

PALAJet Injection Unit

step by step procedure

For Fabricated Dentures

STEP 1 - PREPARATION

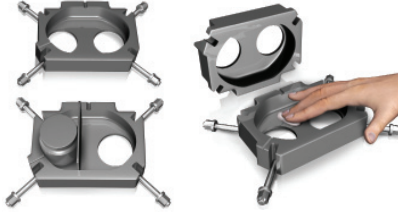
Dentures that are set up in wax are waxed-up anatomically to reduce finishing work.

DO NOT USE A SEPARATOR CONTAINING ALCOHOL BETWEEN STONE AND WAX (as this may cause discolorations on the denture's base surface).

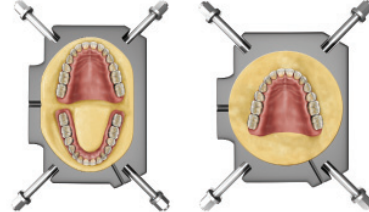


STEP 2 - FLASKING

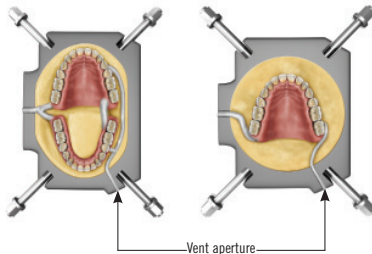
Prior to investing, make sure both flask halves have the same number to ensure a precise fit. Apply Vaseline to the inner surfaces so the stone can be easily removed. The duoflask is designed for the processing of two dentures at the same time. To process one denture in the duoflask, use the single denture spacer.



The waxed dentures must be invested with the arch facing to the outside of the flask. Use a class III stone for investing. Remove excess stone and produce smooth surface. Any stone residue must be removed from the edges of the flask.



The sprues are made after the stone has set. Provide the injection duct (7mm) and vent duct (3mm) with sprue wax. Choose shortest distance between denture and vent aperture.



Apply Aislar separating agent or Vaseline® to the surface of the stone.



Attach matching half flask and tighten the compression rings.



Pour stone through openings and fill the entire flask until the stone reaches the occlusal surface of the teeth. Apply Aislar separating agent and fill the remainder of the flask with stone. Remove excess stone from the flask so it will fit between the centering disks of the PALAJet.

STEP 3 - BOIL OUT



After stone has set, place flask in clean hot water (80°C/175°F) for approx. 5 minutes.



Open flask and remove the remaining wax with clean hot water.

STEP 4 - ISOLATION

Roughen the base surface of the teeth with a diamond rotary instrument to remove debris and to enhance the bond of the teeth to acrylic. (Never use carbide burs, they do not roughen the surface but rather create a smear layer.)



Isolate the hot stone by applying two thin coats of Aislar (let dry between coats, avoid puddles).



Apply two coats of Palabond to the surface and let dry between layers to enhance the bond between the teeth and the Palapress vario. AFTER PLACING THE SECOND LAYER, PALABOND WILL REMAIN ACTIVE FOR ABOUT 10 MINUTES!! Dentures must be processed before the 10 minutes.

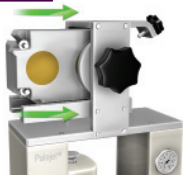


Close flask in preparation for injection.



STEP 5 - PREPARING, MIXING AND LOADING

PREPARE



Place the boiled out flask in the Palajet all the way to the stop screw.



Prepare the injection cylinder first. Place a plunger base into the cylinder sleeve. Press it all the way to the bottom stop.



Unscrew the metal cylinder lid from the injection cylinder and insert a nozzle lid into it.



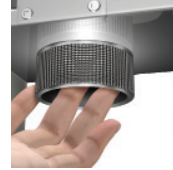
Place the steel injector sleeve over the nozzle.

LOAD



Insert the loaded injection cup into the metal injection cylinder all the way to the sealing lip stop.

Make sure the injection module is all the way back in the load position and the air control switch is in the down position. Place the prepared metal cylinder lid into the Palajet by turning it clockwise.



Check to ensure the plastic nozzle is in the flask.



Secure the flask with the centering disks by turning the flask holder knob clockwise.

MIX



Mix Palapress vario in the ratio of 2g powder : 1ml liquid. SAME LEVEL AS ON DOSING POT! Use clean measuring cups to measure acrylic and monomer.

Mix in clean ceramic bowl. POUR LIQUID FIRST, then powder. Mix gently to avoid bubbles. If desired, use vibrator at base to get rid of bubbles.



Pour the mix slowly into the prepared cylinder sleeve. DO NOT LET THE MIX RUN DOWN THE INNER WALL OF SLEEVE AND DO NOT CONTAMINATE THE SEALING LIP OF THE SLEEVE.



After the acrylic loses its sheen, place the prepared cylinder into the threaded lid of the Palajet.

STEP 7 - INJECTION

Pull the injector module into the injection position and flip the air control switch up to the inject mode.

Timing: Paladon - 15 mins.
Palapress vario - 5-10 mins.



After the mold is full, acrylic will escape through the ventilation channel, which is then closed by turning the vent knob clockwise.

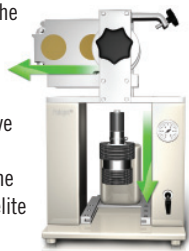


After specified time, flip the air control switch down.

Slide the injection module back to the load position. Remove the injection cup with the lid by turning it counter-clockwise.



Unscrew the centering disks to release and remove the flask. Place in the Palamat elite for final polymerization.



STEP 6 - POLYMERIZATION



Polymerization time is 30 minutes at 55°C/130°F and 2 bar/29 psi pressure.

After 30 minute polymerization time, take flask out of the Palamat elite and let it cool down to room temperature (30-60 minutes).



STEP 8 - FINISHING

Remove the compression rings with ring opener and deflask carefully. REMOVE STONE FROM THE FLASK WITH A PLASTIC HAMMER. DO NOT HIT THE FLASK WITH HAMMER!!



Take model with denture on articulator and check occlusion, then lift off denture from model.



The Palajet user instructions provide more detailed information.

PALA®

©2011 Heraeus Kulzer, LLC 300 Heraeus Way, South Bend, IN 46614
Phone: (800) 431-1785 Fax: (877) 271-5211 www.heraeusdentalusa.com

Vaseline® is a registered trademark of Unilever. 4000550 rev 3/2011