+ Pekkton® ivory –
Instructions for use.
Pressing technique with
PEKKtherm and PEKKpress.

Pekkton®
Index

1 Product name 3
2 Product description 3
3 General information 3
   3.1 Intended use 3
   3.2 Disposal 3
4 Instructions for use 3
   4.1 Indications 3
   4.2 Contraindications 3
   4.3 Warnings 3
   4.4 Preventive measures 3
   4.5 Side effects 3
5 Processing instructions 4
   5.1 Technical parameters 4
   5.2 Preparation 4
   5.3 Framework criteria 4
   5.4 Model and stump preparation 5
      5.5 Manufacturing by pressing 5
         5.5.1 Equipment 5
         5.5.2 Waxing 6
         5.5.3 Sprueing 7
         5.5.4 Investing 8
         5.5.5 Preheating 8
         5.5.6 Pressing 11
         5.5.7 Divestment and cleaning 12
   5.6 Conditioning 13
   5.7 Veneering 14
      5.7.1 Preparation 14
      5.7.2 Veneering concepts 14
   5.8 Cementation 15
   5.9 Handling after integration 15
      5.9.1 Cleaning and follow-up 15
      5.9.2 Traceability 15
6 Ordering information 16
7 Symbols 17
8 Disclaimer / Validity 17
9 Availability 17
10 Copyright and trademarks 17
11 Further information 18
   11.1 Troubleshooting 18
   11.2 FAQ's 19
   11.3 Acknowledgements 19
1 Product name
Pekkton® ivory (pressing blanks)

2 Product description
Pekkton® ivory is a material based on PEKK composed of OXPEKK® IG1 (Implantable Grade with pur material) and Titanium Dioxide for the determination of tint and mechanical properties. Color: whitish.

The material is available to users as a pressing blank. The dental technician fabricates crown and bridge frameworks from the pressing blank. The frameworks are then esthetically veneered in the laboratory with bonded pressable crowns, veneering composites, prefabricated acrylic teeth or trays.

3 General information
For the exact specifications of Pekkton® ivory, please refer to the material data sheet and the safety data sheet. You will find the data sheets mentioned free of charge at www.pekkton.com.

Important information for the specialist / note instructions for use.

Warning symbol for increased caution.

3.1 Intended use
Pekkton® ivory is intended for use with fixed (crowns and bridges) and removable dental prostheses.

3.2 Disposal
Pekkton® waste can be disposed of along with normal household garbage.

4 Instructions for use
4.1 Indications
(Pekkton® ivory)
– Definitive supported and veneered crowns and bridges with maximum two pontics. Can be veneered with bonded press crowns, with composites or prefabricated acrylic teeth and veneers.
– Definitive supported, veneered single crowns and bridges with maximum one pontic on natural teeth.
– Removable restorations such as secondary constructions on bars and telescopic crowns, transversal connectors, occlusal splints and denture bases.

⚠️ The responsibility for the use of custom-made products beyond the described indications lies with the dentist.

4.2 Contraindications
(Pekkton® ivory)
– When patients have a known allergy to one or more components of the material.
– Patients with parafunctions e.g. bruxism.
– Crowns and bridges with less than 1.3 mm of occlusal space.
– When the minimum dimensions of the framework cannot be maintained:
  – Minimum circular wall thickness less than 0.6 mm.
  – Minimum occlusal wall thickness less than 0.8 mm.
  – Connector dimensions of front (anterior) bridges less than 12 mm²
  – Connector dimensions of side (posterior) bridges less than 14 mm²
– Bridges on implants with more than two intermediate elements or extensions.
– Bridges on natural teeth with more than one intermediate element or extension.
– Unveneered crowns and bridges with a wearing period of more than 12 months.

4.3 Warnings
If patients are allergic to one or more elements of the material, the latter should not be used. In patients with suspected allergy to one or more elements of the materials, this product may only be used following allergological clarification and proof of non-existence of an allergy.

