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* This description does not replace the regular Instructions for Use, but are solely intended to visualize individual procedural steps.
Dentures with cast-metal frameworks

Cover the clasp-retained cast metal framework with self-curing opaque if required. No dispersion layer must be present after polymerizing the opaque, otherwise streaking may occur. Always use retention holes. In exceptional cases, use narrow ridge retentions whose shadows do not exceed 2 mm².

Precondition the cast and framework in the Eclipse® pre-heating oven at 55°C until the indicator has turned black.

Remove the cast but leave the framework in the oven. Measure out the baseplate material as needed. Place the baseplate material on the warm cast with the rounded side facing down. Wait briefly until the material has absorbed the heat of the cast. Then adapt, paying attention to the size of the saddle.

Close any retention in the casting using baseplate material. Smooth out the baseplate material with your fingers.

Paint the baseplate material with ABC varnish. Light-cure immediately in the Eclipse® polymerization unit (menu 3). After polymerization is complete, allow to cool to room temperature. Peel off or wash off the protective varnish. Leave the base on the cast and place in a lukewarm water bath for 10–15 minutes.

Remove the denture base from the cast, finish the margins and roughen the surface of the baseplate. Any whitish discolorations that may appear as a result of overheating during roughening must be removed in order to prevent them to be included in the polymerized base. Clean the base, first with water and then with propanole. Allow the cast to dry.

Boil out the denture teeth to completely remove all residual ways. Roughen the basal surfaces and create V-shaped undercuts using the diamond cutter that is part of the set.
Dentures with cast-metal frameworks

1. Roughen the denture teeth all around and create a groove, making sure the groove marks the end of the gingiva modellation (even interdentally).

2. Before the denture teeth can be set up, the mechanical retentions must be filled with setup material. Use an electric wax knife for this step to prevent air entrapments.

3. Form a wall from setup material and adapt it to the baseplate. After filling the retentions, use the electric wax knife to slightly melt the setup material and then press the teeth in. Avoid air entrapment. Remove any excess setup material with a cold instrument.

4. Melt contouring resin in the crucible at 87°C. Careful stirring may prevent the "veins" from setting. Caution: Excessive stirring may cause air to be trapped and may in due course result in air entrapments.

5. Use the electric wax knife to coat the denture with contouring resin. Allow the setup material and contouring resin to fuse. Add contouring resin even on the palatal aspect, including the interdental spaces. Avoid overcontouring. Use a clean, pointed, hard instrument for modelling. The material will be easier to handle if the workpiece is first placed in the refrigerator for 10 minutes.

6. Paint the denture with ABC varnish and place in the pre-heating oven for one hour. Light-cure immediately in the Eclipse® polymerization unit (menu 2).

7. After polymerization is complete, remove the cast and allow to cool to room temperature. Peel off or wash off the protective varnish. Leave the base on the cast and place in a lukewarm water bath for 10–15 minutes. Remove from the cast and finish.

8. Polish with pumice and regular polishing brushes. Use a buff wheel for high-lustre polishing.
Combination dentures

Apply two thin layers of Al-Cote separating agent to the dry cast. Allow each separating layer to air-dry well. Attach temperature indicator. Apply opaque to the framework if required. The opaque must be light-curing. No dispersion layer must be present after polymerizing the opaque, otherwise streaking may occur.

Pre-condition the cast and framework in the Eclipse® pre-heating oven at 55°C until the indicator has turned black. Remove the cast from the oven and immediately start applying the baseplate material. Leave the framework in the pre-heating oven.

Measure out the Eclipse® baseplate material as needed. Hint: Place the baseplate material in the refrigerator for a few minutes. The colder material will be easier to break into pieces.

Place the base material on the warm cast with the rounded side facing down. Wait briefly until the material has absorbed the heat of the cast. Adapt the material until it has the desired shape. Remove any excess material with a cold instrument.

Remove the cast-metal framework from the pre-heating oven and slowly press into the baseplate material while the framework is still warm. No shadows may be created in excess of 2 mm. Retention holes are recommended. After completion, the frameworks should be veneered with Eclipse®.

The baseplate material must be pressed through the retention mesh.

Close any retention in the casting using baseplate material. Smooth out the baseplate material with your fingers and paint it with ABC varnish.

