

Graphy

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Instructions for Flexible Dentures

(with TFDH, TC-80DP, S-100M)

Rev.01(2021-06-30)



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1. 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

1. Preparation

: Tools needed



Denture Bar



Flat Brush and Wax Instrument



Cotton Swab



Denture Pad

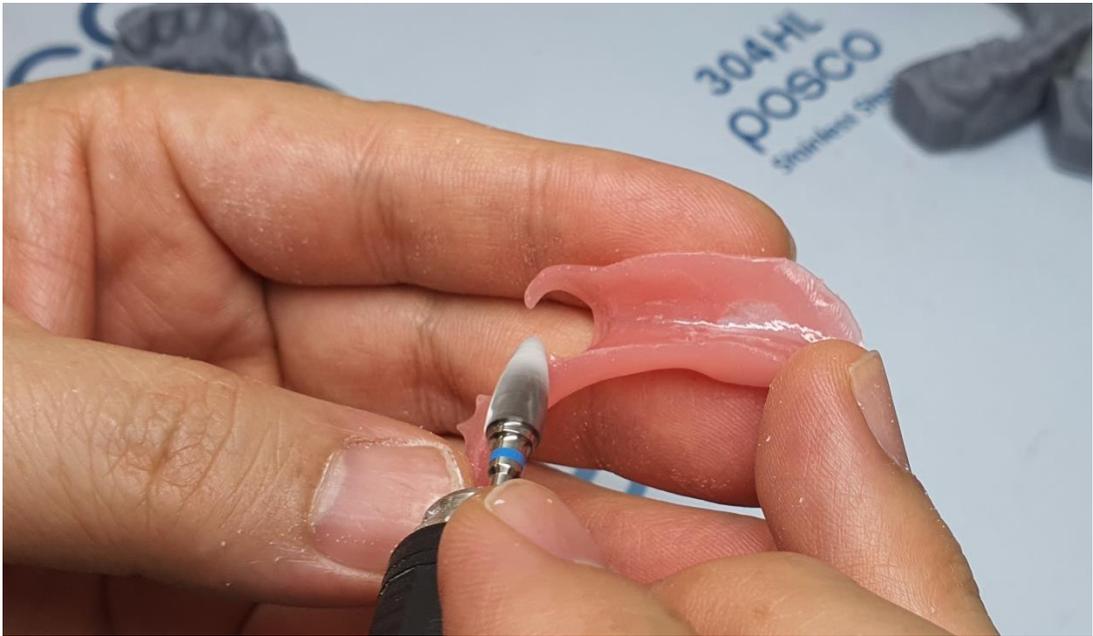


Glaze Resin



Resin Separator
(Vaseline)

2. 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.

2. Fitting Check and trimming the Flexible Denture Base



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



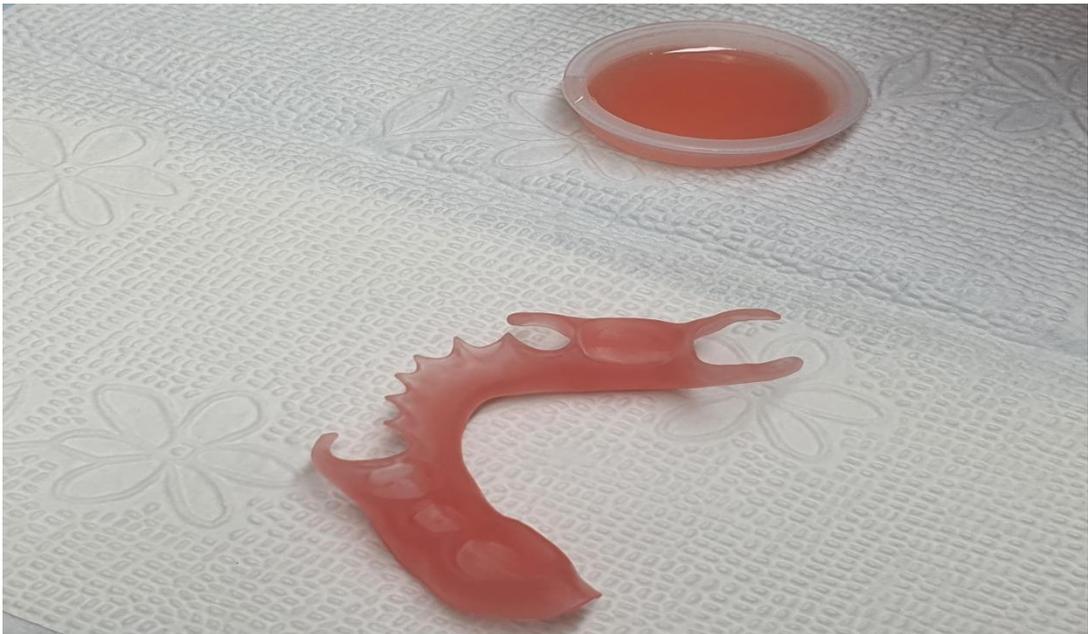
: Wash the trimmed Flexible Denture Base with running water.

