

# Graphy

*We like creating specialized materials.*

*"Smart Materials"*

## Post Process Manual for TFDH

(Flexible Denture Resin)

Rev.01(2021-06-30)

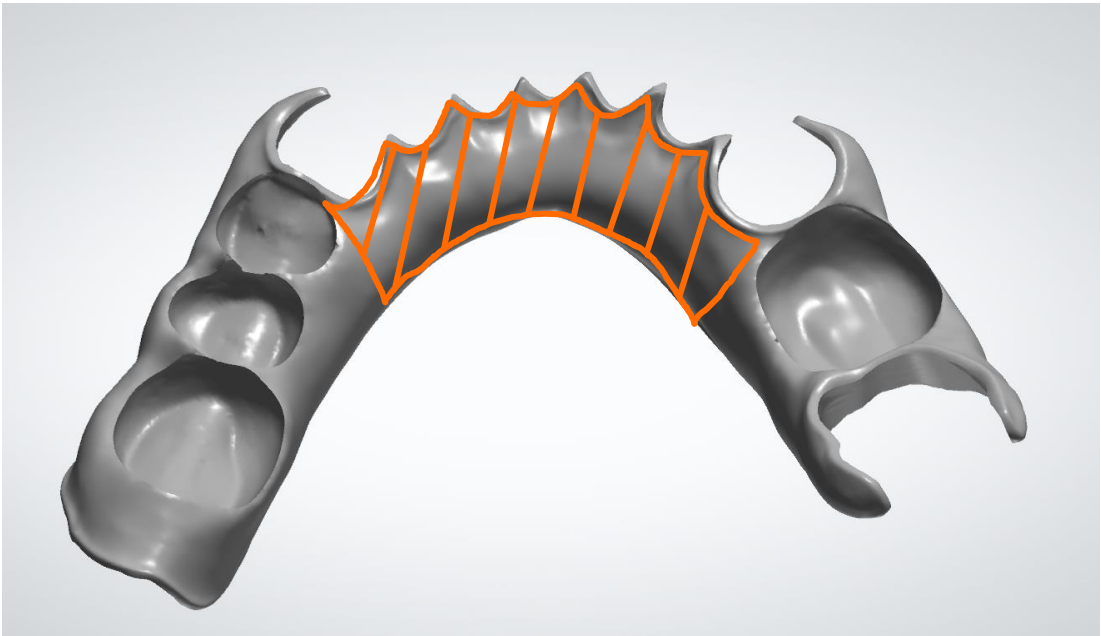
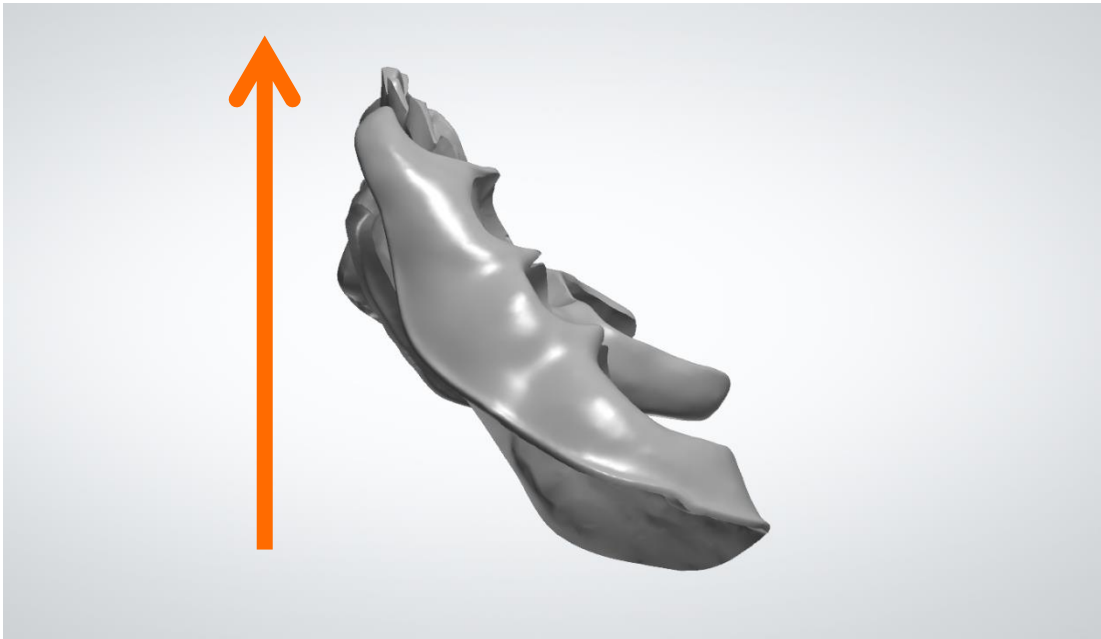