Pekkton® ivory has not been evaluated for safety and compatibility in the MR environment. Pekkton® ivory has not been tested for heating or migration in the MR environment.

For further information, please contact your Cendres+Métaux representative.

A professional dentist and dental technician know-how is required. The instructions for use must be available and understood before the first application. The manufacturing work must be carried on by qualified specialists.

4.4 Preventive measures
When grinding the Pekkton® framework, wear protective goggles with a dust mask and use a suction unit.

4.5 Side effects
No known side effects if used as intended.

1 Pekkton® based on OXPEKK® from OPM, Oxford Performance Materials, USA.
5 Processing instructions
5.1 Technical parameters
Please refer to Data Sheet «Pekkton® ivory – Material Data Sheet» following URL: www.cmsa.ch/docs
Document Type: Factsheet, Product category: Pekkton®

5.2 Preparation

Any reduction in framework thickness always means a reduction in strength.
This aspect must be considered in the preparation, in particular within the occlusal area.
The height of the crown die preparation should be at least 4 mm and the angle of convergence should be 4 – 6°.
Eliminate undercuts.

Principally, the preparation technology corresponds to the one of full ceramic reconstructions.
The preparation is based on the concept of reduced, anatomical form. A chamfer preparation in the angle of approx. 10 – 30° or a shoulder preparation with rounded inside edges is ideal. The width of the chamfer/shoulder is approx. 0.8 mm.

5.3 Framework criteria

The key for clinical success and a durable restoration in the patient’s mouth is compliance with the guidelines for the design of a crown or bridge in Pekkton®.
The change from framework to veneering material may not occur in the functional contact area.
In there is a lack of space, please respect the maximal possible framework thickness. For an optimal color reproduction, a veneering thickness of 0.5 mm is recommended.
The occlusal minimum thickness of a crown should be < 1.3 mm.

Material thickness of the frameworks

<table>
<thead>
<tr>
<th>Pekkton® ivory</th>
<th>Crown</th>
<th>Posterior tooth</th>
<th>Bridge</th>
<th>Posterior tooth</th>
</tr>
</thead>
<tbody>
<tr>
<td>Design type</td>
<td>Tooth shape-supporting</td>
<td>Cusp supporting</td>
<td>Tooth shape-supporting</td>
<td>Cusp supporting</td>
</tr>
<tr>
<td>Minimum wall thickness circular</td>
<td>&gt; 0.6 mm</td>
<td>&gt; 0.6 mm</td>
<td>&gt; 0.6 mm</td>
<td>&gt; 0.6 mm</td>
</tr>
<tr>
<td>Minimum wall thickness occlusal</td>
<td>&gt; 0.8 mm</td>
<td>&gt; 0.8 mm</td>
<td>&gt; 0.8 mm</td>
<td>&gt; 0.8 mm</td>
</tr>
<tr>
<td>Connector dimensions</td>
<td>–</td>
<td>–</td>
<td>&gt; 12 mm²</td>
<td>&gt; 14 mm²</td>
</tr>
</tbody>
</table>

The stability of the connector surface is increased when the ratio of vertical to horizontal is significantly greater (ratio of approx. 60 % to 40 %).
5.4 Model and stump preparation
Careful preparation of the work models is required to obtain a well fitting crown or bridge.
The dies must fit reproducibly and be removable.
It is advisable to apply a sealer to harden the surface and to protect the die.

Two layers of spacer are applied to maximum 1 mm from the preparation margin.

5.5 Manufacturing by pressing
5.5.1 Equipment

PEKKtherm
The device makes it easy and safe to stabilize the muffle temperature (out of the preheating furnace) to the pressing temperature, which is 385°–395°C depending on the size of the cylinder. Pekkton® ivory is then melted before the pressing process.

The device is distributed exclusively by Cendres+Metaux SA. The manufacturer is Effegi Brega srl, IT-29010 Sarmato.

