

DENTCA® Denture Teeth for Carbon printers Protocol



STORAGE

Temperature	17 - 25°C (64 - 77 °F)
Packaging	1 kg bottle

Notes

- Can be used immediately from storage.

RESIN DISPENSING & PRINTING

Supplemental information available.

Ratio	1 part
Speed	N/A
Mixing tip	N/A
Burn off	N/A
MMD	No
Pot life	N/A Reusable (filtered)
Release film	Not required/ optional

Dispensing Process

- Check the cassette.
- Shake bottle well before use.
- Pour required resin amount into cassette using preferred measuring technique.
- After printing, reuse, discard or save resin for later use.

Notes

- For subsequent prints, stir resin in cassette with a spatula between prints to check window for any adhered resin.

WASHING

Supplemental information available.

Solvent	99% Isopropanol
Exposure	N/A
Part Washer	No
Part Washer solvent	N/A

Notes

Washing Process

Part Washer

- N/A

Manual Washing

- Remove parts from platform.
- 5 min orbital shaker at 140 RPM and remove parts from washtub.
- With **FRESH IPA** solvent, 5 min orbital shaker at 140 RPM.
- Air dry for 30 min.

CURING

Cure start	w/in 1 hr of printing
Dymax ECE 5000	• 3-5 sec w/teeth facing up • Glycerol: 10 min/side
Dreve PCU LED	• 5 sec at 90% intensity • Glycerol: 30 min at 90% intensity Program Name: Dentca • Available in Configuration File 2

Curing Process

- Assemble dentures before curing.
- UV cure **before** glycerol bath.
- Wipe off glycerol and wash with water.
- Move part to contamination free zone and polish as necessary.

Notes

- No baking, safe for use after UV curing
- Pre-warm glycerol bath to 60°-70°
- Use binder-clip and glass plate methods in curing
- Do not exceed stated glycerol cure times