



Graphy TC-80DP Flexible Dentures Instructions

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Graphy

We like creating specialized materials.

"Smart Materials"

Graphy TC-80DP Flexible Dentures



*Appendix



Preparation



- Prepare the Flexible Denture Base, Denture Teeth and Model after the post-curing work has been completed.

(However, in the case of Flexible Denture Base, it is prepared only after the 1st post-curing in the TFDH post-processing manual.)

LED Light Curing Machine



Any kinds of LED Handy Light Curing Machine. : Graphy_CureM_U102H

Tools needed



Denture Bar



Flat Brush and Wax Instrument



Cotton Swab



Denture Pad

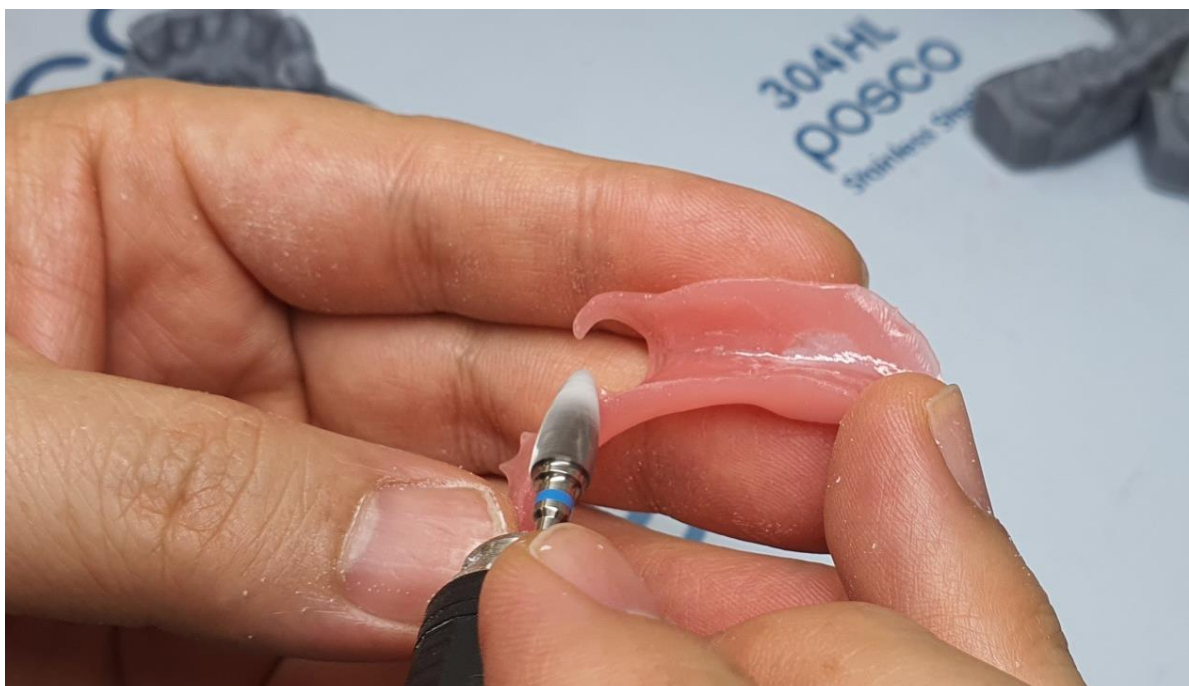


Glaze Resin



Resin Separator
(Vaseline)

Fitting Check and trimming the Flexible Denture Base



- Remove the support marks on the surface of the Flexible Denture Base using the denture bar.



- Check the fitting of the model and Flexible Denture Base, and remove unnecessary parts for accurate fit.



- After checking the fitting, smooth the outer surface of the Flexible Denture Base with the denture pad.



Wash the trimmed Flexible Denture Base with running water.

Glazing the Flexible Denture Base

(Please skip this page if you want to polish Flexible Denture polished finish.)



- Remove the remaining water after washing with swab...etc.