Please follow the included operating instructions from the manufacturer when operating the device.

PEKKpress
This device is used to efficiently and gently inject Pekkton® ivory after the material and muffle have been prepared in the PEKKtherm device.

The device is distributed exclusively by Cendres+Metaux SA. The manufacturer is Effegi Brega srl, IT-29010 Sarmato.

Please follow the included operating instructions from the manufacturer when operating the device.
5.5.2 Waxing

Only use wax that can be burned out without leaving a residue.

Design the caps and bridge elements in accordance with the basic principle of the maximum possible framework thickness, as well as the cusps-supported reduced tooth form. Avoid dirt-collecting recesses on the gingival design when modeling the pontics.

A thin garland can be designed circularly or partially on the posterior tooth. In case of insufficient space, a direct stop can also be prepared.

⚠️ For larger bridge work, form the palatal / lingual part in the framework material Pekkton® ivory in favor of a maximum possible framework thickness and do not veneer.

### Removable restoration

⚠️ Long-term stability depends on the dimensions and design of the restoration. Ideally, the cross-section of a Pekkton® ivory framework should be minimally increased by a factor of 1.5 in contrast to working with metal alloys.

#### Posterior tooth (molar)
- Buccal
- Palatinal/lingual

#### Anterior tooth
- Labial circular tapered edge design
- Palatinal/lingual mini edge (garland)

- Buccal/labial
- Palatinal/lingual

- After pressing, Conditioned on the model.
- Finished and polished Pekkton® ivory bridge.
#### 5.5.3 Sprueing

The sprues should be attached in an angle of 5–10°, similar to the indications for press ceramic systems.

- It is essential to avoid sharp edges because when pressing viscous Pekkon® investment material can be entrained. This can prevent inclusions, especially in the marginal zone. Respect the length of the press channel to avoid loss of pressure.

<table>
<thead>
<tr>
<th>Single crowns and smaller bridges</th>
<th>Large bridges and removable restoration</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Ring system recommendation</strong></td>
<td>PEKKpress mould set 200g Order No. 08000628</td>
</tr>
<tr>
<td></td>
<td>Pressplunger, Diameter 12 mm Order No. 08000626</td>
</tr>
<tr>
<td></td>
<td>Manufacturer: Cendres + Métaux SA</td>
</tr>
<tr>
<td><strong>Diameter of the wax wire</strong></td>
<td>Supply to the object: 3 – 3.5 mm Ventilation: For bridge elements Air outlets (0.8 – 1 mm) to prevent bubbles.</td>
</tr>
<tr>
<td><strong>Sprue point at the object</strong></td>
<td>Single crown: Aligned with the die. Bridge: Attach to the thickest connection point.</td>
</tr>
<tr>
<td><strong>Sprue angle to investment ring base</strong></td>
<td>In a small angle of approx. 5–10°</td>
</tr>
<tr>
<td><strong>Press channel</strong></td>
<td>Position centrally in the cylinder</td>
</tr>
<tr>
<td><strong>Design of sprueing points</strong></td>
<td>Trumpet shape, without sharp edges and angles</td>
</tr>
<tr>
<td><strong>Distance to margin of investment ring</strong></td>
<td>5–10 mm</td>
</tr>
<tr>
<td><strong>Distance to margin of investment ring</strong></td>
<td>Min. 10 mm</td>
</tr>
<tr>
<td><strong>Distance between various objects</strong></td>
<td>3–5 mm</td>
</tr>
<tr>
<td><strong>Max. weight compressible</strong></td>
<td>Up to 2 press blanks (2 gramm)</td>
</tr>
</tbody>
</table>
5.5.4 Investing

Please weigh the wax object including the pressing channel to avoid pressing with too little material.

Do not use a debubblizer on the wax objects e.g. spray (danger of micro bubbling on the surface).

Please follow the manufacturer's instructions for use for correct processing of the investment material!

Slowly and carefully fill in the investment material up to the wax margin.

