



**detax**

Materials  
that matter

# DETAX Processing Manual

FREEPRINT<sup>®</sup> crown  
&  
FREEPRINT<sup>®</sup> denture flex

Bonding the printed denture teeth to the printed denture flex base.

# Presentation content

1. Overview
2. Prepare crown / bridge
3. Check the fitting of denture flex base and crown / bridge
4. Bonding of denture flex base and crown / bridge
  - Bonding material
  - Process (step by step)
5. 3D Printing materials
6. Accessories

# 1) Presentation Overview

Follow the IFU instructions for washing the denture flex base and denture teeth with IPA.

## ATTENTION

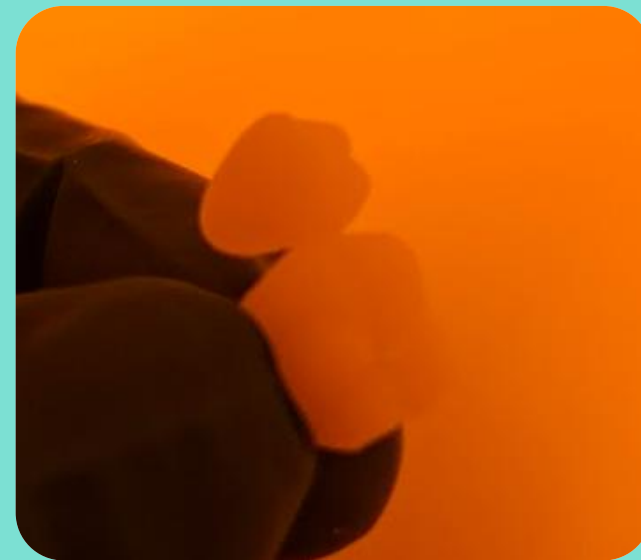
After washing, don't post-expose the uncured components.

Wear personal protective equipment when handling the uncured material.



## 2) Prepare crown / bridge

Remove the supports from printed part carefully



3) Check the fitting of denture flex base and crown / bridge

**dx**



# 4) Bonding of denture flex base and crown / bridge dx

- Bonding material

FREEPRINT® denture flex resin is used for bonding the denture teeth.

Make sure that you use the same color which you used for printing.

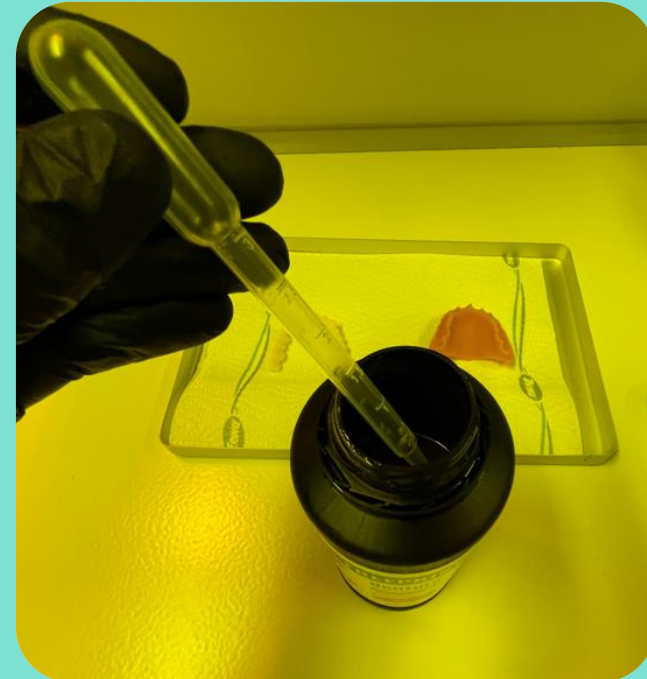


# 4) Bonding of denture flex base and crown / bridge dx

- Process Step 1

Application with an application syringe

- DETAX recommend an application syringe for the application of the FREEPRINT® denture flex material.
- To remove the FREEPRINT® denture resin from the bottle, DETAX recommend a pipette.

