

Tips for finishing Compartis Ti frameworks

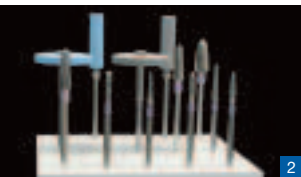
The current Compartis finishing Instructions must be followed when finishing Compartis Ti frameworks.



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Bridge as supplied

You may be able to detect slight machining marks on the inside of the crown. Therefore, the first step is to sand-blast the inside with approx. 50 µm aluminium oxide at 1.5 bar. Some minor faults may still be visible, which must be removed with a hard-metal cutter suitable for titanium until the framework fits on the die.



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TwisTec Titanium Set

The titanium set contains eight TC cutters and four rubber discs for finishing all standard titanium dental alloys. The different cutting geometries are specially designed for the material surfaces.

TC cutters

REF	Spiral cut, superfine
5990 0023	Cone, Ø 2,3 mm
5990 0024	Torpedo, Ø 2,3 mm
5990 0025	Cone, Ø 1,6 mm
5990 0028	Cylinder, Ø 2,3 mm
5990 0029	Cone, Ø 4,0 mm
REF	Spiral cut, fine
5990 0050	Cone, Ø 2,3 mm
5990 0051	Bud, Ø 6,0 mm
5990 0052	Cone, Ø 4,0 mm

Polishers

REF	Shape / Type
5990 2020	Wheel, grey, Ø 22,0 mm
5990 2021	Cylinder, grey, Ø 6,0 mm
5990 2022	Wheel, blue, Ø 22,0 mm
5990 2023	Cylinder, blue, Ø 6,0 mm

Mandrels

REF	Shape / Type
5990 9002	Screw mandrel, Ø 5,0 mm
5990 9004	Twist mandrel, Ø 5,0 mm



Finishing Instructions

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Grinding the frameworks

Fit the margin exactly to the preparation margin and make any required corrections. Compartis titanium frameworks must only be trimmed with cross-serrated hard-metal cutters suitable for trimming titanium. Press lightly on the framework while grinding and work in one direction only.



Sand-blasting the frameworks

Caution: rework may be required, particularly in the region of the connectors and the basal surfaces of the pontics, if designing was completed in Cercon art without the smoothing function.

To prepare for veneering, first sand-blast the framework carefully with aluminium oxide (100 – 150 µm and 2 bar pressure) and clean it with a steam cleaner. Trimmed titanium surfaces should be left for 10 to 15 minutes after trimming and sand-blasting for passivation of the surface.



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