Use a suitable instrument for the fine investment of the cavity (e.g. small brush), so that the humidity will not be withdrawn from the investment material.

A fine probe can also be used. Please make sure that the delicate wax margins are not damaged.

Carefully fill the investment ring up to the margin.

– Allow the investment ring to set without vibration.
– No investing before a weekend
  (Danger of drying out or too much humidity through Hygrophor)

5.5.5 Preheating

Check temperature precision of the burnout furnace regularly.

Please follow the manufacturer's work instructions.

After setting of the investment material according to manufacturer's indications, the investment ring is prepared for preheating. 
1. Carefully turn and remove the investment gauge.
2. Carefully turn and remove the investment ring base, too.
3. Remove rough spots with a plaster knife or a belt grinder.
4. Please make sure that no investment material enters the press channel.

The investment ring base should have a 90° angle and be situated flat on the investment ring holder in the pressing furnace.

Definition of wax weight:
1. Put the base of investment ring without wax objects on the balance and calibrate to 0.
2. Fix the wax objects on the base of the investment ring.
3. Put the base of investment ring with the wax objects on the balance.
4. The indicated value corresponds to the wax weight.
**Quick press technology**

<table>
<thead>
<tr>
<th>Recommended investment material</th>
<th>CM20. Manufacturer Cendres+Metaux SA anaxvest PM Manufacturer anaxdent</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standby temperature of the preheating furnace</td>
<td>850° C</td>
</tr>
<tr>
<td>Holding times in the preheating furnace at 850° C:</td>
<td></td>
</tr>
<tr>
<td>– Cylinder (100 g)</td>
<td>45 min.</td>
</tr>
<tr>
<td>– Cylinder (200 g)</td>
<td>60 min.</td>
</tr>
<tr>
<td>– Cylinder (300 g)</td>
<td>75 min.</td>
</tr>
<tr>
<td>– Cylinder (400–600 g)</td>
<td>90 min.</td>
</tr>
<tr>
<td>Position der Muffel im Ofen</td>
<td>Opening downwards. Please make sure that the wax burn-out occurs outside of the investment ring, e.g.:</td>
</tr>
<tr>
<td>– Tip out the investment ring in the direction of the rear wall</td>
<td></td>
</tr>
<tr>
<td>– Preheat the self-produced, not yet burned out press stamp, or that for the 400–600 g cylinder, in the furnace heated to 850° C with the ring.</td>
<td></td>
</tr>
</tbody>
</table>

**Start PEKKtherm**

**Press Heat (blue button)**

PEKKtherm is blocked for 15 minutes.

When the Go LED lights up green (audible beep), the device is ready to operate (at 390° C) and ready for program selection.

**Use the Stop button to select the program**

(Keep the key pressed until the desired program is displayed)

5 programs are available:

1 = 100 g LED ○ ○ ○
2 = 200 g LED ○ ○ ○
3 = 300 g LED ○ ○ ○
4 = 400–600 g LED ○ ○ ○
5 = 400–600 g LED ○ ○ ○

**Press the Go button**

The furnace opens, program starts.

Put the ring and press stamp 12 mm next to each other in the PEKKtherm immediately.

Depending on the program selected, PEKKtherm remains open as follows:

1 = 5 minutes
2 = 10 minutes
3 = 15 minutes
4 = 20 minutes
5 = 20 minutes

PEKKtherm then closes automatically and remains closed for 20 minutes to allow the temperature to stabilize.

An alarm sounds when the program is done.

⚠ Take the press stamp (26 mm) for the 400–600 g ring out of the preheating furnace 10 min. prior to pressing and let it cool on the PEKKtherm device.

**Melting Pekkton® ivory**

Press the Go button, furnace opens.

Cylinder can now be loaded with the PekktonR ivory press blanks.

⚠ Max. 9 pcs. (9 grams) at one time! (400–600 g investment ring)
**Press the Go button**

PEKKtherm remains closed for 20 minutes followed by an alarm (beep). Press the Go button, furnace opens.

