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Argentina 54 11 5258 7148 Cba 54 351 569 1409

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GFM FLEXIBLE

GFM FLEXIBLE Chemical family (Polyamide Nylon)

Comparable with Valplast , GFM , TCS, CFS but more Flexible and color stable

Characteristics

1. Unbreakable
2. Bio Biompatible
3. Can be added and repaired in non flexible areas with Rapid set and using Aaron Alfa as a adhesive
4. Can be relined and added mayor areas by re injecting and using Repair liquid as an adhesive
5. Can be relined with a soft reliner silicone based using Flexil
6. Requires less precision in the design and block out of undercut areas
7. Designs are mostly tissue supported
8. Can add esthetic clasps using Clasp Eze and Aaron Alfa as an adhesive
9. Variety of shades and V-Plast- Light Pink, Translucent –

Translucnet con, Ethnic & Clear



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GFM D-FLEX

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Chemical family: Co-Polyamide 9 (Casted Nylon)

Same formula as **Deflex TM**

Characteristics:

1. True cast thermoplastic with excellent dimensional fits, comparable to alloy castings.
2. Gum retainers can be done due its flexibility
3. Designs can be Tooth and Tissue supported (Dento-muco supported)
4. Can be added and repaired in non flexible areas with Rapid set and using Aaron Alfa as Adhesive
5. Acrylic will stick and chemically glue on it with the use of Aaron Alfa.
6. Polishes to a high gloss
7. Bio-compatible,
8. Clinically unbreakable.
9. Can be re adapted to the stone model with the Heat gun with great stability
10. Almost No Shrinkage
11. Shades: Rosa Suave and Rosa intens (Intense Pink and Light Pink)



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GFM CREATION

GFM CREATION

Chemical family: Methyl Methacrylate Blend (Multi-Polymer Acrylic)

Compared with regular High Impact heat cure acrylic like Lucitone but Monomer free , faster and easier to manipulate

Recommended

Fulls, TMJ's Bruxism, Provisionals for Implants in progress, Anti-Snoring Devices, and Silicone-Acrylic Combinations.

Characteristics:

1. Hi-impact Acrylic. Above average impact and dimensional fit.
2. Perfect Crystal clear comes easy
3. Can be relined or added to with standard repair acrylic
4. Can be relined with a soft reliner silicone based using Flexil
5. Monomer Free
6. Can be added and repaired with regular monomer acrylic
7. Standard colors: Lucitone pink, and Standard



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GENERAL INSTRUCTIONS

MODEL DUPLICATION

1. MATERIALS:

A. Duplicating Flasks

B. Any top grade duplicating materials specifically for stone models. If you get a film of stone that remains on duplicating gel, you may be using the duplicating gel meant for the chrome department. Discard and do not use!!

2. TECHNIQUE:

A. Soak the model in water for a minimum of 30 minutes. But do not cover teeth. Prolonged soaking of models completely submerged in water will result in smaller teeth as minute stone particles will dissolve into the water.

B. A quick alternate method: Put model in pressure pot filled with slightly warm water. Cover completely. Build pressure up to 15-20 lbs. and allow to stand for only 7 minutes.

C. Blow excess moisture off model, set on base.



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D. Dip bottom of flask into duplicating gel and place on base.
This will seal flask to base or flat pan.

E. Pour duplicating gel and allow to harden for 15 minutes.

F. Refrigerate or allow cold water to run through flasks for 30 minutes.
Entire time is 45 minutes.

G. Separate and pour. Try to use different color stone, if feasible, to
differentiate between master and duplicated casts.

H. Separate after surface has hardened. Copy design in pencil and
remove all artifacts. I suggest you survey with red pencil and
clasp design in black pencil.

TOOTH PREPARATION

A. Retain as much bulk as possible when setting teeth to allow room for burring
Diatorics into plastic teeth. Never use short bite teeth.

B. Diagram shows a X ray view example of molar tooth. Dark area indicates
retention prepared
with burr, similar to porcelain diatorics.



C. Anterior teeth diatorics are cut toward lingual so that holes are not visible
anteriorly.



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D. Wire loops may be added for close bites and add retention .
*Vacuum fired porcelain teeth may be used but never next to a clasp.



