# **SOFT RELINING - 100°C CURING**

# DenPlus Impact-20 acrylic with Molloplast-B®

# Relining of new dentures

#### Plaster cast

Pour a master cast of dental stone.

# Spacer

It is fabricated with Photobase, Premium Tray or with a silicon base like Blue Eco Putty. Thickness is to be determined by the dental professional and should be between 1 and 3 mm. Set up teeth and try-in with spacer in patient's mouth.







### Flask

When teeth fixed to the wax, an insulation of the teeth by Flexistone is recommended. Complete flask and let dry.

#### Wax

Take care to remove all traces of wax with boiling water or in the microwave oven during 1 minute at maximum power. Wax residues must not adhere to plaster.

## Acrylic

Acrylic should be mixed according to instructions and packed into a lukewarm flask. Place a polyethylene foil between acrylic and spacer.

### **Pressing**

Pre-press in intervals of 10 minutes at 1000 - 1200 psi (100 bar). Open the flask, remove excess acrylic. Press again.

<u>Long curing</u>: Let the flask in the press for an entire night. <u>Fast curing</u>: Put the flask into boiling water for 5 to 10 minutes. The acrylic must show adequate stiffness to avoid deformation by the next handling.

# **Molloplast-B**

Open flask. Remove spacer and polyethylene foil. Apply a layer of separating liquid Separa-Plus on the plaster cast, to avoid adhesion of plaster dust on Molloplast-B. Let dry. Take Molloplast-B with a clean spatula and pack it on the acrylic and the model. Place a new polyethylene foil between the two layers of Molloplast-B. Close it and press. Open flask, remove polyethylene foil and Molloplast-B excess. Close flask and press for 10 minutes.





# **Polymerization**

Cure in boiling water (100°C) during 2 hours. Deflask after self-cooling to room temperature. Do not place flask in cold water.



## **Trimming**

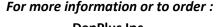
Use normal procedure for trimming acrylic. The relined denture base and the functional borders can be trimmed with Molloplast-B special cutters without problems and heat build-up.



# **Polishing**

Use standard methods for pre-polishing with pumice, brush or buff, applying commercially available materials. On Molloplast-B, for high gloss polishing, Lustrol gloss varnish is recommended.





DenPlus Inc.

333-M Chemin du Tremblay, Boucherville, QC, Canada, J4B 7M1 Tel.: (450) 641-1330 or toll-free: 1-888-344-4424 Fax: (450) 641-1337 www.denplus.com



# **SOFT RELINING - 100°C CURING**

# DenPlus Impact-20 acrylic with Molloplast-B®

# Relining of existing dentures

#### Plaster cast

A master cast of dental stone is poured. Let the master cast set and invest it into a flask with counter. For easier removal of the denture from the plaster counter it is recommended to coat the teeth and also a part of the denture surface with silicone(Flexistone®) prior to making the flask counter. Allow plaster to set completely, open the flask and remove the impression material from the denture.

### **Denture** base

Reduce acrylic material for approximately 1-3 mm by means of a coarse grinding stone. Provide sufficient retentions to ensure optimum bonding with Molloplast-B. For a smooth surface between acrylic and Molloplast-B, we recommended to cut grooves evenly into the functional borders by means of a wheel or fissure bur. Afterwards brush Primo adhesive 1-2 times onto the entire denture base. Let Primo air-dry for 60-90 minutes prior to applying Molloplast-B.

### Packing of Molloplast-B

Take ready-to-use Molloplast-B with a clean spatula from the jar and apply it evenly onto the denture base. Cover with a polyethylene foil, close the flask and place it under the press. The flask must be lukewarm. Press for approximately 4 minutes, open flask and remove polyethylene foil and Molloplast-B excess material. Check and if necessary apply more Molloplast-B material. Close the flask and place it under the press for approximately 15 minutes .

# **Polymerization**

Cure in boiling water during 2 hours (100°C). Deflask after self-cooling to room temperature. Do not place flask in cold water.

# **Finishing**

Use normal procedure for trimming the acrylic. The relined denture base and the functional borders can be trimmed with Molloplast-B special cutters or grinding sleeves, without problems and heat build-up. Use Molloplast-B pre-polishing discs for smoothing of rough spots.

# **Polishing**

Use standard methods for pre-polishing with pumice, brush or buff, applying commercially available materials. Mechanical polishing of Molloplast-B relined dentures is not possible - for high gloss polishing, Lustrol gloss varnish is recommended.



For more information or to order:

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