

Flexcera™ Smile and Flexcera™ Smile Ultra+ Protocol



HARDWARE			
Printer	M1	M2	M3 M3 Max
Cassette	C2	C2	D1

STORAGE

Temperature	5 - 30° C (41 - 86° F)	Notes Ensure resin is at room temperature before using.
Packaging	Bottle	

RESIN DISPENSING & PRINTING

Ratio	1 part	Dispensing Process - Check the cassette. - Pour required resin amount into cassette using preferred measuring technique. - After printing, reuse, discard or filter and save resin for later use. - Always check liquid resin for solids between prints.
Speed	N/A	
Mixing tip	N/A	
Burn off	N/A	Notes - Manufacturer recommends rolling resin in bottle roller for at least 12 HR before using. - Use Flexcera Smile/Ultra+ Bleach dropdown for Bleach shade. - Use Flexcera Smile/Ultra+ A1, A2, B1 dropdown for all other shades. - Crown and bridge parts require the Print Profile Flexcera Smile Ultra+ C&B located in Print Controls. - Remove parts from platform shortly after printing to prevent deformation.
MMD	No	
Pot life	N/A Reusable after filtering	
Release film	Not required/ optional	

WASHING

Solvent	Isopropanol (min.>96%)	Washing Process 1. Remove parts from platform. 2. Place parts in dedicated container of fresh IPA. Solvent should cover ¾ of tallest parts. 3. 5 MIN max orbital shaker at 140 RPM and remove parts from washtub. 4. Dry with compressed air. 5. Place parts in second dedicated container of fresh IPA and wash additional 2 MIN max in orbital shaker at 140 RPM. 6. If glossy areas remain, spot clean with IPA-dipped swab 7. Dry with compressed air and transfer to paper towel lined tray. 8. Place the dried parts in an incubator/oven at 37 °C for 30 minutes (alternatively, the parts may be air dried for a minimum of 45 minutes at a temperature between 73° F and 85° F (23° C and 28° C) 9. Remove supports
Exposure	7 MIN max	
Part Washer	No	
Notes • Post treatments recommended immediately following a completed print. • Washing should occur no later than 8 hrs after print completion. • Wash parts in dedicated container (only for cleaning parts printed in Flexcera Smile Ultra+). • Stir thoroughly after adding fresh resin to existing resin in cassette		

CURING

Cure start	Recommended directly after parts have dried.	Curing Process • Cure in UV post-cure unit (see left). • Check part for tackiness with a clean glove after curing cycle is complete. • Move part to contamination free zone.
Otoflash G171 (with Nitrogen)	3000 flashes per side, under Nitrogen. Allow parts to cool completely before removal.	
Dreve PCU LED	Cure parts for 18 MIN at 90% intensity, under vacuum. Cure profile: DHealth 1	

Notes • Safe for handling after UV curing. • After curing, polish/finish as needed. • Wash with soap and water before delivery to patient.