The melted PekktonR ivory normally has a cream color and has no brown discoloration. The material is ready for the pressing process.

Insert the preheated single-use press stamp, press lightly and put in the PEKKpress press (pressing process, see 5.4.6).

**Option (for program 5)**
(if more than 10 g are needed)

1) Audible beep.
2) Press the Go button (furnace opens).
3) Fill material.
4) Press the Go button (furnace closes).
5) Wait 15 minutes (no alarm)
6) Press the Go button (furnace opens)
7) Insert the preheated single-use press stamp, press lightly and put in the PEKKpress press (pressing process, see 5.4.6).

⚠️ If PEKKtherm is not operated for one hour and the green Go button is illuminated, PEKKtherm is in Standby mode and automatically switches off.
### 5.5.6 Pressing

<table>
<thead>
<tr>
<th>Start PEKKpress</th>
<th>The red LED lamp is illuminated above the green and blue button.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Press the green button</td>
<td>LED lamp turns green. Furnace opens. PEKKpress is ready for program selection.</td>
</tr>
<tr>
<td>Set pressure</td>
<td>Pressure regulator is adjustable from 0 – 6 bar.</td>
</tr>
<tr>
<td>– Cylinder</td>
<td>1.5 Bar</td>
</tr>
<tr>
<td>– Cylinder (200 g)</td>
<td>2.5 Bar</td>
</tr>
<tr>
<td>– Cylinder (300 g)</td>
<td>3.5 Bar</td>
</tr>
<tr>
<td>– Cylinder (400–600 g)</td>
<td>5.8 Bar</td>
</tr>
<tr>
<td>The vacuum is deactivated by pressing the blue button.</td>
<td>Large pieces are pressed under vacuum.</td>
</tr>
<tr>
<td>LED red –&gt; vacuum off</td>
<td>LED green –&gt; vacuum on</td>
</tr>
<tr>
<td>Use the red button to select the program</td>
<td>4 programs are available:</td>
</tr>
<tr>
<td>1 = 100 g</td>
<td>🟢🟢🟢</td>
</tr>
<tr>
<td>2 = 200 g</td>
<td>🟢🟢🟢</td>
</tr>
<tr>
<td>3 = 300 g</td>
<td>🟢🟢🟢</td>
</tr>
<tr>
<td>4 = 400–600 g</td>
<td>🟢🟢🟢</td>
</tr>
<tr>
<td>Cooling phase after pressing</td>
<td>1 = 10 minutes</td>
</tr>
<tr>
<td>2 = 20 minutes</td>
<td></td>
</tr>
<tr>
<td>3 = 30 minutes</td>
<td></td>
</tr>
<tr>
<td>4 = 40 minutes</td>
<td></td>
</tr>
<tr>
<td>PEKKpress then opens automatically.</td>
<td></td>
</tr>
<tr>
<td>Switch off PEKKpress (green illuminated button)</td>
<td>Device closes automatically.</td>
</tr>
<tr>
<td>Cool the investment ring to room temperature</td>
<td></td>
</tr>
</tbody>
</table>

![PEKKpress images](attachment:image1.jpg)

![PEKKpress images](attachment:image2.jpg)

![PEKKpress images](attachment:image3.jpg)
5.5.7 Divestment and cleaning
Using pliers, carefully remove the investment material without damaging the frames.

- Divest as soon as the investment ring is room temperature.
- Do not use tongs to divest larger pieces.

Fine divestment is carried out with abrasive 110µm aluminum oxide under pressure of 2 bars.

- Caution: Sandblast for a short period only to prevent damage. Sandblast only the framework and not the interface.

Crown framework after fine divestment.

- The material can be pressed only one time.
5.6 Conditioning

Cleaning with oil-free compressed air only.
Ceramic stones and old burs can cause clogging, which makes conditioning difficult and may lead to overlaps.