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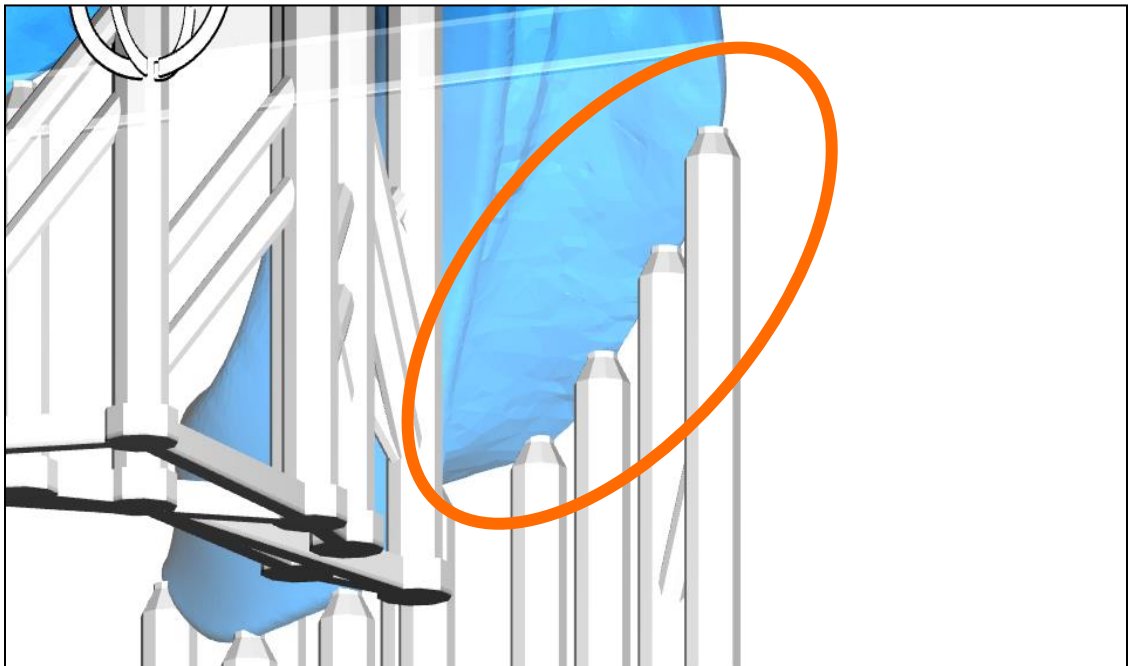
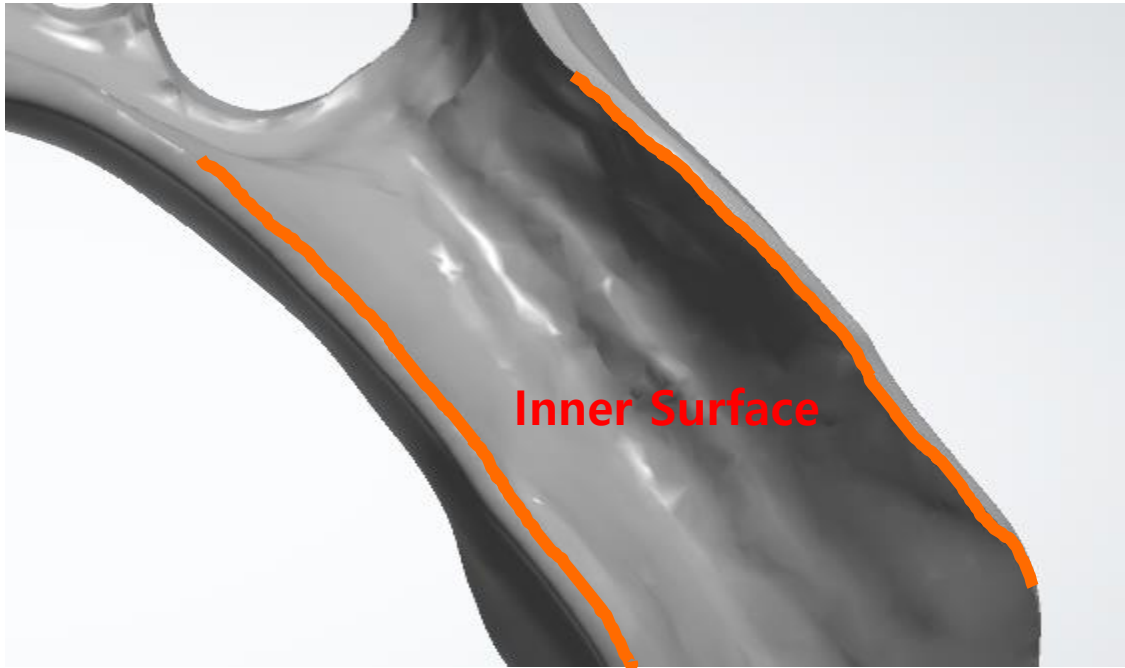