Light-cure immediately in the Eclipse® polymerization unit (menu 3). After polymerization is complete, allow to cool to room temperature. Peel off or wash off the protective varnish. Leave the base on the cast and place in a lukewarm water bath for 10–15 minutes.
Remove the denture base from the cast, finish the margins and cut back as required.

Roughen all of the baseplate material. Any whitish discolorations that may appear as a result of overheating during roughening must be removed in order to prevent them to be included in the polymerized base. Clean the base first with water and then with propanole. Allow the cast to dry.

Boil out the denture teeth to completely remove all residual ways. Roughen the basal surfaces and create V-shaped undercuts using the diamond cutter that is part of the set.

Roughen the denture teeth all around and create a groove, making sure the groove marks the end of the gingiva modellation (even interdentally).

Form a wall from setup material and adapt it to the baseplate.

Before the denture teeth can be set up, the mechanical retentions must be filled with setup material. Use an electric wax knife for this step to prevent air entrapments.

After filling the retentions, use the electric wax knife to slightly melt the setup material and then press the teeth in. Avoid air entrapment. Remove any excess setup material with a cold instrument.

Melt contouring resin in the crucible at 87°C. Careful stirring may prevent the "veins" from setting. Caution: Excessive stirring may cause air to be trapped and may in due course result in air entrapments.
Combination dentures

Use the electric wax knife to coat the denture with contouring resin. Allow the setup material and contouring resin to fuse.

Add contouring resin even on the palatal aspect, including the interdental spaces. Avoid overcontouring. Use a clean, pointed, hard instrument for modelling. The material will be easier to handle if the item is first placed in the refrigerator for 10 minutes.

Paint the denture with ABC varnish and place in the pre-heating oven for one hour. Light-cure immediately in the Eclipse® polymerization unit (menu 2).

After polymerization is complete, remove the cast and allow to cool to room temperature. Peel off or wash off the protective varnish. Leave the base on the cast and place in a lukewarm water bath for 10–15 minutes. Remove from the cast and finish.

Polish with pumice and regular polishing brushes. Use a buff wheel for high-lustre polishing.

The completed restoration.

For additional information see Section 9, “Troubleshooting”.
Apply cuts on the dorsal aspect of the mandibular cast. Reduce any reflection folds that are deeper than 2 mm to a maximum of 2 mm. In case of undercuts, duplicate the cast first. Fabricate the baseplate on the duplicate cast (which is subsequently destroyed, with the base then being adapted to the modified master cast). Attach the temperature indicator. Apply Al-Cote separating agent onto the cast.

Pre-condition the cast and framework in the Eclipse® pre-heating oven at 55°C until the indicator has turned black. Remove the cast from the pre-heating oven and immediately start applying the baseplate material.

Place the baseplate material on the warm cast with the rounded side facing down.

Wait briefly until the material has absorbed the heat of the cast, then adapt the baseplate material. Begin adapting in the vestibular region and then cover the palatal region.

Displace any excess material dorsally and adapt it to the dorsal cuts. This prevents the A line from being lifted during polymerization.

Wet the baseplate with ABC varnish. Light-cure immediately in the Eclipse® polymerization unit (menu 1). After polymerization is complete, allow to cool to room temperature.

To ensure the best possible fit, leave the baseplate on the cast for up to 24 hours before lifting it off. Remove the dorsal excess with a cutting disk. Lift off the baseplate and finish.

Attach a wax wall to the baseplate and return the cast for bite registration. Mount the cast in an articulator.
Boil out the denture teeth to completely remove all residual ways. Roughen the basal surfaces and create V-shaped undercuts using the diamond cutter that is part of the set.

Roughen the denture teeth all around and create a groove, making sure the groove marks the end of the gingiva modellation (even interdentally).

Remove the wax wall with a knife. Remove all residual wax with steam cleaner or boiling water. Leave the baseplate on the cast as you do this. Roughen all of the baseplate material. Any whitish discolorations that may appear as a result of overheating during grinding/roughening must be removed in order to prevent them to be included in the polymerized base.

Measure out the setup material with a cold instrument.

Clean the baseplate, first with water and then with propanole. Allow the baseplate to dry.

Form a wall from setup material and adapt it to the baseplate.

Before the denture teeth can be set up, the mechanical retentions must be filled with setup material. Use an electric wax knife for this step to prevent air entrapments.