- Prepare the small amount of Flexible Denture Resin(TFDH).

(Please skip this page if you want to polish Flexible Denture polished finish.)



Apply the resin thinly to the outer surface of the Flexible

Denture Base.

Be careful not to let the resin flow into the inner surface of the Denture and the area where the teeth will be seated.



Place the stainless bowl with flexible denture in the middle on the rotation table in the CureM chamber. Post-curing for 20 minutes with Level 3 strength of CureM.

Denture teeth trimming and fitting check



Removes support marks on the surface of the teeth. : Check the fitting between flexible denture and teeth. : If necessary, remove the contact and basal surface area of the teeth.

Attaching and glazing the Denture Teeth.



Apply the thin layer of Vaseline to areas of the model that may be stained with resin.



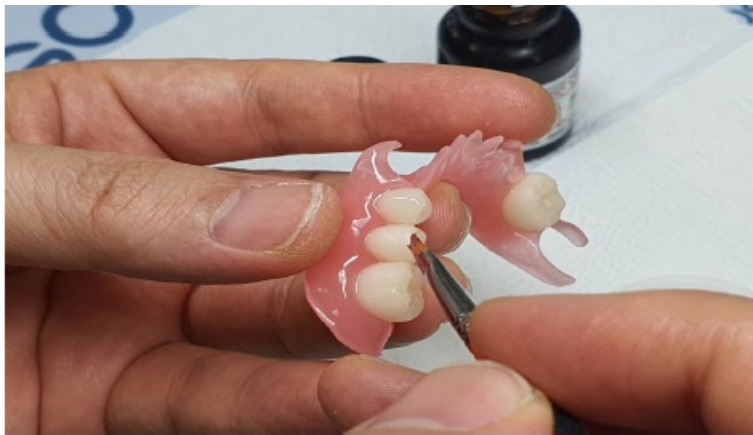
- Pour the Flexible Denture resin into the position where the teeth will be seated using a wax instrument.
- Pour in an appropriate amount of resin so that it overflows slightly when the teeth is seated.



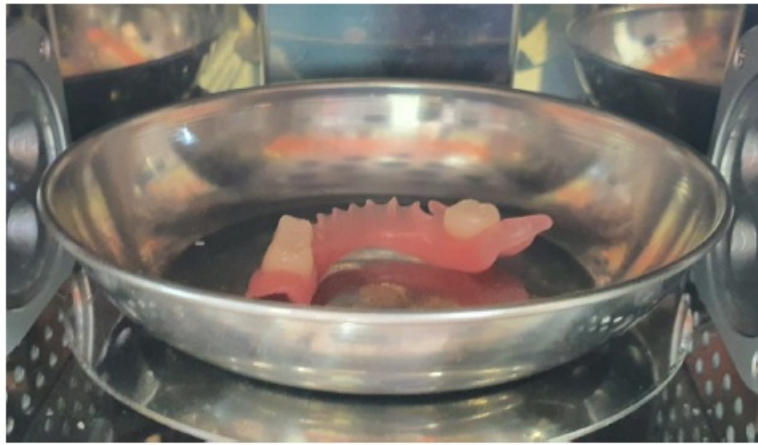
- Wipe off the spilled resin with cotton swab.



- Put LED light 10 to 15 seconds to each tooth.
(Please skip this page if you want to polish Flexible Denture polished finish.)



- Apply Glaze Resin thinly on the surface of the attached teeth using brush.
- Glaze Resin such as GC and Kulzer are recommended



- After applying the glaze resin, put the Flexible Denture into the CureM. And curing it with Level3 for 1 minute

Finalize



- After glazing the teeth, the production of flexible denture is completed.