# 1. Precautions for setting support



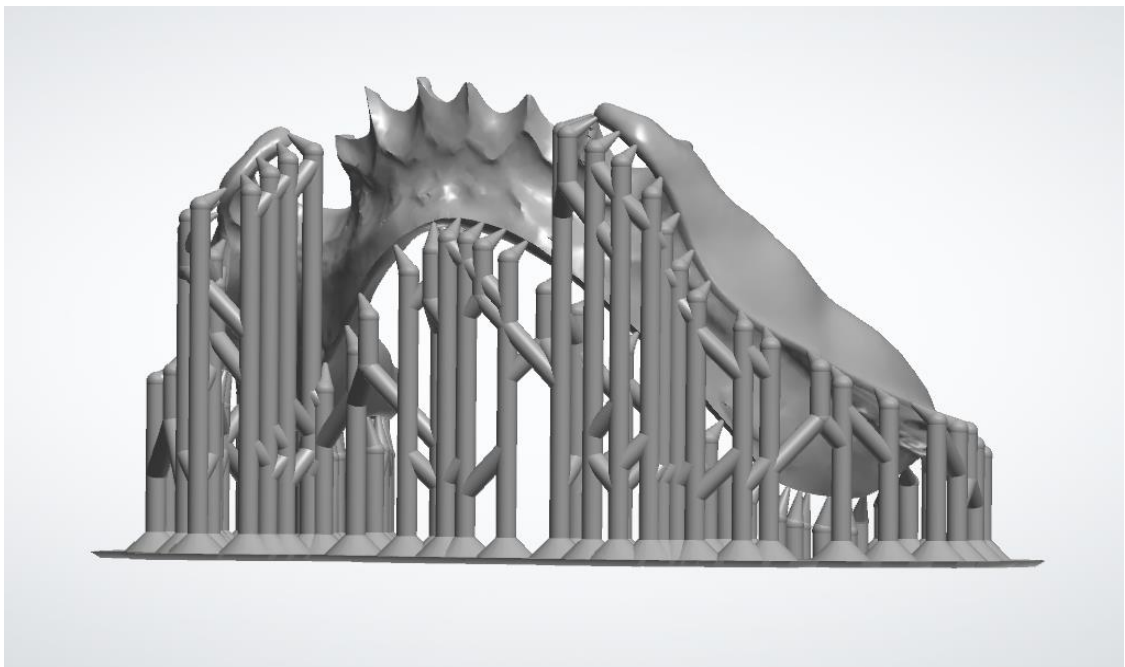
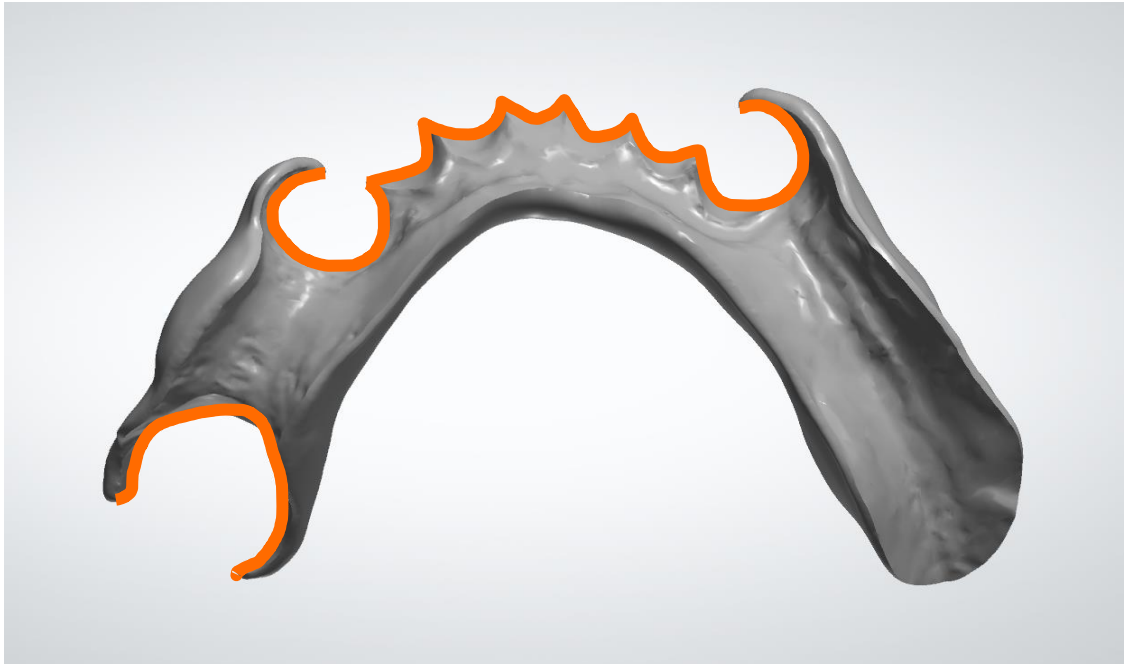
:Position the Flexible Denture Lingual Strap so that it is vertical.