After filling the retentions, use the electric wax knife to slightly melt the setup material and then press the teeth in. Avoid air entrapment.
Remove any excess setup material with a cold instrument.

Complete the denture tooth setup in the setup material.

Melt contouring resin in the crucible at 87°C. Careful stirring may prevent the “veins” from setting. Caution: Excessive stirring may cause air to be trapped and may in due course result in air entrapments.

Add contouring resin to the denture body using the electrical wax knife. Make sure to allow the setup material and contouring resin to fuse. Cover the baseplate with contouring resin. Leaving the palate free may improve the fit. Add material to the interdental spaces as well.

Adding the papillae and alveoli.

The wax model is smoothened with a hot-air gun. Caution: Excessive heat may promote air entrapments in the contouring resin.

Remove any excess setup material with a cold instrument, making sure to include the palatal side.

Add contouring resin even on the palatal aspect. Leave the palate free. Of course, it is also possible to create an individual palatal design should the customer desire this. Create a chamfer in the baseplate and fill with contouring resin.
Avoid overcontouring. Use a clean, pointed, hard instrument for modelling. The material will be easier to handle if the item is first placed in the refrigerator for 10 minutes.

Make sure to return the denture for try-in using only completely opaque bags or boxes. If any of the denture teeth must be moved, remove the teeth, fill the retentions, add new setup material, and set up the teeth.

After try-in, disinfect the dentures and carefully clean it using water and a natural-bristle brush. Paint the denture with ABC varnish and place in the pre-heating oven for at least one hour. Longer pre-heating times (4 hours) may improve the fit of the restoration.

Wet the entire denture margin with MRA and fixate it with Eclipse® Gel, thus making sure that the baseplate will not be lifted off during polymerization.

Light-cure immediately in the Eclipse® polymerization unit (menu 2).

After polymerization is complete, remove the cast and allow to cool to room temperature. Peel off or wash off the protective varnish. Leave the base on the cast and place in a lukewarm water bath for 10–15 minutes. Finish. Polish with pumice and regular polishing brushes. Use a buff wheel for high-lustre polishing.

For additional information see Section 9, “Troubleshooting”.

PROSTHETIC RESIN SYSTEM
Survey the cast and indicate the tooth equator. In the anterior region, the margin of the splint should align with the tooth equator, while in the posterior region it should run approximately 1–2 mm below the tooth equator. Apply a wax cuff that follows this line exactly. Block out any undercuts.

Duplicate the cast and apply Al-Cote separating agent. Attach the temperature indicator. Pre-condition the cast and framework in the Eclipse® pre-heating oven at 55°C until the indicator has turned black. Remove the cast from the pre-heating oven and immediately start applying the splint material.

Place the splint material on the warm cast with the rounded side facing down. Wait briefly until the material has absorbed the heat of the cast, then adapt to the desired form by pressing with your fingers.

Isolate the opposing cast with MRA and lower according to the edge-to-edge relation of the splint. To avoid adhesion, press the opposing cast only briefly into the soft material and re-open the articulator immediately. As soon as the desired occlusal height and any impressions and canine guidance have been created, place the cast and splint in the refrigerator for 5–10 minutes. Perform the necessary movements and excursions on the articulator and check the splint accordingly.

The splint with impressions.

Light-cure immediately in the Eclipse® polymerization unit (menu 7). After polymerization is complete, allow to cool to room temperature. Peel off or wash off the protective varnish. Leave the splint on the cast and place in a lukewarm water bath for 10–15 minutes.

Paint the splint with ABC varnish.
Splints

Finish the splint on the articulator.

Determine the lateral extension of the splint.

Remove the splint from the cast and finish. Polish with pumice and regular polishing brushes. Use a buff wheel for high-lustre polishing.

The completed splint on the master cast.

The completed splint on the duplicate cast.

For additional information see Section 9, “Troubleshooting”.
Drilling stents

Create parallel bores in the model according to the dentist’s instructions. Attach temperature indicator.

Insert the analogues in the cast, then fit the bore guides over them.

Apply two thin layers of Al-Cote separating agent to the dry cast. Allow each separating layer to air-dry well. Pre-condition the cast and framework in the Eclipse® pre-heating oven at 55°C until the indicator has turned black. Remove the cast from the oven and immediately start applying the transparent baseplate material.

