

### Technical Notes

🔒 This is a technical manual description of the steps, hints and tips for making **LUFLEX** injected polyamide flexible dentures. We clarified that most of the information specified in the manual are suggested for a better performance in your **LUFLEX** dentures. We are available for any questions you may have.

🔒 **Take dental impressions s** (made by the dentist)

🔒 **Plaster casts** (Densita type IV)

🔒 **Ask the dentist** To carve niches for making occlusal supports if necessary to make.

🔒 **Denture Design**

🔒 **Plate Base**

- The minimum thickness suitable for the wax is 2 mm.
- Allow between the heel of the teeth and the model a minimum thickness of the wax from 1 to 1.5 mm, since the material must be able to pass during the injection through the space left between one and another.

🔒 **Dental Carving**

Since the material is translucent, **LUFLEX** needs to carve (wear) the heel tooth leaving the aesthetically desired crown height.

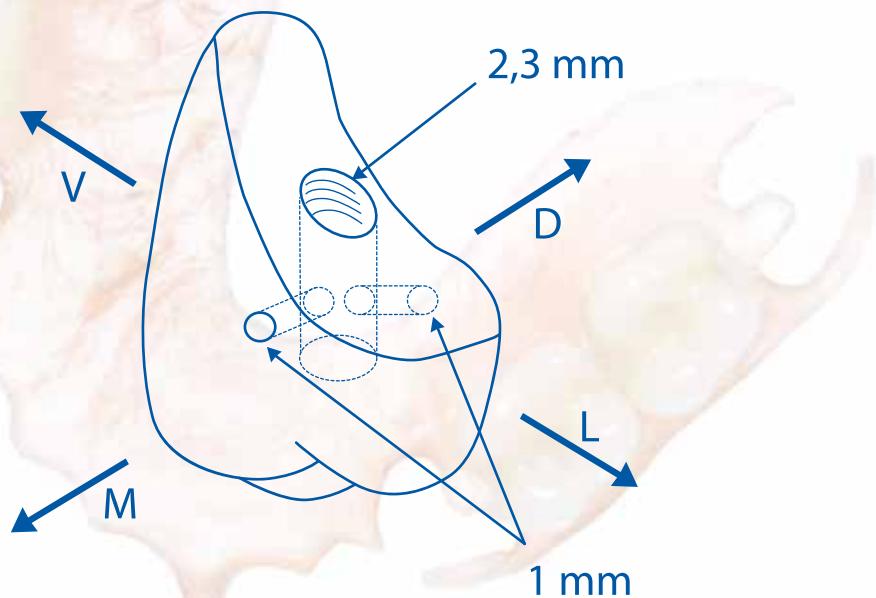
🔒 **Placement of teeth in row**

Rowed Disarmament

### 🔒 Mechanical retention of the teeth

Suggestions:

- Make holes with a drill bit or straight mill. Not used in the form of inverted cone.
- Clasps must be done in the proximal side.
- Lateral clasps must be connected with the central retention.
- Recommendation: make the holes after finishing the wear of the teeth heel, **not before**.



Suggested mechanical retention of the teeth: 2.3 mm vertically retention and 1 mm crossed retentions.

### 🔒 Reassembly and Waxing

🔒 **Mouth test** (made by the dentist)

🔒 **Paralelizado del modelo**

### 🔒 Retentivity

Once the model is parallelized, use a spatula to deduct the thickness of the wax that is between the Ecuador tooth and the gingival impeller. This will create the necessary retentivity to the prosthesis.

### 🔒 Gingival relief in wax

### **Reproduction of models**

During the injection of the prosthesis, we will miss the model, so we must make a duplicate of this, on which we will work from now on.

Duplicates can be made of:

- Alginate
- Gelatin (for plaster)
- Silicone

#### IMPORTANT:

To perform emptying, use Densita Type IV, which is suitable to withstand the pressure and the temperature used.

### **Duplicate model of work**

Once we obtain the model to work with, we will move the same to put it in row, To make the final waxing and to place the prosthesis in the flask.

### **Final waxing**

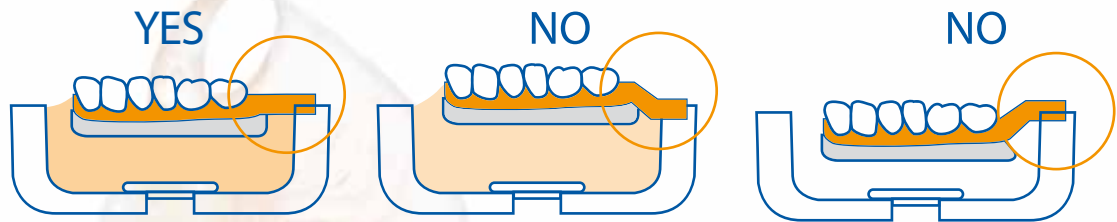
### **Place it in flask**

#### Suggestions:

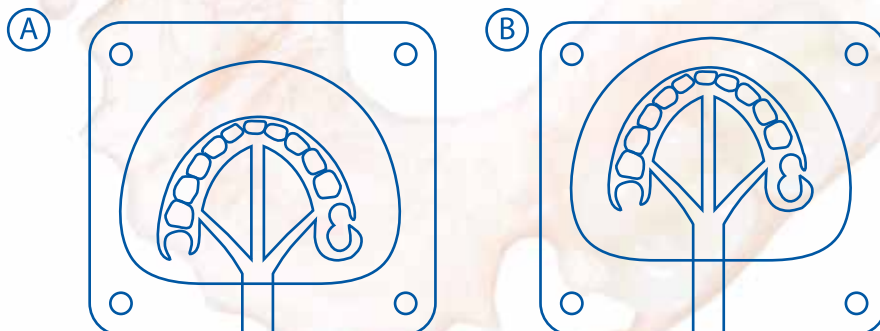
- Wearing the teeth in the plaster model to avoid undercuts.
- Use Type IV Densita plaster.
- Prepare with thick consistency, and spatulate well.
- Place the puck on the inside of the flask.
- Note that the back flask is the part that has the 4 holes of air leakage.
- Remember to pass in petroleum jelly against the back-flask and the front -flask.

