

## 1. Injection condition

Following is the injection condition by using 「SINGLE JET」 of Denken-Highdental Co., Ltd.

Injection machine : SINGLE JET (Air / Ar gas pressure)

Injection pressure : 0.7 MPa

Desiccating condition : 100°C / 6~20 h

Melting condition : 300°C / 20 min

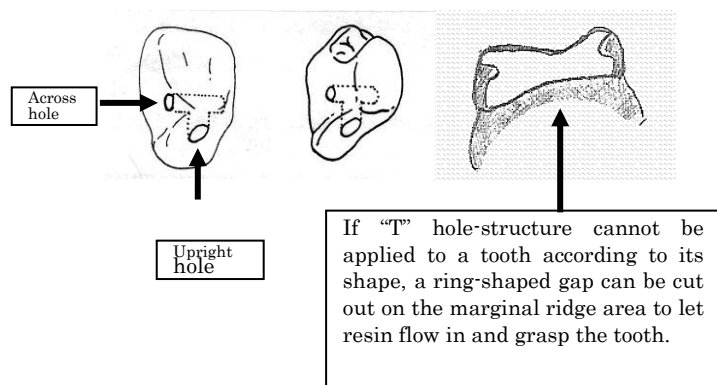
Temperature of flask : 55°C (by heating the flask)

Please note that injection pressure and melting condition might vary by different denture system machines. The figures we recommend above are given only according to our “Single Jet system”. Users might need to adjust injection pressure and melting condition on their own machines.

## 2. Bonding to artificial teeth (Important)

BIOTONE is not chemically adhesive to artificial resin teeth. Users will have to cut out holes on the bottom of resin teeth to achieve bonding physically with resin flowing into those holes.

“T” hole-structure showed in the below picture is recommended.



## 3. Desiccation

BIOTONE need to be desiccated in a oven under 100°C for over 6 hours, but not exceeding 20 hours.

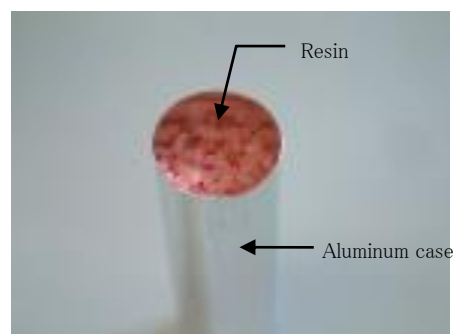
- ※ Desiccating for over 20 hours could cause resin discoloration.
- ※ Resin under desiccation is recommended not being laid deeper than 8 mm to make sure desiccation is completed thoroughly.

## 4. Melting preparation of Resin while using 「SINGLE JET」

- (1) Turn on the melting machine.
- (2) Inert the cylinder into the machine for preheating.

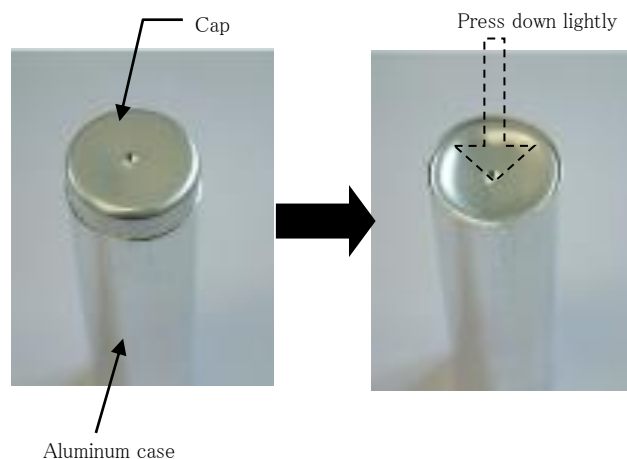


- (3) Put desiccated resin into aluminum case.



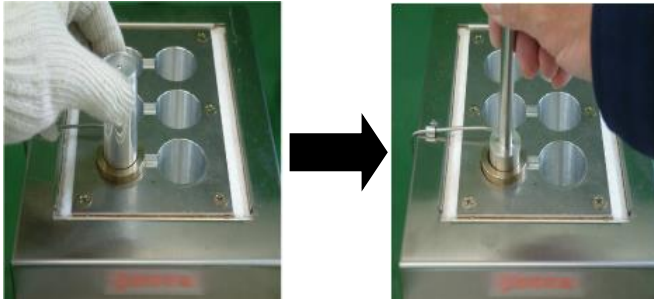
- (4) Insert the cap into the aluminum case and press it lightly.

It is important to seal the case to prevent resin from being oxidized.

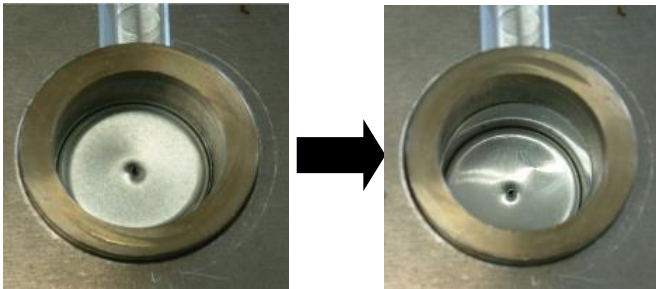


## 5. Melting of Resin

- (1) Insert the aluminum case into the preheated cylinder and press it down to the bottom.



- (2) Press down the aluminum cap to the surface of resin.



## 6. Injection

※ After melting is finished, put two rubber gaskets onto the aluminum cap one by one, to prevent resin from overflowing. Then put a metal plate onto the gaskets for pressure dispersion. Proceed injection.

※ Hold the pressure for 60 seconds to make sure the resin doesn't flow backward after injection.

※ Annealing before deflasking under 130℃ for 4 hours is recommended to better dentures condition.

## 7. Cautions on treatment of denture

Do not use automatic polishing machine to avoid change in shape and being damaged by polishing heat.