Place the transparent base material on the warm cast with the rounded side facing down. Wait briefly until the material has absorbed the heat of the cast, then adapt to the desired form by pressing with your fingers.

Adapted drilling stent.

Paint the drilling stent with ABC varnish. Light-cure immediately in the Eclipse® polymerization unit (menu 7). After polymerization is complete, allow to cool to room temperature. Peel off or wash off the protective varnish. Leave the drilling stent on the cast and place in a lukewarm water bath for 10–15 minutes.

Remove the drilling stent from the cast and finish. Polish with pumice and regular polishing brushes. Use a buff wheel for high-lustre polishing.

The finished and polished drilling stent.
Provisionals

Baseline situation.

Provisionals (1–3 teeth) can be fabricated without clasps due to their excellent fit. But clasps can be added if needed; bend them into the desired shape before adapting the baseplate material.

Use an instant adhesive to attach the clasps on the vestibular aspects of the clasp tooth.

Attach the temperature indicator. Precondition the cast and framework in the Eclipse® pre-heating oven at 55°C until the indicator has turned black. Remove the cast from the oven and immediately start applying the baseplate material.

Remove all residual wax from the tooth. Roughen the basal surface and create V-shaped undercuts using the diamond cutter that is part of the set.

Roughen the denture teeth all around and create a groove, making sure the groove marks the end of the gingiva modellation (even interdentally).

Heat the fracture area with a hot-air gun before applying the baseplate material.
Measure out the Eclipse® baseplate material as needed. Hint: Place the baseplate material in the refrigerator for a few minutes. The colder material will be easier to break into pieces.

Apply the baseplate material (rounded side down) in the desired position.

Push baseplate material forward to the edentulous areas.

Heat the basal surfaces of the teeth with a hot-air gun.

Press the tooth into the baseplate material, moving it into the desired position. A silicone index can be used if desired, as long as these are removed before polymerization (important!).

Positioning the premolars.

Remove any excess material with a cold instrument.

A regular wax knife can be used for shaping the gingiva.
Paint the provisional with ABC varnish. Light-cure immediately in the Eclipse® polymerization unit (menu 2). After polymerization is complete, allow to cool to room temperature. Peel off or wash off the protective varnish. Leave the base on the cast and place in a lukewarm water bath for 10–15 minutes.

Carefully lift the provisional off the cast. Finish the provisional. Polish with pumice and regular polishing brushes. Use a buff wheel for high-lustre polishing.

For additional information see Section 9, “Troubleshooting”.

The completed provisional.
Repair

1. Widen the fracture. Grind a border/termination resembling a chamfer. Clean the fragments first with water and then with propanole.

2. Apply Al-Cote separating agent onto the cast. Apply temperature indicator. Pre-condition the cast in the Eclipse® pre-heating oven at 55°C until the indicator has turned black.

3. Measure out the baseplate material. Hint: Place the baseplate material in the refrigerator for a few minutes. The colder material will be easier to break into pieces.

4. Heat the fracture area with a hot-air gun. Adapt baseplate material to the fracture area.

5. Smoothen out the baseplate material.

6. Paint the denture body with ABC varnish.

7. Light-cure immediately in the Eclipse® polymerization unit (menu 5). Allow the denture to cool. Remove from the cast. Paint the tissue side with ABC protective varnish and re-polymerize with the tissue side facing up (menu 6). Immediately remove the denture, return it to the cast, allow to cool and place in a lukewarm water bath for 10–15 minutes.

8. Finish the denture. Polish with pumice and regular polishing brushes. Use a buff wheel for high-lustre polishing.
Create a split-cast working cast for the denture to be rebased.

Fixate the cast with the denture and rebasing impression in the fixator.

Lock the denture in the fixator.

Open the fixator and remove the denture from the cast. Remove the rebasing material and roughen the basal surface. Cut a delineating margin into the denture body in the vestibular region. Clean the denture using water and propanole. Allow to dry.

Apply Al-Cote separating agent onto the cast. Apply temperature indicator.

Pre-condition the cast and framework in the Eclipse® pre-heating oven at 55°C until the indicator has turned black. Remove the cast from the oven and immediately start applying the baseplate material.

Place the roughened denture base on the counterplate and heat with a hot-air gun.