Note: Use #8 round burr for a center hole. Open generously when feasible.
Open other holes with #4 round burr from mesial to distal. Connecting with center hole if possible

DO NOT SET TEETH ON HEAVY BASEPLATES. USE THIN WAFER OR SETUP WAX WITH RE-ENFORCING WIRE SO THICKNESS OF TOOTH IS PRESERVED FOR RETENTION.

PREPARING FOR CLASPS AND MATRICES

After design is marked off in red pencil, mark approximate position of clasps.
Using a heatless stone, cut in at least 1-1/2 mm of space for GFM broadening towards the lingual.



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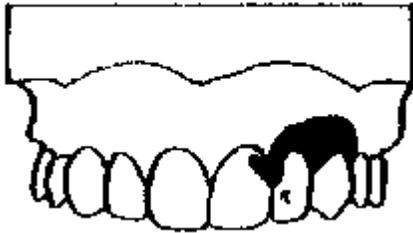
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Note cut-outs on lower quadrant showing approximately how much space should be provided.



To transfer teeth to duplicate model, use full occlusal arch matrices.

*For free-end saddles where no natural molar teeth are present, be sure to have the plaster matrix rest on saddle.



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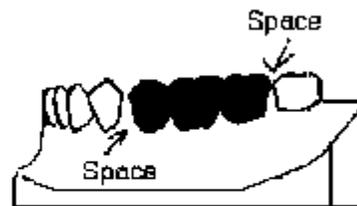
Alternate Technique:

Survey, design and block out undercuts. Duplicate model and articulate with counter model. Put in retention holes and setup teeth on duplicated model. You will have one counter model and two working models. No transferring of the teeth will be necessary. Complete on duplicate model.

5. SPACING FOR CLASPS



Note the occlusal space.



Note spaces in buccal area.



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Note the occlusal space Note spaces in bucal area.



DESIGNS FOR FLEXIBLE DEVICES



Note there are mostly supported by the soft tissues



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WAXING TECHNIQUES

1. MATERIALS:

- A. Base plate wax. (Use thin gauge for partials and heavier gauge for Fulls)
- B. 1/4 inch Boxing wax for sprues only in metal and GFM combinations.
See Page 10
- C. Usual waxing instruments
- D. Abbots brushes
- E. Odorless Mineral Spirits. (Wax solvent) Can be purchased at Home Depot.

2. TECHNIQUES:

Assuming design has been copied on to duplicate model, proceed as follows:

- A. With small spatula fill in clasp areas with a light flush. For full uppers, flush palate slightly with wax from wax pot. Soften spruce wax and mold into center of palate with fingers to provide a rib for added support and flow.
- B. Soften base plate wax and apply to palate. Try not to nick or dent palatal area.
- C. When **waxing upper partials extend posteriorly as if for a full palate.**
- D. Apply wax to bucal areas by heating base plate wax and pressing on. One sheet thickness usually will suffice. Double when necessary.



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E. Trim gingival around teeth but leaves interdental papillae convex rather than concave.

F. Use abbots brush with wax solvent to clean excess.

G. Apply odorless mineral spirits to wax surface, then burnish wax with soft paper towel.

(Bounty or Viva brands are durable and work best)

h. High shine with cotton dipped into soapy water, or use GFM Debubblizer.



IMPORTANT TIPS:

A. Follow taper principle for clasps. Observe buccally as well as occlusally to insure proper taper.

B. Buccal and lingual clasps may be connected when the bite is very close and the tooth has been ground excessively.

C. This is particularly so when processing a GFM saddle against a metal frame. If there is not at least 2 mm of space between tooth and metal retention, carry an extra sprue toward buccal saddle.



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SPRUIING

Standard Procedure For All GFM Cases.

UPPERS:



Use a flat sheet of base plate wax. Wax all uppers as if they were full dentures. Extend to end of model and tape to the entry hole in Flask. Plastic will be cut back later to bead line.

LOWERS:



Take sheet of base plate wax, and trim to fit into entire lingual. Be sure to trim stone in center platform section so base plate wax is flat and can be sealed down low at periphery.

