

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.

Long curing: Let the flask in the press for an entire night.

Fast curing: 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.



For more information or to order :

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.



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