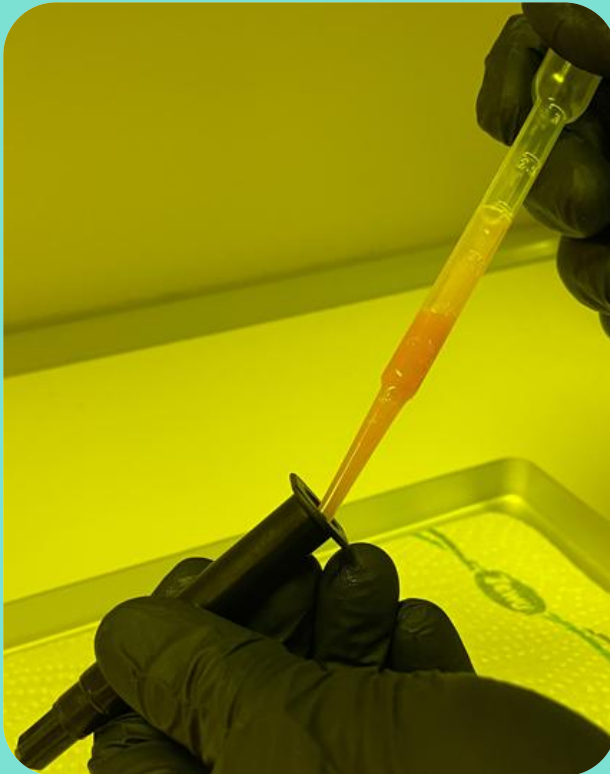


# 4) Bonding of denture flex base and crown / bridge dx

- Process Step 2

Application with an application syringe

- Fill the application syringe carefully.
- After filling the syringe, remove the cap carefully.

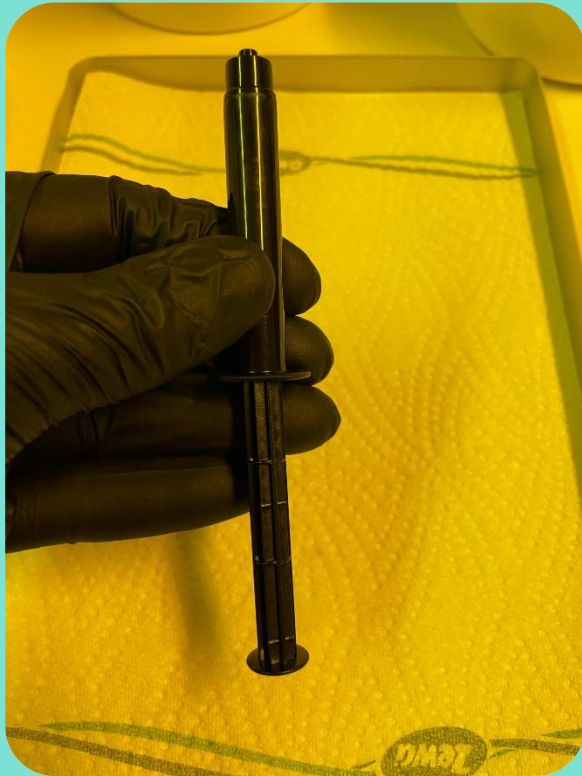


# 4) Bonding of denture flex base and crown / bridge dx

- Process Step 3

Application with an application syringe

- Press the piston carefully and slowly into the syringe.
- Until a small amount of material comes out of the opening.