Heat and roll ½ inch strip of base plate wax into entry hole. (Entry hole remains plugged in wax)

Compress upper flask into position. Trim excess wax till flasks close properly, remove and pinch and taper wax into center.



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BRUXISM and TMJ's:



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Bruxism and TMJ's are sprued differently because of the heavier than usual occlusal. To avoid bubbles, connect a heavy 1/4" inch sprue from the entry hole to the distal of both saddles.



INVESTING (FLASK)



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***IMPORTANT:**

Vaseline is used only one time to lubricate inside of flasks so stone can be extracted easily.

Make sure that no excess Vaseline remains on platform or entry hole.

"Paint & Pour" spray is recommended as the separating medium between stone in the flasks.

DO NOT USE VASELINE! With Vaseline the risk of contaminating the teeth is too great.

Spray with "Paint & Pour" plaster separator. With "Paint & Pour" this is eliminated. No teeth will shift out of position. Vaseline affects the plastic.

1. Soak cases in water to eliminate dryness.
2. Trim points of stone teeth and any protruding stone areas that are undercut.
3. Mix stone to a smooth creamy texture and invest in lower half of flask.

Note: The lower half contains the larger platform. Upper half does not contain threads for the Allen screws, therefore always screw top to bottom.

4. Draw all teeth over, unless butted.
5. Smooth and dry out stone. Prepare for Spruing.
6. Spray lower half with PNP separator, rinse with water and top with well mixed stone.
Vibrate in slowly rotating flask so teeth are covered, then add the rest of the stone.
7. Screw in 2 Allen screws diagonally opposed, making sure flasks have metal to metal contact.



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8. When stone is set, remove the 2 screws and immerse flasks in boiling water for 7 minutes.

BOIL OUT TECHNIQUE

A. Remove bolts from flasks before putting into boiling water for **7 minutes**.

B. After 7 minutes separate flasks but allow the model side to remain in the boiling water until you complete boiling out the side containing the teeth.

C. Take the Odorless Mineral Spirits (Purchased from Home Depot- 1 Gal Container), put it into a convenient plastic bottle that you can squeeze.

D. Flush out wax with mineral spirits (a wax solvent) Then flush with clean boiling water.

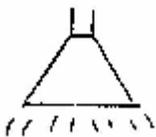
(Repeat if necessary)

E. Spray with Fantastic (household cleaner purchased in super markets)
(OPTIONAL)

F. Flush with clean boiling water.

G. Allow to dry and paint with separator.

H. Put flasks under 100 watt flood lamp, but never directly.





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I. Use separator that doesn't peel, either Degussa or GFM Acrylic Foil Separator. Two coats.

J. After opening case, put into ultrasonic cleaner with plaster stone remover and it will come out clean.

Use econo discs to cut off sprues. (You may cut off sprues before you put in cleaner)

HELPFUL HINTS:

1. Take an old tooth brush, shorten the bristle to less than one inch. Take heat gun and bend the handle at right angles so you can use it for the wax solvent.

2. Purchase basting brush in supermarket and shorten it slightly to use with Fantastic cleaner.

3. Open flask, trim sharp excesses and check teeth with fingers for any mobility. Set loose teeth aside and paint the mold with our plastic separator. Then carefully seat the teeth into place. The teeth will remain clean and you will not have to finish the occlusal surface as you would have to when using glue.

4. Place under lamps until ready to close. (Distance should be around 12 in.) Usually 25 minutes for a medium size cartridge and 30 min. for a large cartridge. A 100 watt flood light is O.K. **Flasks should be warm, not hot.**

5. Rotate occasionally so that acrylic teeth do not soften. Do not concentrate heat in one spot.

6. When ready to inject, use 4 Allen screws. Clean off all surfaces, especially the entry hole, and inject case.



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FINISHING

1. MATERIALS FOR FINISHING AND POLISHING :

A. Scraper or Bard Parker knife.

B. Nylon cutoff disc. (4 inches Econo Cutters Keystone # 1300500)

C. 2 Rubber Red Wheels – Keystone 3in x 3/8in # 1900050

Shape one to a V shape and the other to a U shape.