Check the fit and adjust, if necessary.

Cut the sprue by using a cutting wheel.

When grinding the Pekkton® framework, wear protective goggles with a dust mask and use a suction unit. The cutting wheels available from Cendres+Métaux SA are ideal for removing surplus material.

Cross-toothed milling is used to finish the framework.

Speed limit maximum 15,000 rotations/min.
Do not work on the object if the pressure is too high.

Roughen the surface using a diamond milling cutter before sandblasting the framework.

After milling is complete, sandblast the framework with aluminum oxide 110µm under 2 bar pressure and clean well using oil-free compressed air.

Caution: Sandblast only the framework and not the interface connection.
After sandblasting the surface, do not touch the surface with your bare fingers. Never clean the framework with steam or water.
5.7 Veneering

5.7.1 Preparation
Before veneering, it is imperative that the Pekkton® framework is treated with composite primer. We recommend the primer visio.link, Cendres+Métaux SA, Order No. 0800 0570.

⚠️ Please follow the manufacturer’s instructions.

5.7.2 Veneering concepts
After preparation of the framework as described in Section 5.6.1, Pekkton® ivory can be refined esthetically in different ways. For example, it can be refined by veneering with composites, affixing custom-made pressable ceramic crowns or using prefabricated acrylic teeth and trays.

⚠️ As veneering is outside the area of responsibility of Cendres+Métaux SA, it is not further described in these instructions for use. Please follow the manufacturer’s instructions for the veneering concept selected.

Information about the veneering concepts is available from our clinical case documentation on our website www.pekkton.com.

⚠️ Bridge work: To avoid cracks (and late effects) in the veneering as a result of different modulus of elasticity values for Pekkton® ivory and the veneering material, a separation should be made between the teeth down to the opaque.
5.8 Cementation

Preparation: (in the laboratory):
1) Sandblast the inner surface of the reconstruction with abrasive 110 µm grit at a pressure of 2 bar.

Prior to cementation:
1) Check reconstruction for fit and correct by grinding, if necessary.
2) Occlusal precision corrections can be performed after cementation because composite veneering is very easy to polish in the patient’s mouth.
3) Pretreat the inner surface with composite primer visio.link (Order No. 0800 0570) to increase the bond.

Please follow the manufacturer’s instructions for the visio.link.

To increase the bond to Pekkton® ivory, the inner surface can be silicatized before application of the composite primer and subsequently silanized.

Cementation:

<table>
<thead>
<tr>
<th>Method of cementation:</th>
<th>Conventional (glass ionomer cements)</th>
<th>Self-adhesive</th>
<th>Adhesive</th>
</tr>
</thead>
<tbody>
<tr>
<td>Stump</td>
<td>Length of stump &gt; 4 mm</td>
<td>Length of stump &gt; 4 mm</td>
<td>short stump, &lt; 4 mm</td>
</tr>
<tr>
<td></td>
<td>Preparation angle: 4 – 8°</td>
<td>Preparation angle: 4 – 8°</td>
<td>Preparation angle: &gt; 8°</td>
</tr>
</tbody>
</table>

Please follow the manufacturer’s instructions.

