

Keystone® KeyPrint® KeyDenture Try-In™ Protocol



WASHING

Supplemental information available.

Solvent	99% Isopropanol (IPA)
Exposure	5 min max.
Part Washer	No
Part Washer solvent	N/A

Notes

- Washing should occur as soon as possible but no later than **8 hrs** after print completion.
- Wash parts in dedicated container (only for cleaning parts printed in KeyDenture Try-In).

Washing Process

Manual Washing

1. Remove parts from platform. Remove supports.
2. Place parts in dedicated container of **fresh IPA**. Solvent should cover $\frac{3}{4}$ of tallest parts.
3. **30 seconds** orbital shaker at **140 RPM** and remove parts from washtub.
4. Place parts in second dedicated container of **fresh IPA** and wash **additional 30 seconds** on orbital shaker at **140 RPM**.
5. Place parts in an ultrasonic bath for **2-3 min** (if no ultrasonic bath is available, increase first orbital shaker time to **3 min** and second shaker wash to **2 min**).
6. Air dry for **30 min** or use **compressed air**.
7. If glossy areas remain, repeat swabbing and drying.

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

1. Check the cassette.
2. Pour required resin amount into cassette using preferred measuring technique.
3. After printing, reuse, discard or filter and save resin for later use.
4. Always check liquid resin for solids between prints.

Notes

- Agitate the bottle **1 hour** prior to use for a minimum of **5 minutes** to ensure all pigments are dispersed within the resin and to avoid bubbles during printing.

CURING

Supplemental information available.

Cure start	Recommended directly after parts have dried.
Dreve PCU LED (with Nitrogen)	12 min at 90% intensity, under Nitrogen. Program Name: Key TryIn • Available in Configuration File 1 & 2
Dreve PCU 90 (with Nitrogen)	Use control knob to select 8 min per side, under Nitrogen.
Otoflash G171 (with Nitrogen)	2000 flashes per side, under Nitrogen or ambient air. Allow parts to cool completely before removal.
Uvitron Intelliray 400W	2 min/side at 100% intensity on lowest rack under ambient air.

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.

Notes

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