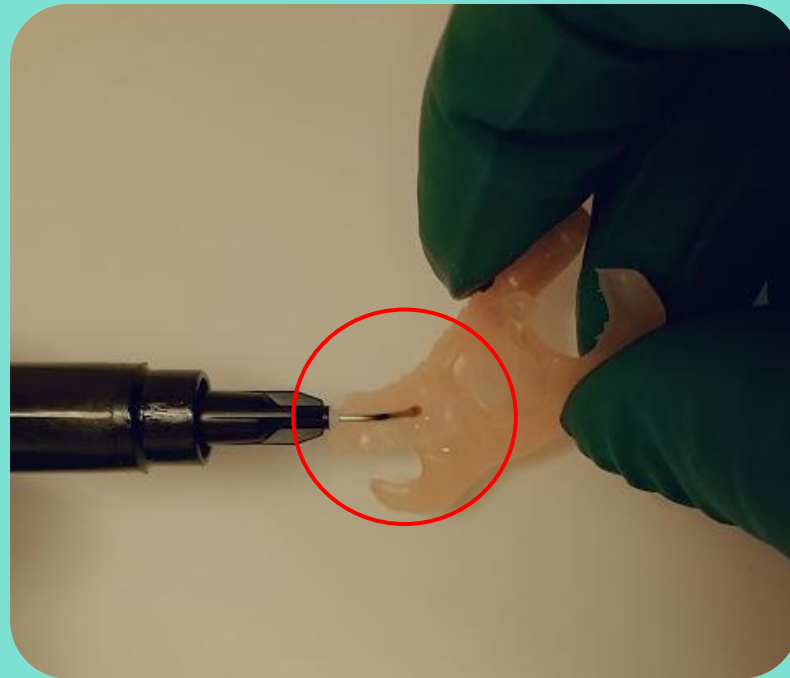


# 4) Bonding of denture flex base and crown / bridge dx

- Process Step 4

Application with an application syringe

- Place the application needle on the syringe.
- Apply the FREEPRINT® denture flex material with the syringe into the cavities with slight pressure.

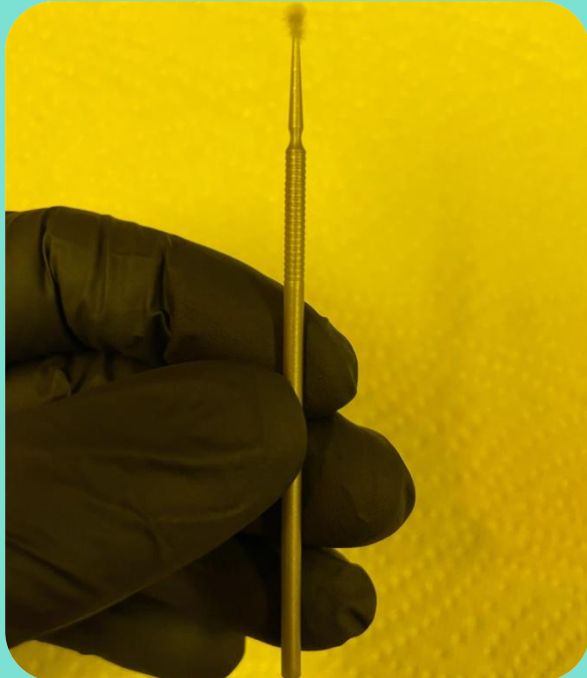


# 4) Bonding of denture flex base and crown / bridge dx

- Process Step 5

Application with an application syringe

- Using a brush to remove the excess material on the cervix of the teeth.



# 4) Bonding of denture flex base and crown / bridge dx

- Process Step 6
  - For pre-curing, the denture (flex base and teeth) is cured with 400 flashes (Otoflash G171 N2) with nitrogen.
  - Make sure you use the correct tray (UV360).



# 4) Bonding of denture flex base and crown / bridge dx

- Process Step 7

Application with an application syringe

- If material needs to be applied again, you can apply it now before the final curing.
- After final use, please close the syringe with the cap.

