Instructions for Use

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

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

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

I. PREPARING THE MASTER MODEL FOR DUPLICATION

1. Allow the master model to cool under water for 12 hours. Do not use a hammer. Carefully remove the soft wax from the model.
2. Create a void in the wax up to the level of the undercut. Use a surgical blade to clean the model and remove the undercuts.
3. Use a dental bur to remove the undercut in the wax. Do not create sharp angles with the burrs.

II. SET-UP

1. Position the flask with the sprue end up, directly under the shaft of the press. After 12 minutes, remove the sprue end. Use the thick bronze disc for medium tubes and the thin bronze disc for the large tubes.
2. Insert the sprue into the wax and connect it to the center diatoric hole. Preheat the cartridge sleeve in a furnace for approximately 15 minutes.

III. WAXING

1. Insert the stone (or plaster) into the flask opening. After the stone has set, use two sprues from the flask opening to the most posterior portion of the wax on both sides. Use a small round carbide bur to create mechanical retention in the teeth, from mesial to distal and connected to the center diatoric hole.
2. Use a medium grit fine-grit abrasive, such as pumice, with a wet rag wheel. Avoid overheating.
3. 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 the appliance.

IV. INVESTING AND SPRUING

1. Position the 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 completely.
2. Apply thin layers of separator on the entire surface of the stone and allow it to dry. Do not apply separator on teeth. When dry, close flask.

V. REMOVING WAX

1. 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 completely.
2. 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

1. Wear safety goggles and heat-protective gloves for this procedure.
2. Spray inside of the cartridge sleeve with mold release spray and place it into furnace.
3. Turn on the furnace and allow it to reach approximately 550°F (290°C). Preheat cartridge sleeve for approximately 15 minutes.
4. Remove cartridge from the 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.
5. Use the thick bronze disc for medium tubes and the thin bronze disc for the large tubes. Heat cartridge for 12 minutes.
6. Position the flask with the sprue end up, directly under the shaft of the press. After 12 minutes, remove the sprue end. Insert the bronze disc into the cartridge sleeve. 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 steady motion. Continue applying pressure until tube bursts and continue with maximum downward pressure for 3 minutes.
7. 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 the flask into a cold water bath. Use a plastic cap to de-flask. Do not use a hammer.
8. 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

1. Remove appliance from the mold. 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 brush.
2. 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 the appliance.
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