# 1. Precautions for setting support



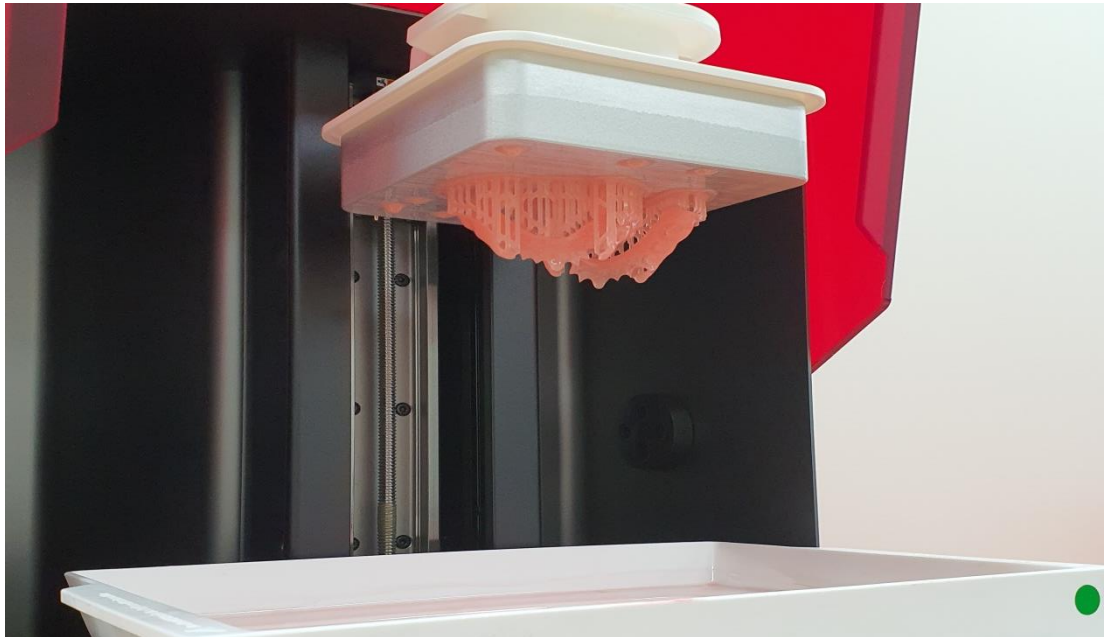
: Do not form support on the inner surface of Flexible Denture.

# 1. Precautions for setting support



: Form the support near the border area. But do not put the support the area that may affect fitting.