3. 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).

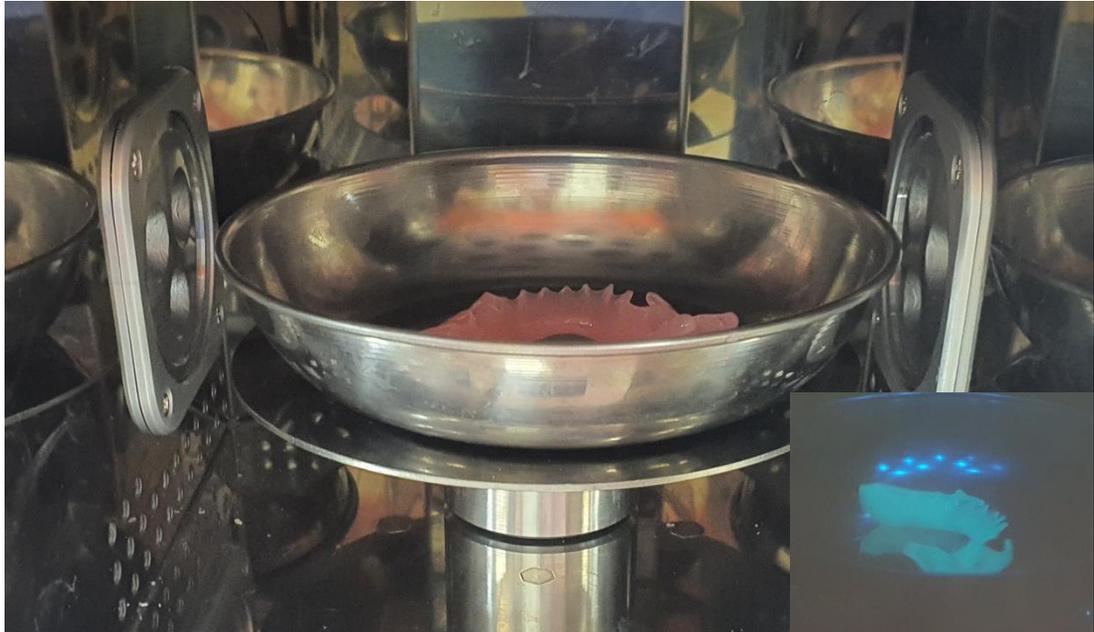
3. Glazing the Flexible Denture Base

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



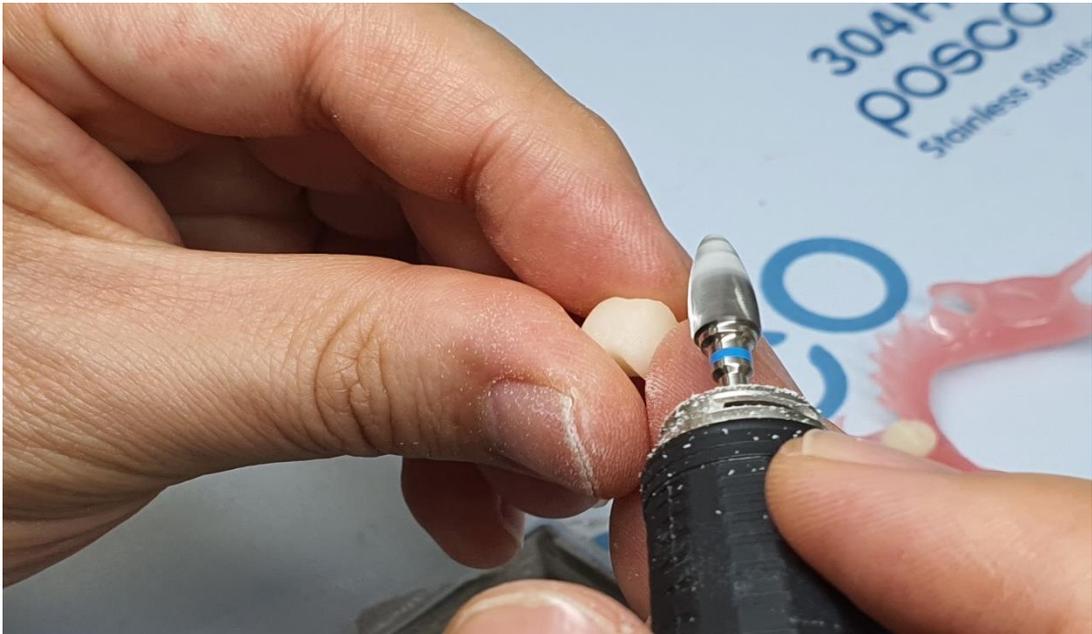
- : Apply the resin thinly to the outer surface of the Flexible Denture Base.