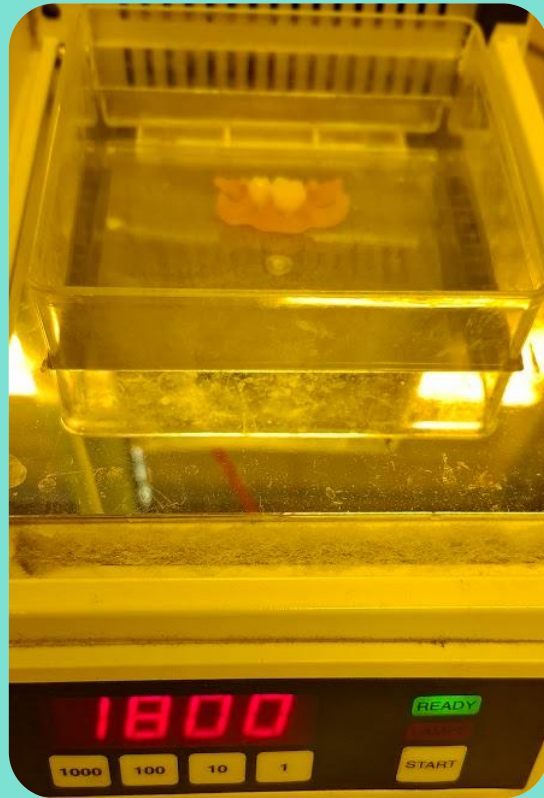


# 4) Bonding of denture flex base and crown / bridge dx

- Process Step 8

For final curing, the denture (flex base and teeth) is cured with 2 x 1800 flashes (Otoflash G171 N2) with nitrogen.

Between the 2 curing cycles, please turn the denture flex around.



# 4) Bonding of denture flex base and crown / bridge dx

- Process Finish

Finishing after light curing



## Interdental fine finishing

- If necessary, the excess FREEPRINT® denture flex resin can be grinded off in the interdental area using a diamond disc or a separating disc.

## Grinding in the occlusion

- Place the denture on the model and check the centric, protrusion, retral movements and sideshift in the articulator - the occlusion is successively grinding according to the grinding rules.

## Polish

- Smoothing the surface of the denture before polishing can be done classically with sandpaper strips.
- The polishing of the denture is done at the polishing unit from coarse to fine: 1. brush/pumice, 2. brush/polish and 3. buff/polish.

## Cleaning

- Clean the denture in the cleaning liquid in the ultrasonic unit for max. 1 min.
- It is possible to use a toothbrush and a steam jet for cleaning

# 5) 3D Printing materials

FREEPRINT® crown



FREEPRINT® denture flex



- FREEPRINT® crown A1 500 g 02372 1.000 g 02376
- FREEPRINT® crown A2 500 g 02378 1.000 g 02415
- FREEPRINT® crown A3 500 g 02417 1.000 g 02446
- FREEPRINT® crown B1 500 g 02481 1.000 g 02519
- FREEPRINT® crown B3 500 g 02645 1.000 g 02758
- FREEPRINT® crown C2 500 g 02766 1.000 g 02782
- FREEPRINT® crown D3 500 g 02783 1.000 g 02825
- FREEPRINT® crown BL 500 g 02845 1.000 g 02884

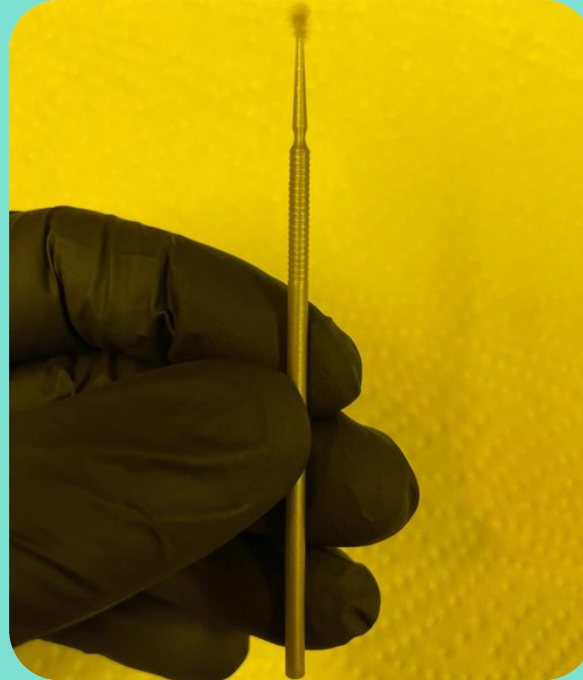
- FREEPRINT® denture flex pink-transparent 1.000 g 02040
- FREEPRINT® denture flex clear 1.000 g 04092

# 6) Accessories

- Application syringe



- Smartbrush, silver 100 pcs. 02715



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Thank you for your attention

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