

Notice

For details, please refer to the Ivotion® Base Print from Ivoclar, SprintRay Apex Teeth and/or SprintRay EU Temporary Crown & Teeth instructions for use.

Preparing the printed objects



Once the printed objects have been successfully cleaned and post-cured, they may be removed from the build platform. If necessary, use the supplied auxiliary tools.

Check the fit of the teeth in the denture base. If there are interferences, adjust the tooth arch by using crosscut or diamond-coated tungsten carbide burs.

Notice

For bonding the printed tooth arch from SprintRay Apex Teeth or SprintRay EU Temporary Crown & Teeth to the Ivotion Base Print denture base from Ivoclar, use the appropriate bonding system Ivotion Bond from Ivoclar. For details, please refer to the Ivotion Bond instructions for use.

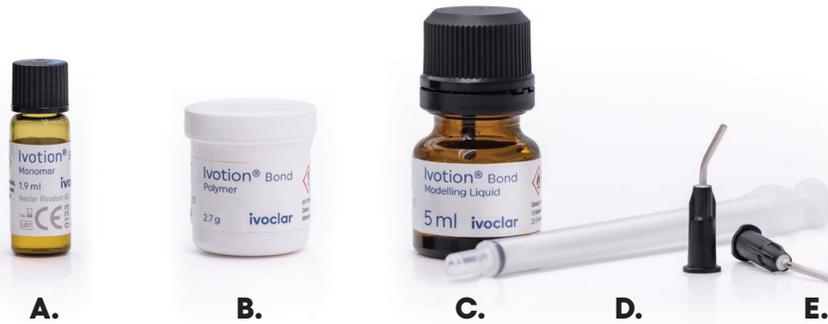
Preparing the bonding surface

1. Roughen the bonding surface. Use Al_2O_3 (80–100 μm) and 1–2 bar pressure.
2. Clean with oil-free compressed air.
3. Wet with denture base monomer, e.g. ProBase Cold Monomer.

Notice

The predosed bonding agent is sufficient for a complete (max. 14 teeth) maxillary or mandibular denture. Observe the processing parameters in table 1.

Bonding the teeth to the denture base



1. Pour the entire monomer (A) into the polymer container (B).
2. Mix according to table 1. Use a spatula.
3. Dip the application syringe (D) into the mixed bonding agent.
4. Draw up the application syringe (D).
5. Apply the bonding agent to the tooth cavities starting with one side.
6. Position the teeth correctly. Ensure exact fit to avoid interfering contacts.
7. Optional: Add additional bonding agent. Use the cannula (E).
8. Remove excess material. Use a brush and the modelling liquid (C).
9. Polymerize according to Table 1.

Mixing Time	Processing Time at 23° C	Polymerisation in Pressure pot
10 – 20 sec	8 – 10 min	2 – 5 bar for 15 min at 50° C

Table 1

Finishing

Any remaining residues of the support structures should be removed using cross-cut tungsten carbide burs. These burs can also be used for making shape adjustments. When finishing the objects, pay particular attention to the margins of tooth cavities, interdental spaces and basal surfaces. Make sure to wear protective goggles during finishing.

Please note that the improper use of grinding tools, polishing brushes and steam jets can lead to overheating of the object, which may result in damage to the material.

Polishing

Polish the object in the usual manner using customary brushes and polishing agents suitable for denture base materials. As a result of the additive manufacturing process, layer lines can form in some areas of the denture. These layer lines can be removed by polishing.

After polishing, clean the object under running water using a brush or with a steam cleaner or in an ultrasonic bath.