- : Be careful not to let the resin flow into the inner surface of the Denture and the area where the teeth will be seated.

3. Glazing the Flexible Denture Base



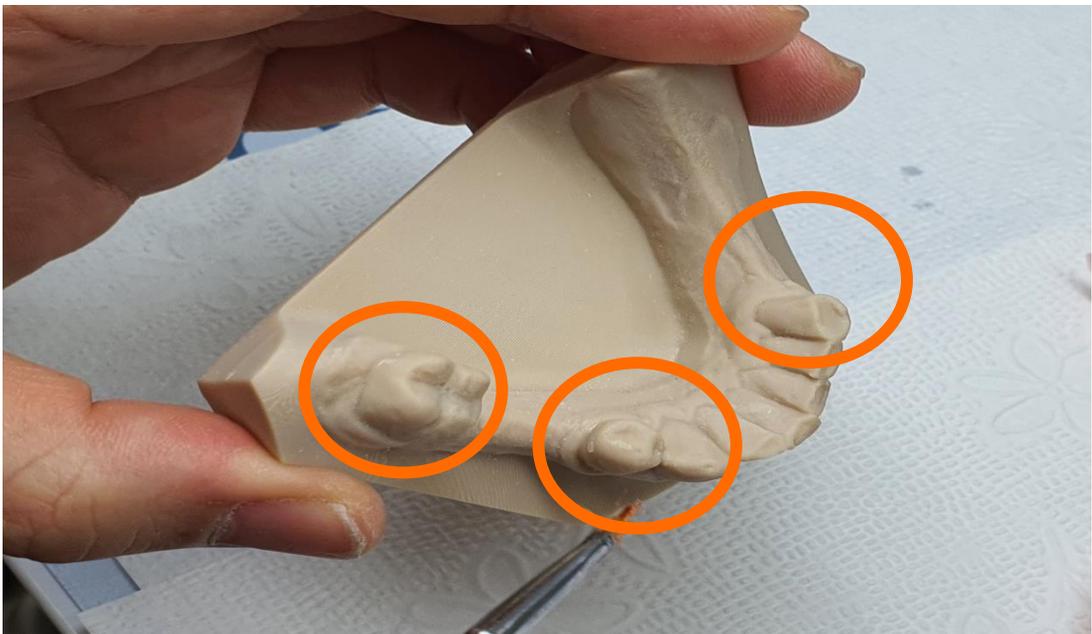
- : Place the stainless bowl with flexible denture in the middle on the rotation table in the CureM chamber.
- : Post-curing for 20 minutes with Level 3 strength of CureM.

