Technical table 001

Esthetic Clasp Manufacturing Procedure

1) Fully waxed-up duplicated model
   a) Duplicate the master, with the metallic partial denture in position, preferably using an alginate.
   b) With this type of procedure the model can be made of hard conventional plaster.
   c) Model the wax clasp 2.5 mm thick.

2) Position of the model in the flask base
   a) Remove undercuts from the model.
   b) The plaster layer in the mold must be as high as the wax element and must not cover the clasp.
   c) The feeding channel is 4 mm wide.
   d) Use plaster-plaster insulation for the flask before making the countermold.

3) Open flask after wax removal
   a) Close the 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) View of the metallic partial denture with the esthetic clasp on the master model.

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

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Melting temperature</td>
<td>220 °C</td>
</tr>
<tr>
<td>Melting time</td>
<td>20 minutes (J-100 Timer 1)</td>
</tr>
<tr>
<td>Heating time after injection</td>
<td>02 minutes (J-100 Timer 2)</td>
</tr>
<tr>
<td>Cooling time under pressure</td>
<td>20 minutes (J-100 Timer 3)</td>
</tr>
<tr>
<td>Injection pressure</td>
<td>04 Bar (J-100)</td>
</tr>
</tbody>
</table>

Remove the flask only at the end of the cycle.

a) Open the flask when it is at room temperature. If necessary, after 20 minutes, dip the flask into the water to cool it down.

b) Conventional burrs for acrylic resins can be used for the finishing process.

c) To enhance polish use "Universal Polish"