

Guideline

Ivotion® Base Print
on SprintRay Pro 2



This guideline describes the validated application of Ivotion Base Print on the SprintRay Pro 2.



SPRINTRAY PRO 2

Software

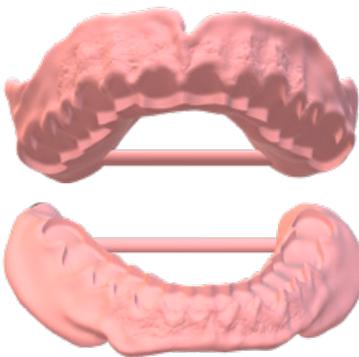


CAD Design

Use Ivoclar material libraries in exocad or 3Shape in which the material-specific design parameters are stored.

When using an alternative CAD, the following setting parameters are recommended for the STL file of the maxillary and mandibular:

Denture Base Thickness (Gingival)	2 mm
Denture Base Minimum Thickness	0.5 mm
Denture Base Minimum Thickness Cervical	0.7 mm
Denture Base Thickness under Teeth	0.8 mm
Denture Tooth Pocket Gap	0.2 mm

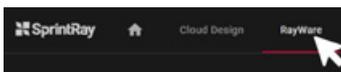


To ensure a higher standard of precision, the construction of at least one "stability bar" on the denture bases in the CAD is recommended. These remains in place until the bonding process and is removed in the final step of finishing.



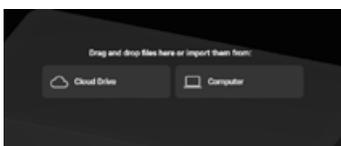
RayWare Software

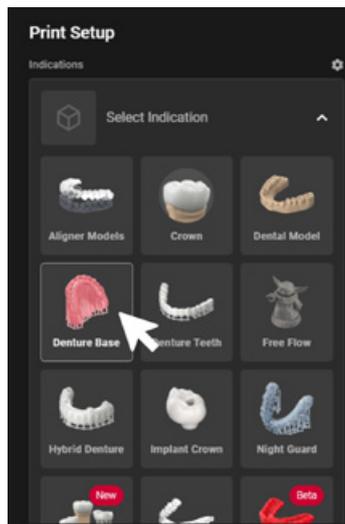
Open the SprintRay RayWare Cloud Software.



Files

Import STL File / Patient Case.





Indication

Select Indication Denture Base.



Orientation

Choose Automatic Orientation.



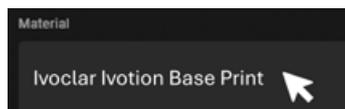
Printer Selection

Select Printer Pro 2



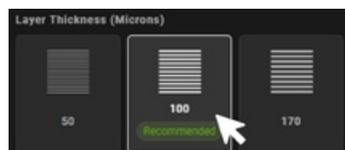
Build Platform

Choose Build Platform – Standard



Material

Select the material 'Ivotion Base Print' in the material library of the SprintRay RayWare Cloud software.



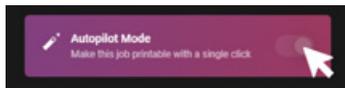
Layer Thickness

Select a layer thickness of 100 µm.



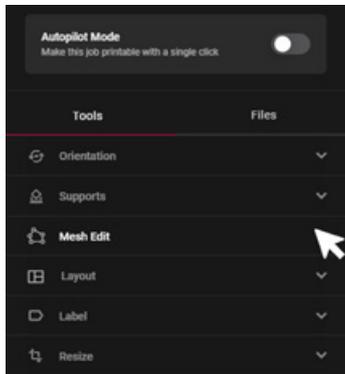
Prepare Print

Prepare Print.



Recommended Manual Adjustments

Manual settings are recommended for generating additional stability bars. Disable the autopilot mode for this purpose.



Select Mesh Edit.



Adding additional posterior stability bars.



Print
Send to printer

Hardware



Material preparation and printing process

Shake the material in the bottle for 2 minutes.

Use a fresh Pro 2 Resin Tank. Fill the tray to the maximum filling level mark.

Stir the resin before each build job using the silicone spatula supplied with the printer.



Pro 2

Pro 2

Print the objects.

Allow uncured material to drip off in the printer with the lid closed after printing is complete.



Wash

Washing should occur immediately after the last step to maintain optimum material properties. Clean the objects in the ProWash/Dry or ProWash S. Use isopropanol ($\geq 99\%$) for Reservoir I and II.

The objects can be cleaned on the building platform. For better cleaning performance, separate the objects from the building platform before cleaning using the basket supplied with the SprintRay cleaning devices.



ProWash/Dry

ProWash/Dry and ProWash S

Select 'Wash Profile' in the settings of the device and create a Custom Cycle 'Multi Cycle Wash':

Reservoir I	Reservoir II	Dry Mode
5 min	5 min	3 min



ProWash S

In the case of visible resin adhesions, also rinse with fresh isopropanol using a spray bottle.

After cleaning, dry the objects thoroughly with oil-free compressed air.



Cure

Pro Cure 2

The objects are post-cured in the ProCure 2 light-curing unit using the Ivoclar Ivotion Base Print Curing Profile.



ProCure 2

Finishing

Finish the dentures according to the Ivotion Base Print IFU.



Manufacturer
Ivoclar Vivadent AG
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