## 2. Printing



: Detach the printed Flexible Denture Base from the build plate of the 3D Printer with tool like the picture above.

### 3. Washing and support removal



- : Wash off the residual resin on the surface of the Flexible Denture Base using IPA(alcohol 99%) and ultrasonic cleaner.
- : Washing time should be around 30 seconds.

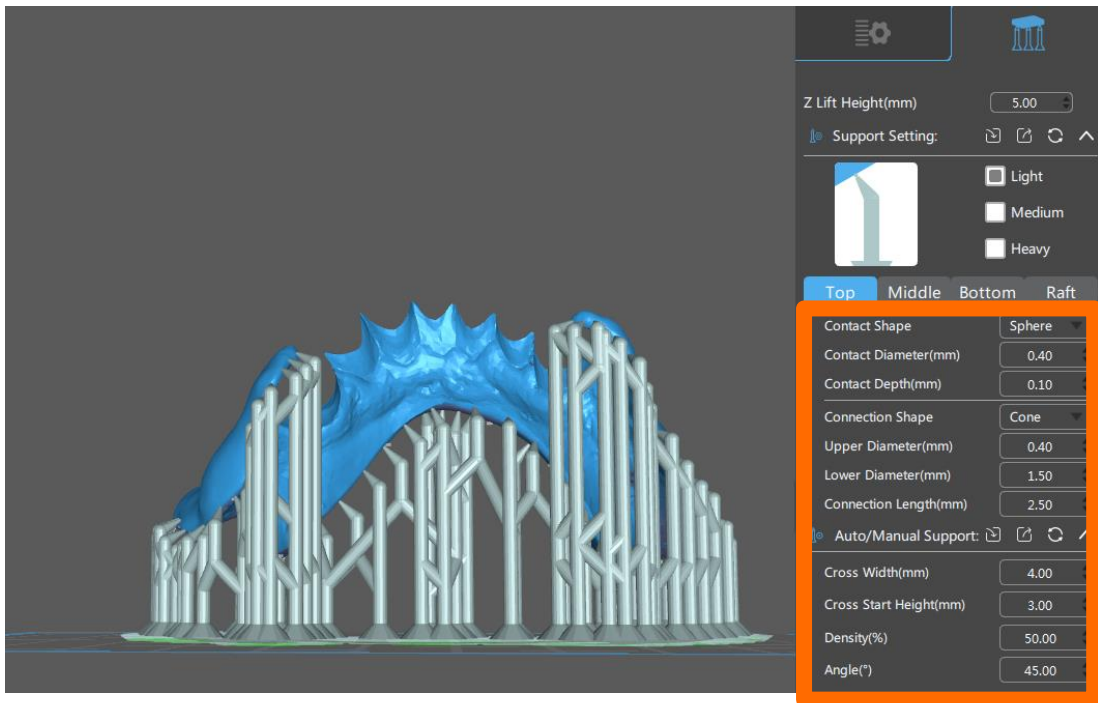


- : Blow out the IPA on the surface using an air gun.