Place the baseplate material on the warm cast with the rounded side facing down. Wait briefly until the material has taken on the temperature of the cast. Then adapt the baseplate material.
Rebasing

1. Press the pre-heated denture onto the cast with the base and clamp it in place in the fixator. Place the fixator in the refrigerator for a few minutes so the material can set. Open the fixator and remove the cast.

2. Paint the denture margins with ABC varnish.

3. Light-cure immediately in the Eclipse® polymerization unit (menu 4).

4. After polymerization, place the cast in a lukewarm water bath for 10–15 minutes. Lift the rebased denture from the cast and clamp it in place in the top part of the fixator, with the tissue side facing up. Hint: Remove the counterplate from the fixator and use it to fix and polymerize the denture (menu 6). Allow to cool, then finish and polish.

For additional information see Section 9, “Troubleshooting”.
## Frequently asked questions

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<td>Air bubbles in the baseplate or splint material.</td>
<td>Baseplate material was adapted too quickly.</td>
<td>Allow the baseplate material to rest on the cast so it can absorb the heat of the cast and is easier to adapt. Try adapting the baseplate material in only one direction.</td>
</tr>
<tr>
<td>Baseplate material cannot be adapted.</td>
<td>Cast is too cold.</td>
<td>Work on warm casts only. Wait for the temperature indicator to turn black.</td>
</tr>
<tr>
<td>Baseplate material is viscous and sticky as it is taken out of the packaging.</td>
<td>Incorrect storage (too hot).</td>
<td>Store the material at 17–21°C.</td>
</tr>
<tr>
<td>Setup material is sticky.</td>
<td>Incorrect storage (too hot).</td>
<td>Store the material at 17–21°C. Measure out with a cold instrument</td>
</tr>
<tr>
<td>Some of the baseplate material has not polymerized (in the reflection fold or under the cast framework retentions).</td>
<td>Shadow areas too large.</td>
<td>Reduce the height of the reflection fold to 2 mm. When designing cast-metal frameworks, make sure that the shadow areas of the retentions do not exceed 2 mm².</td>
</tr>
<tr>
<td>Irregular baseplate surface (map-like) in complete dentures.</td>
<td>Incorrect isolation.</td>
<td>Use only Al-Cote separating agent. Use only one layer.</td>
</tr>
<tr>
<td>Baseplate breaks as it is lifted off the cast.</td>
<td>Undercuts.</td>
<td>Create a duplicate cast Destroy the duplicate cast to lift off the baseplate and adapt the baseplate to the modified master cast.</td>
</tr>
<tr>
<td>White discolouration spots in the baseplate material.</td>
<td>Heat was generated during roughening/grinding.</td>
<td>Reduce instrument speed during roughening.</td>
</tr>
<tr>
<td>White discolouration spots in the contouring material.</td>
<td>Incorrect crucible temperature setting.</td>
<td>Add contouring resin at 90°C, then fuse with the setup material.</td>
</tr>
<tr>
<td>Whitish bubbles in the contouring material.</td>
<td>Teeth incorrectly repositioned.</td>
<td>When repositioning teeth, always remove them from the contouring resin and set them up from scratch, using the electrical wax knife. Stir the contouring resin in the crucible slowly to avoid air entrapments.</td>
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<td>A line lifts off.</td>
<td>1. Baseplate material not adapted to the dorsal notches on the cast.</td>
<td>1. Adapt the baseplate material to the dorsal notches on the cast.</td>
</tr>
<tr>
<td></td>
<td>2. Baseplate lifted off too soon after polymerization.</td>
<td>2. The baseplate to remain on the cast for one day after polymerization.</td>
</tr>
<tr>
<td></td>
<td>3. Baseplate material too thick in the area of the A line.</td>
<td>3. Make sure the baseplate material is not too thick in the area of the A line.</td>
</tr>
<tr>
<td></td>
<td>4. Conditioning time in the pre-heating oven too short.</td>
<td>4. Extend the conditioning time in the pre-heating oven (at least 4 hours).</td>
</tr>
<tr>
<td>Teeth have broken out.</td>
<td>Incorrectly designed or missing retentions.</td>
<td>Always create a groove in the cervical area and V-shaped undercuts in the basal area. Make sure to fill the basal retentions with setup material.</td>
</tr>
<tr>
<td>Modelling problems.</td>