Use the round shape wheel for peripheral trimming and thinning.

Use the V shape wheel to trim lower anterior sections and where necessary.

D. USDD Red rubber points for flexibles (small and large # 101141)

E. 84TXC and 82TXC Carbide Bur

F. Buff 4 inches x 40 plies (# 100191) with any polish powder compound like pumice

G. Green Bar # 197-GREENBAR with 2 inches mounted buffs # 1180120

H. GFM liquid Polish # 102091

2. SUGGESTED METHOD OF FINISHING:

A. Use nylon disc to cut off sprue.

B. Trim to borders, and round out with Cutoff discs .



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C. Check for undercuts (should have been blocked out in design) and trim back if necessary.

D. Smooth with rubber points , wheels and carbide burs

Note: Some technicians, finish entire case with rubber wheels.

POLISHING

**** GFM ACRYLATE can be finished and polished in conventional Acrylic method.**

GFM D-FLEX and GFM FLEXIBLE require a final step of rubber mounted pointing to create a glaze effect before polishing.

We recommend a flour pumice prior to our green compound for the ultimate hi shine.

DO NOT USE COARSE PUMICE!

ALL SCRATCHES MUST BE REMOVED BEFORE HIGH SHINING WITH MOUNTED RUBBER POINTS

USE GREEN BAR AND GFM LIQUID POLISH FOR FINAL LUSTER.



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THE SECRET OF A GOOD HIGH SHINE

A. A Smooth wax up is imperative!

B. For Finishing, use acrylic trimmers to finalize the surface. (**Red mounted stone wheels for acrylic - 84TXC and 82TXC Carbide Bur**)

C. Rubber point entire surface with **USDD Red rubber points for flexibles (small and large # 101141)** A sheen will develop rapidly

D. Use any Fine Polishing Compound (**USDD Polishing powder – Pumice**)
Apply slight pressure to rag wheel (**Buff 4 inches x 40 plies**) while pumicing and note quick results.

E. On the lathe, use now **Green Bar** with **2 inches mounted buffs**

F. **GFM liquid Polish.**

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Repairs and Additions to GFM MATERIALS

Non Flasking quick cure method

Our Nylons can be added to and relined without flasking in non flexing areas.

A. Roughen the area or section where acrylic is to be added. We suggest you use a paper roll and put in minor grooves with a square #563 burr. Blow off and leave stubborn fibers in place. They will be absorbed and dissolved by the bonding agent. This technique is recommended for relining lower saddles or adding teeth in non-flexing areas.

B. Apply bonding agent (Aaron Alpha 221) to the roughened surface and allow it to dry.

C. Prepare two dampen dishes. Select "Rapid Set" color of choice and fill one dampen dish with Rapid Set powder and the other with a quick cure monomer.

D. Apply with a brush. After build up, put the partial into a pressure pot for approximately (7) minutes at 140 degrees Fahrenheit.

For Relines:

After coating the surface with the brush method, pour powder into the liquid and mix until it thickens slightly. Then add the acrylic to the saddle.



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GFM CREATION REPAIRS

CREATION can be added to and relined with our Rapid Set Pink acrylic powder and our Flexil silicone. ***With GFM M.P. no bonding agent is required for the Rapid Set powder.*** A bonding agent is required for Flexil or silicone soft liner.

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Reinjecting Or Repairing A Fractured Lower Partial

DENTURE AND MODEL PREPARATION

Some strange things do happen. A patient complained her dog chewed her denture when she inadvertently left it on the bathroom sink. **WHAT TO DO?** Do not attempt to repair the fractures. If you can, pour a model from the broken denture and duplicate the original. Here is the procedure:

A. Cut bar section completely off.



B. Hollow out lingual, carry to necks of teeth.

C. Do not touch bucal periphery or clasp.

D. Wax lingual completely with one sheet of base plate wax.



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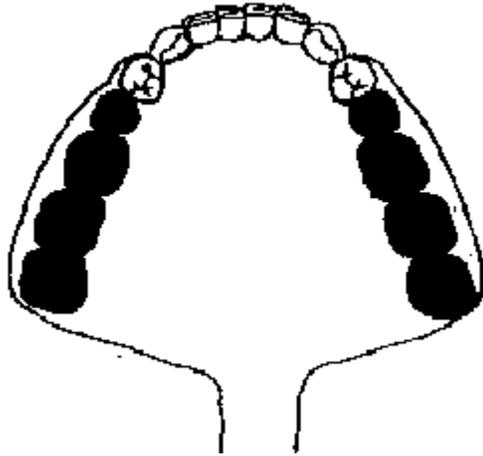
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E. Keep low at periphery.