4. 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.

5. Attaching and glazing the Denture Teeth.



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

5. Attaching and glazing the Denture Teeth.

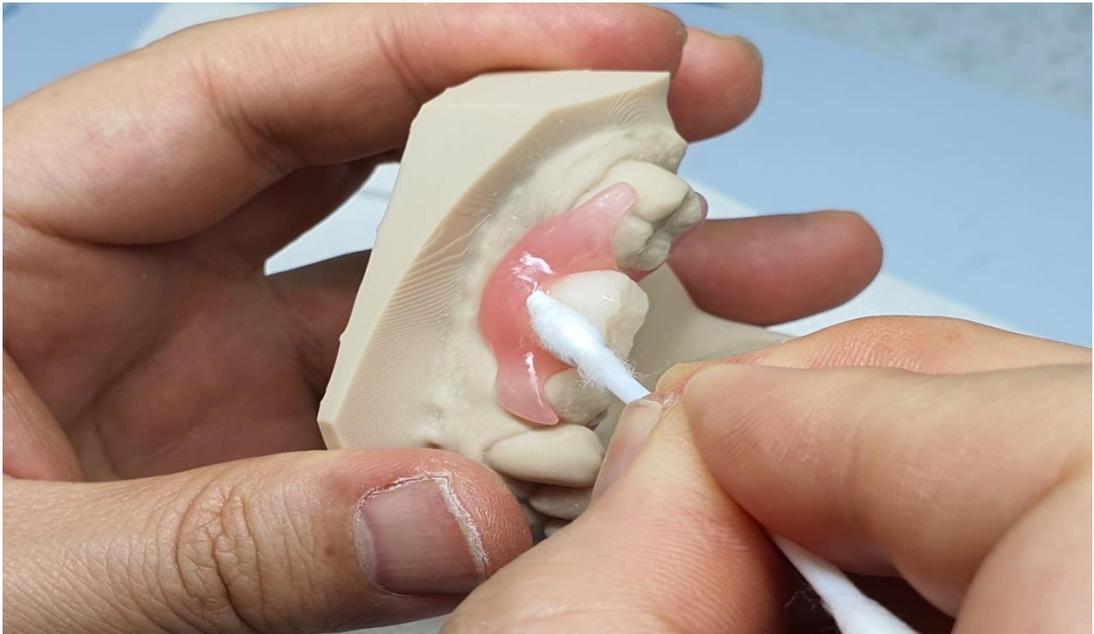


- : Pour the Flexible Denture resin into the position where the teeth will be seated using a wax instrument.
- : Pour in an appropriate amount of resin so that it overflows slightly when the teeth is seated.



- : Put the teeth in the correct position.

5. Attaching and glazing the Denture Teeth.



: Wipe off the spilled resin with cotton swab.

5. Attaching and glazing the Denture Teeth.



: Put LED light 10 to 15 seconds to each tooth.