*Appendix

1. Polishing

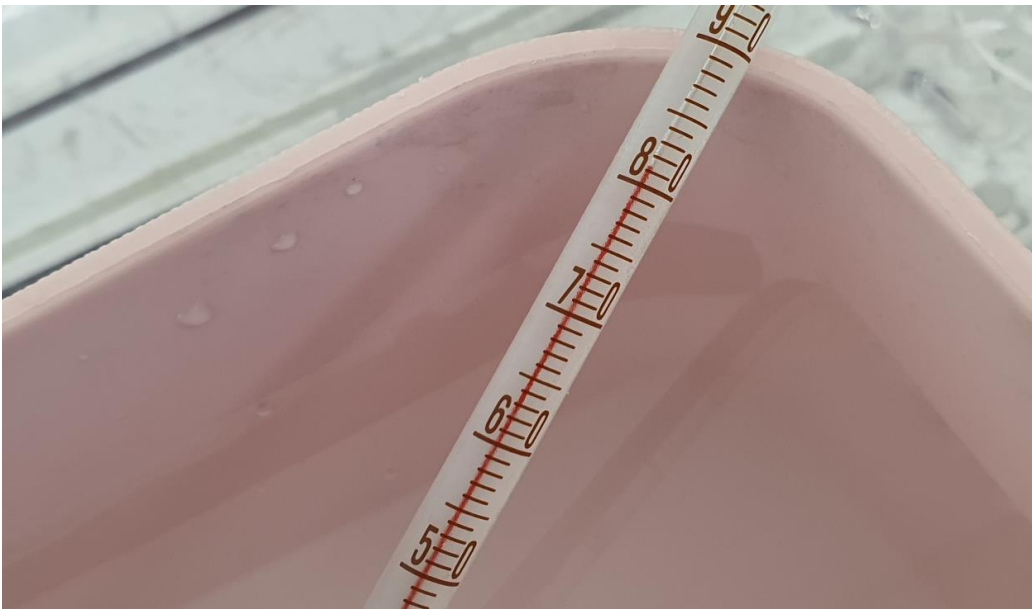


- Similar to the existing flexible denture, abrasive polishing using pumice and rouge is also possible.

2. Solution for Clasp fitting issue.



- If clasp deformation is found during the manufacturing process such as photo-curing, it can be solved in the following way.



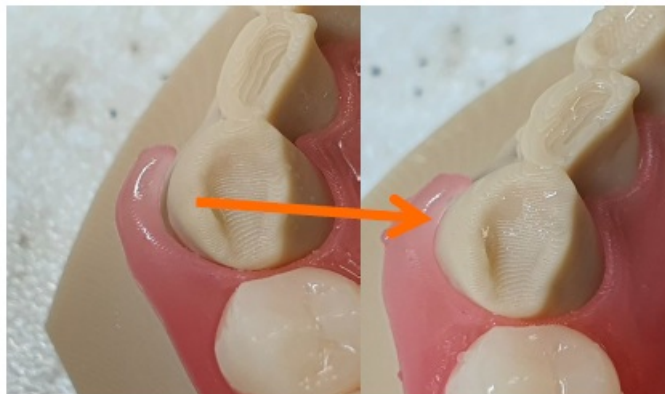
- Prepare over 80 degrees Celsius hot water.



- Soak the Flexible Denture seated on the model in hot water for 1 minute.




- Take out the Flexible Denture and model from hot water and gently press the deformed area with your hands.
- Put it in cool running water until the flexible denture and



- Clasp fitting issue can be solved as above

Documents / Resources

<div data-bbox="172 105 240 136">Graphy</div> <div data-bbox="181 136 231 143"><small>3D Printing Technology</small></div> <div data-bbox="132 150 284 165">Instructions for Flexible Dentures</div> <div data-bbox="164 165 252 176"><small>(with: TC-80DP, TC-80DP S-100M)</small></div> <div data-bbox="252 176 284 183"><small>Graphy 2020-01-01</small></div> <div data-bbox="127 203 288 315"></div> <div data-bbox="199 315 215 324"><small>01/22</small></div>	<div data-bbox="317 172 979 241">Graphy TC-80DP Flexible Dentures [pdf] Instructions TC-80DP, S-100M, Flexible Dentures</div>
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