### 3. Washing and support removal



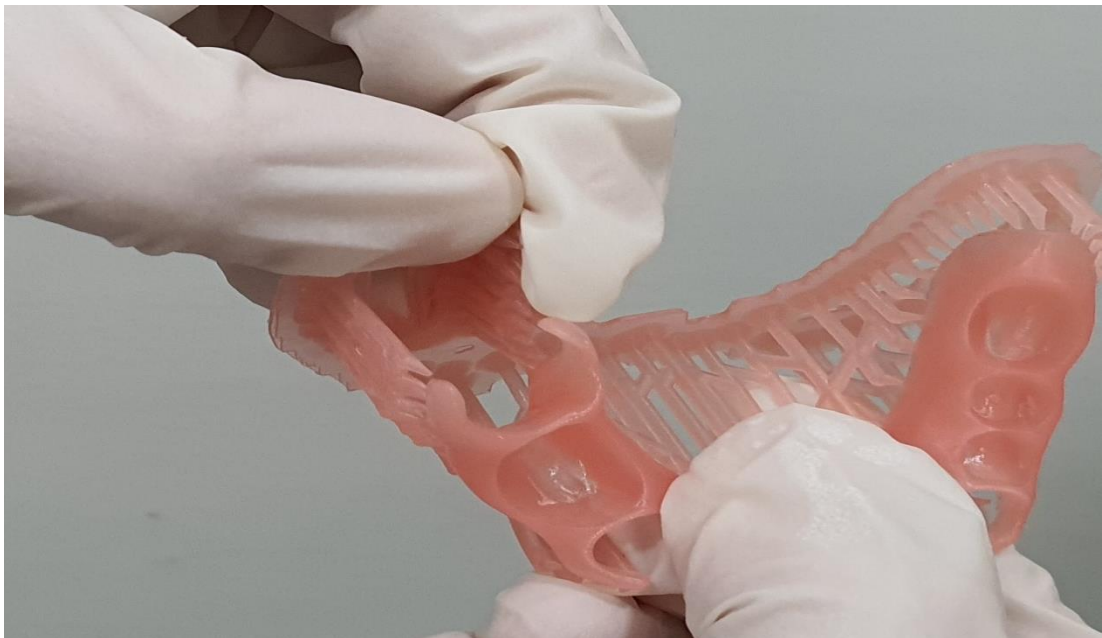
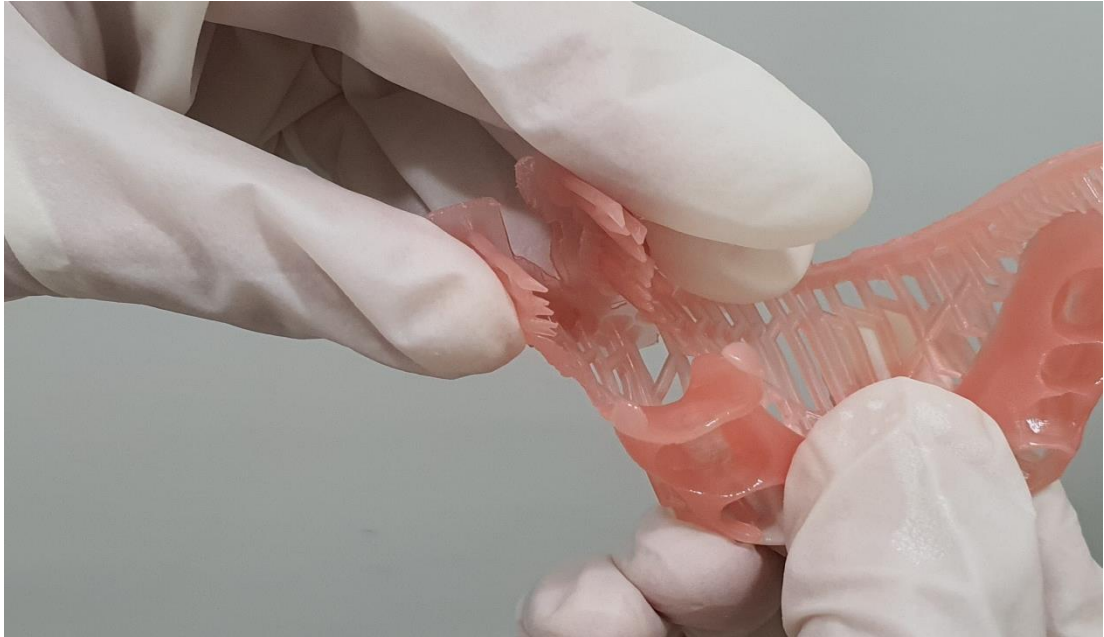
: If the support is generated by the SW which can not control the contact point size between support and flexible denture, cut the support using a nipper.



: If you are available to use the SW that can control the detail values of support, reduce the contact diameter to about 0.4mm.



### 3. Washing and support removal



: If the contact Diameter is set to 0.4mm, you can remove support from flexible denture easily by hand.

### 3. Washing and support removal



: When removing the support by hand, remove the support around the clasp part first, which is easily damaged.



: Gently tear off the support around the rest of border area.

### 3. Washing and support removal



: If there is residual resin, clean for additional 10 seconds using IPA and ultrasonic cleaner.

## 4. Post-Curing

: Post-curing consists of two steps.



: Put the stainless bowl containing the flexible denture into the CureM.

: cure for 15 minutes at Level 3 strength as primary post-curing.

## 4. Post-Curing



- : Secondary post-curing proceeds differently depending on the polishing method.
- : Please check before you do secondary post-curing the 'Flexible Denture Instruction' which provided with this manual.
- : Cure Flexible Denture for 20 minutes with Level 3 as secondary post-curing.