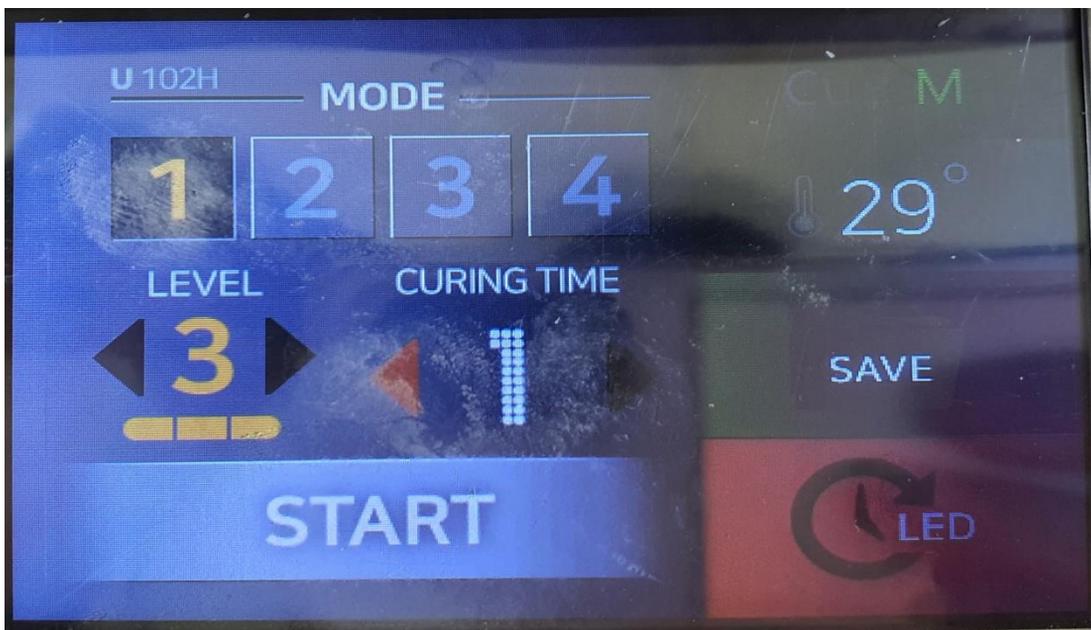
5. Attaching and glazing the Denture Teeth.

(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.

5. Attaching and glazing the Denture Teeth.



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

6. 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.

*Appendix

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.

*Appendix

2. Solution for Clasp fitting issue.



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

*Appendix

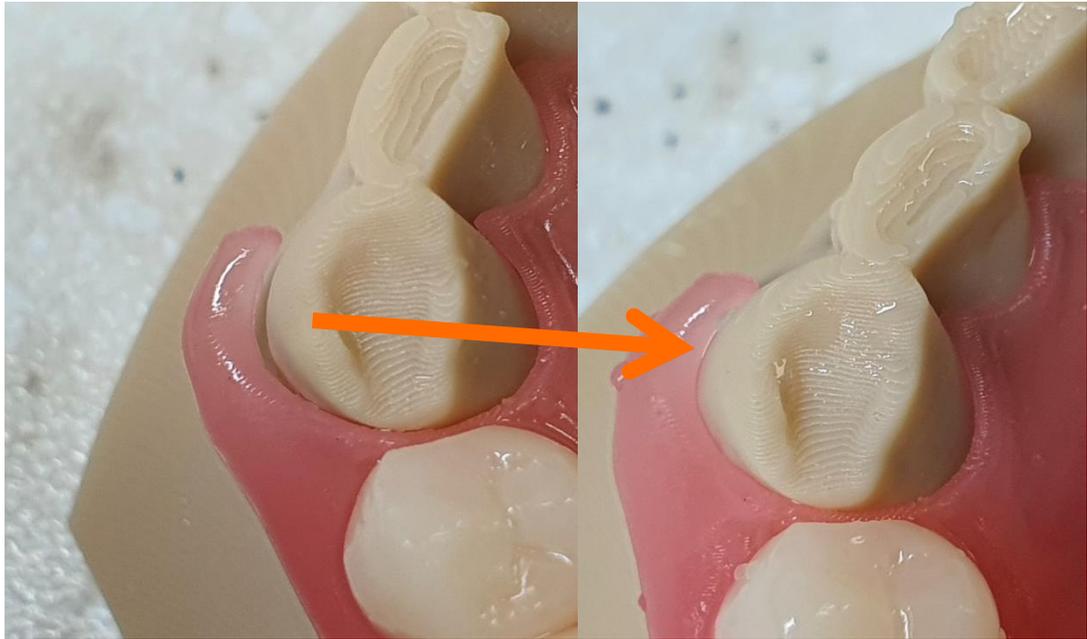
2. Solution for Clasp fitting issue.



- : 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 model became cool.

*Appendix

2. Solution for Clasp fitting issue.



: Clasp fitting issue can be solved as above