



Partial Denture

Waxing of acrylic partial denture ,Flasking ,Curing, Finishing and Polishing procedure

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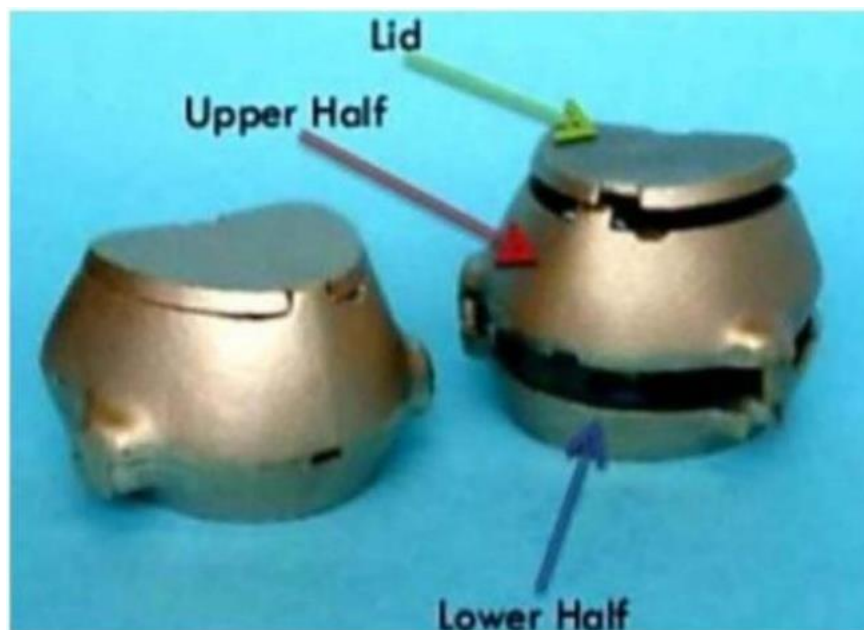
Lecture 7,8

Waxing contouring:

- In waxing up the saddle we can extend it to the border of the cast.
- Care must be taken to eliminate any sharp grooves which form around the neck of artificial teeth during waxing up because these grooves will retain stains and debris.

FLASK:-

IS metal sectional box used for holding the plaster mould of the waxed-up denture in to which the acrylic resin is packed, it composes from two sections, one part being deeper than other. Before flasking the peripheral wax edges should be sealed down to the cast with wax to prevent plaster which is used during flasking from passing beneath the denture.



Procedure of flasking:-

1. Flask should be big enough to allow last (13 mm) space all around the cast._so some time may cut the cast to reduce its size

2. The cast embedded in the shallow section of the flask then mixed plaster of plaster of the cast being with the level of metal flange of the shallow section of flask the all the cast should be cover.
3. Plaster must be smoothed after the initial set-also metal surface of flask completely cleaned.
4. Separating solution is painted over the plaster if desired a tinfoil can be applied over the wax surface of the denture.
5. The tops of the teeth are covered with a mixture of stone to a depth of (6 mm)this should be carefully painted to prevent bubbles
6. The top (deep section) (upper part) of flask is added and then filled with either plaster or mixture (1:1) stone and plaster which is preferable to eliminate
7. Close the flask with its cover. Then put the flask in bench press to ensure. that the cover will be parallel with the base also bench intimate contact to prevent plaster going through out press wake as sure the two section of flask become in intimate contact to prevent plaster going through out which lead to changes in occlusion of finished denture.

Removal of wax pattern:-

- * Flask is immersed in(100c water) for about (5) min in order to separate the wax from the teeth and allow the two section of the flask to be opened.
- * The wax will be lifted out in one piece and the teeth will be left will prevent bonding of teeth to acrylic resin and prevent penetration of the separating media to plaster.
- * leave the flask to dry. Or put it in side over (50C) about (2) hours.

Separation: When the mould is dry, a separating material paint on the surface of the stone is both section of the flask.

Packing: when reach to dough stage acrylic make as a ball and packed into the deep section of the flask, press to over fill all the mould.

Curing (processing of acrylic resin):

Two types of cure are used:

1. Rapid cure where the denture is held at 70c for 12 hours, finally boil for 30 min.
2. Slow cure at 70c for 14-24 hours .usually we are use water bath operator to reach this temperature if we use a higher temperature porosity will occur in the a acrylic. There is a dry bath but it is not use full because the plaster will be very difficult the remove during deflasking.

Deflasking:

The flask remove from the processing bath and allow to be cool.

Finishing and polishing:

If we apply a separating material; correctly we will have a clean surface of resin.

* Initial stage is to remove the excess of acrylic resin at the edge of denture by large ston bur fixed on hand piece- followed by a sand paper to gain a smooth surface

* If there is post dam so the posterior limit of denture .should be trimmed after that denture can be polished

Polishing done by a rotating large bristle brush wet by pumice, then use a proper wet paste or soap with cloth, when to have a final shiny mirror surface of the denture.