax prior to duplication. Do not relieve necklines of teeth or areas desirable for retention. For free-end saddles, it is not necessary to remove the distal undercut of the last natural tooth, unless the area is too deep. For free-end saddle cases where anterior teeth are also being replaced, undercuts in the anterior should also be blocked out.

#### II. SET-UP

Duplicate blocked-out master model. Articulate the duplicate model and the master model (you will need the master model articulated at finishing steps to check occlusion). Set up the case on the duplicate model using only wax (no base plate).

Allow 1 mm of thickness under the teeth to flow to the labial side and into the retention diatorics in the teeth. Use a small round carbide bur to create mechanical retention in the teeth, from mesial to distal and connected to the center diatoric hole.

#### III. WAXING

Important: Wax the case with anatomical features to reduce grinding during the finishing stage.

Recommended thickness of wax-up:

1. Palatal thickness 1.2 - 1.5 mm
2. Buccal & Labial Flange 1.2 - 2.0 mm
3. Clasps 1.0 - 1.5 mm
4. Lingual Flange 1.2 - 2.0 mm
5. Lingual Major Connector (Mandibular) 1.7 - 2.0 mm

#### IV. INVESTING AND SPRUING

Invest the case in the center of the flask, aiming the posterior portion toward the sprue opening. After the stone (or plaster) has set, use two sprues from the flask opening to the most posterior portion of the wax on both sides (see diagram). Sprues should be approximately 7 mm. width. Do not create sharp angles with the sprues, as the heated resin must flow in a straight or slightly curved path. Apply a thin layer of petroleum jelly on the entire stone surface. Then invest top half of flask.

#### V. REMOVING WAX

After the stone has set, place flask in boiling water for 8 minutes. Open the flask and wash out the wax, making sure all wax residues are eliminated. Allow the flask to cool. Apply thin layers of separator on the entire surface of the stone and allow it to dry completely. Do not apply separator on teeth. When dry, close flask.

#### VI. INJECTING

Wear safety goggles and heat-protective gloves for this procedure.

Spray inside of the cartridge sleeve with mold release spray and place it into furnace. Turn on the furnace and allow it to reach approximately 550°F (290°C), preheating cartridge sleeve for approximately 15 minutes.

Remove cartridge from foil-lined bag (do not remove cartridge from bag until this step). Spray the cartridge and bronze disc with mold release spray. Insert the cartridge into the cartridge sleeve with the cap end first. Insert the bronze disc into the cartridge sleeve against the end of the cartridge. Use the thick bronze disc for medium tubes and the thin bronze disc for the large tubes. Heat cartridge for 12 minutes.

Position the flask with the sprue end up, directly under the shaft of the press. After 12 minutes, remove the cartridge sleeve from the furnace. Keep the cartridge sleeve in a horizontal position until resting on top of the flask, and then turn the cartridge sleeve into a vertical position. Immediately use the press to inject the heated cartridge into the flask using a steady fast motion. Continue applying pressure until tube bursts and continue with maximum downward pressure for 3 minutes.

Remove the cartridge sleeve from the flask with a slight twisting motion. After removing the cartridge sleeve, let the flask cool for at least 30 minutes. Do not put flask into a cold water bath. Use a plaster nipper to de-flask. Do not use a hammer. Remove the compressed cartridge from the cartridge sleeve with a knock-out punch. Important: Cartridge sleeve must be pre-heated for 10 minutes BEFORE the next injection.

#### VII. FINISHING AND POLISHING

Remove appliance from the model. Cut off the sprues with a cut-off wheel. Trim the edges of appliance with a coarse grinding wheel. Avoid overheating. Use rubber wheels to smooth scratches. Place the appliance on the articulated master model to check the fit, retention, thickness and occlusion. Clean the tissue surface with a small bristle brush.

To polish, use a coarse dental abrasive, such as pumice, with a wet rag wheel. Apply final shine with a hi-shine compound on low speed with a final buff wheel. Be careful not to overheat appliance.

## 铝桶

### Empty Aluminum Cartridge

编号 No.	规格 D x H, mm
25085	25 x 85 mm
25100	25 x 100 mm
25CAP	24.2 x 16 mm, Cap
22065	22 x 65 mm
22085	22 x 85 mm
22100	22 x 100 mm
22120	22 x 120 mm
22CAP	21.2 x 16 mm, Cap

