Technical table 007        ( GB )
Abutment Manufacturing Procedure

1) Master Model
   a) With this type of procedure the model can be made of hard conventional plaster.
   b) Perspective view of the wax element.

2) Wax element placed in the flask.
   a) The pins connecting the wax element to the bar are 2 mm wide and the bar is distant 3 mm.
   b) The feeding bar is 5 mm wide.
   c) The sprues are 5 mm wide.
   d) In this case the wax element has been removed, one can chose whether to put the master model into the flask.
   e) Use plaster-plaster insulation for the flask before making the countermold.

3) Open flask after wax removal
   a) Close the still hot flask and place it on the oven centering device. Tighten the press manually.
   b) Start the melting process to pre-heat the flask.

4) Pressure-injection finished product removed from the flask.

5) Perspective view of "Acetal Dental ® " abutment placed on the trial model

Pressing® Mod. J-100 must be programmed as follows:

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Melting temperature</td>
<td>220 ° C.</td>
</tr>
<tr>
<td>Melting time</td>
<td>20 minutes</td>
</tr>
<tr>
<td>Heating time after injection</td>
<td>05 minutes</td>
</tr>
<tr>
<td>Cooling time under pressure</td>
<td>40 minutes</td>
</tr>
<tr>
<td>Injection pressure</td>
<td>04 Bar</td>
</tr>
</tbody>
</table>

Remove the flask only at the end of the cycle.

a) Open the flask when it is at room temperature.
b) Conventional burrs for acrylic resins can be used for the finishing process.
c) To enhance polish use "Universal Polish"