F. Taper to entry hole of flask.

G. Invest and flask as usual.

H. Increase temperature 5-10 degrees for additions or add some additional minutes to oven time.

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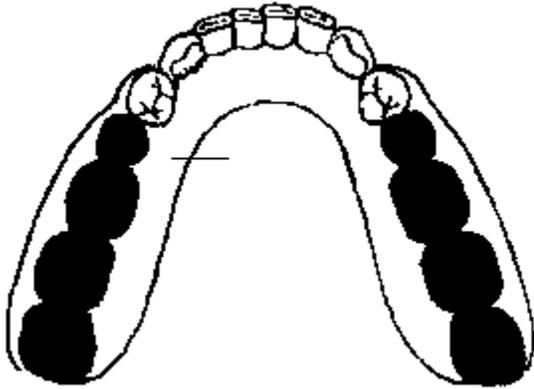
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I. Trim back creating new lingual area.

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TEMPERATURE CHART

INSTRUCTIONS FOR INJECTION GFM

FLEXILBE	550/300 FAHRENHEIT/Celsius	11-12 MIN
METRACYLATE	550/300 FAHRENHEIT/Celsius	20 MIN
D-FLEX	530/280 FAHRENHEIT/Celsius	15 MIN

Leave under pressure for 60 seconds and start the cooling process

REMOVE IMMEDIATELY AFTER THE COOLING PROCESS

Do not exceed more than 2-3 minutes in cold water

NEVER LEAVE CASES IN FLASK OVERNIGHT AS THE STONE GETS HARDER AND DIGGING OUT IS MORE DIFFICULT

Suggested Air/Ni pressure:

Suggested 130 lb



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TROUBLE SHOOTING CHART FOR GFM PLASTICS

TROUBLE POSSIBLE CAUSES REMEDY

Short incomplete

Wrong temperature Check Chart for Correct Temperature.

Cold Flasks Check lamps for proper heat. Flasks should be hot to the Touch.

Improper Sprues Use sheet of base plate wax for sprue. See page 10 in manual.

Wax up Too Thin Check areas where wax stretches in palate.

Not enough Pressure 145 lbs max. pressure for all plastics.

Left in oven too long Check proper time in oven.

Color Change

Overheating Bring Oven Down to Proper Temp.

Check proper length of time in oven.

Bubbles

Overheating Reduce Temperature or Time.

Streak or Silicone Grease Do not put silicone near entry hole



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Separations on Entry Side carry only to crimp on cartridge.
of Cartridge. Occasionally boil out steel chambers.

Raised Bites

Matrix Transfer Check Carefully. Cut away stone where

Not Accurate. interfering with bite.

Check Metal to Use Stone for Investing.

Metal Contact Follow Instructions in booklet, page 8 on Flasks. Ditch stone around edges to make sure upper and lower flasks are flush. Using 1/2 & 1/2 Correct by using **all** stone.
plaster/stone

TEETH POPPING OUT

No Diatorics present Create Diatorics. See page 6

ALL NYLON PLASTICS WILL BREAK:

- (1) If cooked in boiling water.
- (2) If under heated. Not heated to proper temperature to obtain the correct melt.
- (3) If sprued incorrectly. If you run two separate small sprues to either side of the horseshoe you will always have a weaker bond in the middle where the plastic meets. The reason is simple. It takes time for the plastic to flow into the horseshoe when you only have two small sprues. This gives the plastic time to cool down and so where the two separate plastics meet you do not always get a good bond. Also you may even see a small line where the plastic meets.