

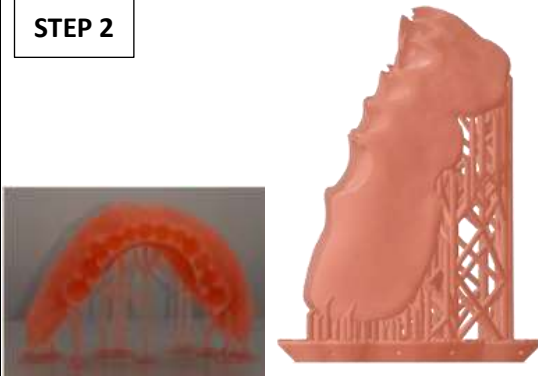
### STEP 1



### Design

Design the denture model in two mating parts, the denture base and denture teeth in a suitable CAD software such as exocad

### STEP 2



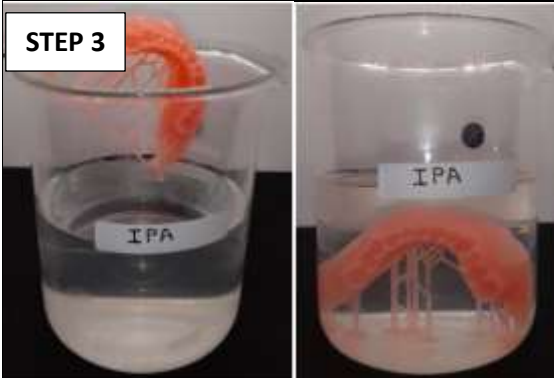
### 3D Print the denture base .stl file

Import the 3D Model .stl file into a slicing software  
Set up suitable setting printer parameters  
Orient it vertically or at a slight angle (10-25°) to minimise the supports and support marks. Avoid supports in the intaglio region.

1. Contact point ~ 1 to 1.5 mm
2. Overshoot diameter ~ 0.7 mm

3D print the part

### STEP 3



### Clean the denture base

Denture base can be cleaned with IPA spray and wipe. Excessive IPA cleaning in acyclone can cause a powdery surface due to resin removal from top layer. If cyclone is used, please use a short cycle (Approx 5 seconds). For Bio Compatible resins, maintain a separate cleaning system with IPA to prevent cross contamination with TEC resins.

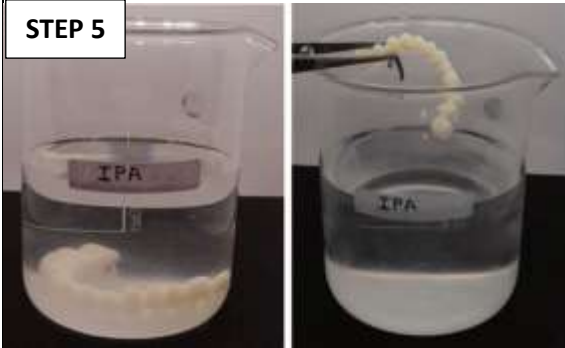
### STEP 4



### 3D Print the denture teeth .stl file

Import the 3D Model .stl file into a slicing software  
Set up suitable setting printer parameters  
Generate suitable supports on the occlusal surface of the part  
3D print the part

### STEP 5



### Clean the denture teeth

Denture teeth can be cleaned with IPA spray and wipe. Excessive IPA cleaning in acyclone can cause a powdery surface due to resin removal from top layer. If cyclone is used, please use a short cycle (Approx 5 seconds). For Bio Compatible resins, maintain a separate cleaning system with IPA to prevent cross contamination with TEC resins.

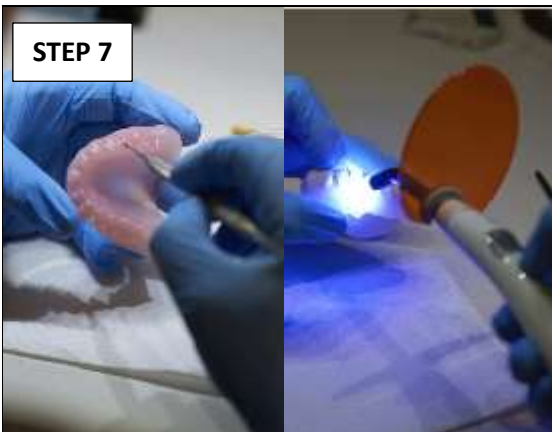
### STEP 6



### Fitment Check

Join the mating parts and check the fitment of teeth in the denture base

### STEP 7



### Assembly

Join the denture teeth to the denture base using a suitable adhesive (recommended product Visiolink, Bredent).

First stage curing of adhesive can be done in the post cure machine. Then, a hand-held dental light cure machine should be used both from above and below to ensure full curing of the adhesive.

Alternatively, a thin layer of denture resin can be applied with a brush in the sockets and used as an adhesive. In this case the post cure machine is best for curing.

### STEP 8



### Post Cure

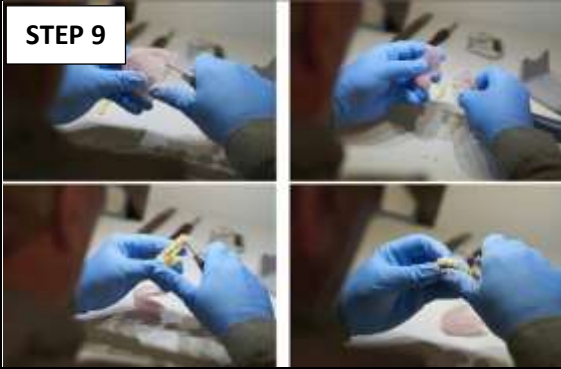
Put the whole assembly in a glass beaker / Glass pot filled with glycerol (50%) +water (50%) and post cure in a curing chamber. This allows the oxygen inhibited layer to cure.

Set curing time based on machine power

1. 30-50 watt- Cure for 20 mins
2. 60-80 watt-Cure for 10 mins
3. >100 watt- Cure for 3-5 mins

\*Curing under nitrogen or vacuum will improve results

### STEP 9



### Support removal

Cut the supports by using a flash cutter

### STEP 10



### Polishing

After ensuring that the adhesion is properly achieved, proceed to polish the denture using standard polishing techniques. For clinicians, we recommend the Bredent polishing kit, Part No REF VLTOOLKIT

### STEP 11



### Glazing

If only polishing is found sufficient for end use, it is the best option. However, if not, then after polishing, a UV cured glaze like D Tech Pro Glaze or GC Optiglaze can be used to give a shiny look.  
Note: Glaze must not be used in instead of polishing. Glaze should act as a sealer of any porosity instead of a substitute to polishing.