<td>Too much contouring resin volume.</td>
<td>Carefully adapt the contouring resin. Finish the wax model with a cold, pointed instrument.</td>
</tr>
<tr>
<td>Denture body shows different colours.</td>
<td>Incorrect colour assignment.</td>
<td>Make sure the colour codes for all three materials agree.</td>
</tr>
<tr>
<td>Traces of the opaque within the resin.</td>
<td>Unsuitable opaque used.</td>
<td>Use only light-curing opaques. No dispersion layer must be present after polymerizing the opaque.</td>
</tr>
<tr>
<td>Difficulties lifting a polymerized item from the cast.</td>
<td>Soaking omitted or incorrect or missing separating agent.</td>
<td>Isolate casts before adapting the baseplate material. Use only Al-Cote separating agent. Soak casts in a hand-warm water bath for 10-15 minutes before lifting off the baseplate.</td>
</tr>
<tr>
<td>Problems while finishing the occlusal surface of a splint.</td>
<td>Missing separating agent on the opposing cast. Occlusal check of the opposing cast took too long.</td>
<td>Always isolate using MRA. Use short, controlled movements to check the occlusion.</td>
</tr>
<tr>
<td>Flowout of the occlusal surface of a splint.</td>
<td>Splint was not polymerized immediately after finishing the occlusal surface.</td>
<td>Polymerize the splint immediately after finishing the occlusal surface.</td>
</tr>
<tr>
<td>Baseplate materials in a repair job do not fuse.</td>
<td>Improper cleaning. Fracture surfaces were not heated before adapting the baseplate material.</td>
<td>Carefully clean the fracture surfaces with water and alcohol. Pre-heat the fracture surfaces with a hot-air gun.</td>
</tr>
</tbody>
</table>
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<td>Broken denture.</td>
<td>Denture was stored in a place that was too dry.</td>
<td>Store dentures only in a moist environment.</td>
</tr>
<tr>
<td>Broken splint.</td>
<td>Cast improperly blocked out or surveyed.</td>
<td>Blocked out and survey the cast properly.</td>
</tr>
<tr>
<td>Insufficient lustre.</td>
<td>Buff wheel dirty.</td>
<td>Use a clean buff wheel.</td>
</tr>
<tr>
<td>Plaque deposits or crack formation at the tooth joints.</td>
<td>Denture teeth were not roughened all around and no groove was created.</td>
<td>All areas of the tooth that come in contact with the Eclipse material must be roughened. A groove must mark the end of the gingiva modellation (even interdentally).</td>
</tr>
<tr>
<td>Discoloured contouring resin after polymerization.</td>
<td>Cleaning and disinfection after try-in was omitted.</td>
<td>Clean and disinfect the item after try-in.</td>
</tr>
<tr>
<td>Discoloured contouring resin in the crucible.</td>
<td>Incorrect temperature setting.</td>
<td>Do not exceed a temperature setting of 87°C. Do not leave the contouring resin in the crucible for longer than 24 hours. Clean the crucible daily. Ensure cleanliness in the workplace. Do not stir too hard. Do not scratch the crucible walls.</td>
</tr>
<tr>
<td>Plaster particles in the baseplate material.</td>
<td>Incorrect plaster used.</td>
<td>Use only Class IV dental stone.</td>
</tr>
<tr>
<td>Bubble formation during polymerization.</td>
<td>ABC protective varnish omitted.</td>
<td>Paint with ABC varnish before each polymerization step.</td>
</tr>
<tr>
<td>Denture base not completely polymerized.</td>
<td>Two or more casts were placed into the polymerization unit.</td>
<td>Polymerize one item at a time.</td>
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## Basic rules

1. Always work on a warm model.
2. For repairs and rebasing, make sure to pre-heat the denture body as well (hot-air gun at level 2).
3. Always allow the cast to cool after polymerization.
4. Soak the cast before removing an item (for approximately 10–15 minutes).
5. Before measuring out the material, place it in the refrigerator for a few minutes. Otherwise, store at 17– 21°C.
6. Roughen teeth mechanically (create a groove in the cervical area and V-shaped undercuts).
7. Use only setup material for denture tooth setup.
8. Add contouring material at 87°C.
9. Finish the wax model with pointed hard instruments after having placed the cast in the refrigerator for 10 minutes. Or use an electrical wax knife.
10. If teeth must be repositioned, remove them completely, heat the baseplate material and redo the setup.