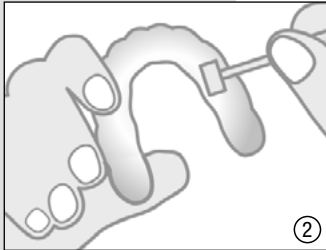
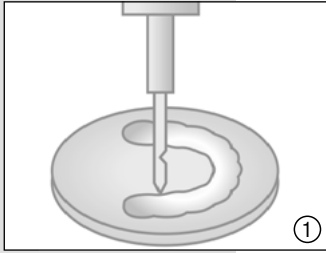


# DURASPLINT® flex milling blank

## Processing information



### for the preparation of occlusal splints

#### Product description

DURASPLINT® flex milling blanks are used for fabricating dental splints with thermal shape memory effect. DURASPLINT® flex occlusal splints are characterized by thermoplastic flexibility allowing an extremely precise fit to the individual dental condition and offering high tension-free wearing comfort for the patient.

Self-adjusting occlusal splints made of DURASPLINT® flex are extremely resistant to breakage and highly transparent. The industrial polymerization process guarantees highest material homogeneity and excellent long-term stability. The use of DURASPLINT® flex milling blanks in CAD/CAM technology ensures a secure process because mixing errors (for example by hand mixing) can be excluded. In addition, the typical smell occurring during mixing is avoided.

#### Processing

DURASPLINT® flex milling blanks can be used with all current CAD/CAM systems (fig. 1). Make sure to use exclusively carbide cutters for processing. For separating the DURASPLINT® flex splint from the milling blank, finely toothed carbide cutters should be used. Cut the supporting bars carefully and without applying any pressure. Careful polishing is crucial to prevent plaque accumulation.

Pre-polishing can be done using pumice stone. For high-gloss polishing we recommend customary polishing mops (fig. 2). Once the splints are finished, they can be cleaned with compressed air and subsequently with water in an ultrasonic bath.

#### Important

Steam cleaning units are not recommended because at high temperature and pressure the material tends to deformation. Improper use of milling tools, polishing brushes, steam jets and water baths may expose the material to overheating, thus impairing the material properties.

Any deviation from the described production process may result in modifications of the mechanical and optical properties of DURASPLINT® flex. The batch number and the expiry date can be found on the material packaging. In case of complaints, please make sure to indicate the batch number of the product. Do not use DURASPLINT® flex milling blanks after the expiration date.

No side effects of the material have been observed when it is properly processed and applied by a dentist, orthodontist or dental technician. In rare cases, immune reactions (e.g. allergies) may occur. In case of allergic patients, consult the dentist or orthodontist to make sure that DURASPLINT® flex can be used for the patient.

**Contraindications:** DURASPLINT® flex should not be used for any purposes other than the production of dental occlusal splints. The production of denture bases is contraindicated, as is the use of the material for the production of conventional splints. Undesirable biological reactions (e.g., allergies to material components) may occur in isolated cases. Occlusal splints made of DURASPLINT® flex are contraindicated in cases of known incompatibilities or allergies to material components.

#### Milling parameters:

##### Roughing:

- 2 mm ball cutter – one cutter
- Spindle peed: 22,000 rpm
- Radial milling distance: 0.6 mm
- Cut depth: 0.6 mm
- Feed rate: 1,600 mm/min

##### Finishing:

- 2 mm ball cutter – one cutter
- Spindle speed: 22,000 rpm
- Radial milling distance: 0.1 mm
- Cut depth: 0.1 mm
- Feed rate: 1,600 mm/min

##### Reroughing:

- 1 mm ball cutter – one cutter
- Spindle speed: 28,000 rpm
- Radial milling distance: 0.1 mm
- Cut depth: 0.1 mm
- Feed rate: 1,200 mm/min

The cooling nozzles located on the spindle should be aligned to the tool tip. A uniform extension length of the tools is important, related to the length of the 2 mm tool. Air cooling is sufficient.

#### Hint

To be used only for the above indication and by qualified personnel. For single use. Serious incidents in connection with the use of the product must be reported immediately to the manufacturer and the competent authority!

#### Delivery program:

DURASPLINT® flex milling blank		
DURASPLINT® flex milling blank	16 mm	REF 3619.1
DURASPLINT® flex milling blank	20 mm	REF 3620.1

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