### Location of the model in the flask

- Drinkers should follow a flat trajectory corresponding to the plane of entry of the material during the injection process.
- This model should be located at the same level, it should not be buried, or be too high in relation to the plane of the flask as well.



- Drinkers should follow a straight path, no curves and no obstacles stopping their income.
- The primary and secondary drinkers, should rest on the plaster of the flask and should not be aerial
- Subsidiary drinkers are over the wax of the model.



- Locate the model as close as possible to the inlet of the flask.

### Tips

By putting in the flask, do not let the flanks buried in the densita

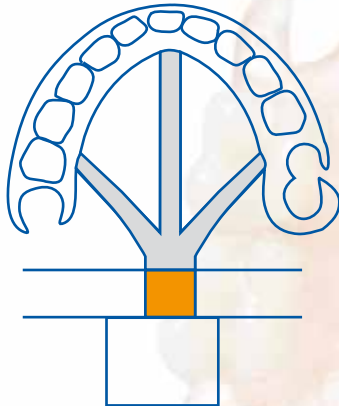
### Shape for the drinkers

Circular shape (Fig. A) or half-round shape (fig. B)  
Not recommended flat troughs (Fig. C)

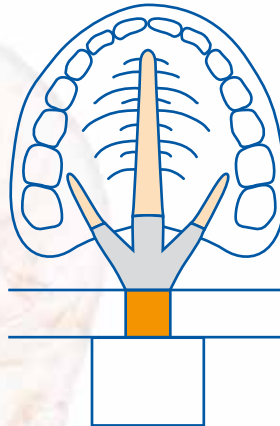


### Diagram of injection drinkers

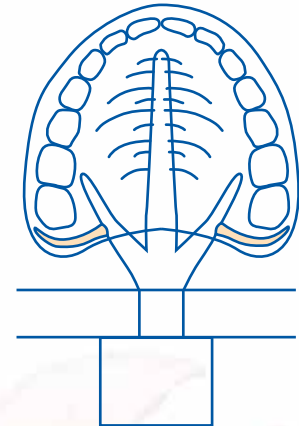
For Lower Denture






For higher dentures



Secondary Drinking Fountains optional (only w / . areas of difficult access)

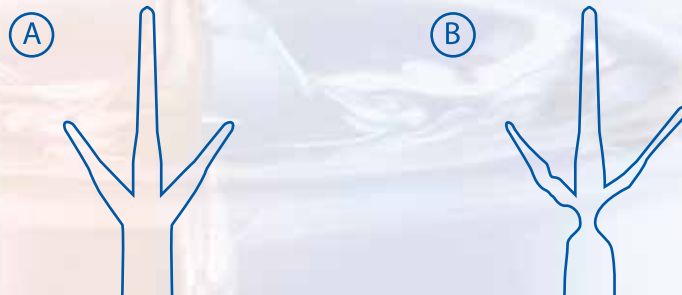


-  Drinker Entry = 10 mm
-  Drinkers Main = 6 mm
-  Secondary or auxiliary sprues = 3 mm

- **Drinker Entry**
- **Drinkers main:** 6 mm.
- **Secondary or auxiliary sprues:** 3 mm.  
Upper denture and areas of difficult access to the material.

**IMPORTANT:**

There should be a smooth transition between primary and secondary drinking.



### Gypsum separator (pink or brown)

### Submit to flask and screw

### Filling flask pair

### Washing flask

- Loosen the screws a half turn before washing.
- Wash time: 6 to 8 minutes.

### Limpieza y corrección de conductos

- After washing the flask should rectify and correct all the ducts eliminating any thin layer of plaster or burrs that are left.
- This will prevent a piece of chalk from breaking in and be injected into of the prosthesis.

### Tooth cleaning boreholes

Check that each of the perforations made in the teeth (mechanical retentions) are free and fair, as the polyamide should be able to enter through them and allow the necessary clamping.

### Separator pink

#### IMPORTANTE

- They spend two or three times depending on the type of separator used
- Cool the flask before passing the separator
- Do not flood separator flask sector to avoid lumps
- Distribute the separator always in the same direction
- Always Allow to dry before injecting, moisture can affect material properties

### Preparation of the flask for Injection

- Check that the screws are placed side holes where the exhaust air (flask pair)
- Check for residues of plaster or wax in the injection orificion.



### 🔒 Injection

### 🔒 Flask opened

### 🔒 Hydration of the prosthesis

#### IMPORTANT:

Immerse the prosthesis with and without model drinking 15 minutes in boiling water, or leave it 24 hours in natural water.

### 🔒 Retoque y pulido

- You can use regular or strawberry Cartee conventional stones.
- Is suggested to wear rubber (eg, Kenda Rubber).
- Recommended for polishing coarse pumice and brush converging rows 2 and 4
- To shine, using cloth wheel and high brightness pulp.

### 🔒 Reparaciones

- Adding teeth in acrylic: Only in cases where there is no need to replenish clamps
- Adding teeth Luflex (must be reinjected)
- Acrylic Lining: Only complete.

#### IMPORTANT:

In all cases should be mechanical retention. When repairing with Acrylic is convenient to place in zone 2 minutes before cyanoacrylate, to improve retention.



MECHANICAL  
CLAMPS  
( ' T' form)

NOTA Relining with waste materials can be made, but it is up to each laboratory to evaluate performance of these materials.