5.9 Handling after integration

5.9.1 Cleaning and follow-up
Please remove remaining processing debris and then air dry the denture.

5.9.2 Traceability
The batch numbers must be documented to ensure traceability.
6 Ordering information

<table>
<thead>
<tr>
<th>Material</th>
<th>Description</th>
<th>Order No.</th>
<th>Manufacturer</th>
</tr>
</thead>
<tbody>
<tr>
<td>PEKKtherm</td>
<td></td>
<td>7020 2394</td>
<td>Effegi-Brega</td>
</tr>
<tr>
<td>PEKKpress</td>
<td></td>
<td>7020 2393</td>
<td>Effegi-Brega</td>
</tr>
<tr>
<td>Pekkon® ivory Pressrohling (Core material)</td>
<td></td>
<td>0106 0003</td>
<td>Cendres+Méaux SA</td>
</tr>
<tr>
<td></td>
<td>(Packaging of 10 pieces)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>visio.link</td>
<td>(PMMA &amp; Composite Primer)</td>
<td>0800 0570</td>
<td>Bredent</td>
</tr>
<tr>
<td>Disposable Pressplunger (Diameter 12 mm)</td>
<td></td>
<td>0800 0626</td>
<td>Cendres+Méaux SA</td>
</tr>
<tr>
<td>Disposable Pressplunger (Diameter 26 mm)</td>
<td></td>
<td>0800 0627</td>
<td>Cendres+Méaux SA</td>
</tr>
<tr>
<td>PEKKpress mould set 200g</td>
<td></td>
<td>08000628</td>
<td>Cendres+Méaux SA</td>
</tr>
<tr>
<td>PEKKpress mould set 600g</td>
<td></td>
<td>08000629</td>
<td>Cendres+Méaux SA</td>
</tr>
</tbody>
</table>
7 Symbols

Date of manufacture
Manufacturer
Patient No.
Catalogue number
Batch code
Quantity
Consult instructions for use
Rx only

Attention: According to US federal law, this product may only be sold by or on behalf of a physician.
Cendres+Métaux products with CE labelling meet the requirements of the relevant European requirements.
Do not re-use
Non-sterile
Keep away from sunlight
Attention (observe accompanying documents)

8 Disclaimer / Validity
The issuing of these instructions for use renders all previous versions invalid.
The manufacturer rejects any liability for damages resulting from non-compliance with these instructions for use.
In case of complaints, please always include the batch number.
Illustrated step-by-step instructions are available on the Cendres+Métaux homepage. www.cmsa.ch/dental
The product must be used exclusively by skilled persons.

9 Availability
Country-specific differences in product range are possible.

10 Copyright and trademarks
Pekkton® ivory is a registered trademark of Cendres+Métaux Holding SA, Biel/Bienne, Switzerland.
Reprints or publication – even excerpts – require the written permission of the publisher.
### 11 Further information

#### 11.1 Troubleshooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Cause</th>
<th>Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Workpiece not pressed out</td>
<td>– Investment ring has not been preheated to recommended temperature.</td>
<td>– Check program and final temperature.</td>
</tr>
<tr>
<td></td>
<td>– Duration of transport from the preheating furnace to the pressing furnace is too long.</td>
<td>– Perform furnace change as quickly as possible.</td>
</tr>
<tr>
<td></td>
<td>– Insufficient material used.</td>
<td>– Weigh press items before pressing.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Framework broke during divestment</td>
<td>– The divestment pliers got too close to the item, the margin.</td>
<td>– Only divest roughly with the pliers, sandblast the rest.</td>
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<tr>
<td>Framework no longer fits properly after divestment</td>
<td>– Sandblasting pressure is too high.</td>
<td>– Set max. pressure to 2 bar.</td>
</tr>
<tr>
<td></td>
<td>– Microbubbles.</td>
<td>– Fit carefully with a precision bur, then sandblast at 2 bar and 110µm.</td>
</tr>
<tr>
<td></td>
<td>– Investment material residues on the inner surfaces.</td>
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<tr>
<td>Veneer becomes detached from the framework (insufficient adhesion)</td>
<td>– Surface not properly prepared for bonding.</td>
<td>– Prepare surface according to instructions.</td>
</tr>
<tr>
<td></td>
<td>– Primer not used.</td>
<td>– Always use primer.</td>
</tr>
<tr>
<td></td>
<td>– Grease on the surface.</td>
<td>– After sandblasting, never touch the surface with your fingers.</td>
</tr>
<tr>
<td></td>
<td>– Moisture between the framework and the veneering material.</td>
<td>– Do not clean the framework with water or steam.</td>
</tr>
</tbody>
</table>
11.2 FAQ
The information can be founded on our Website www.pekkton.com

11.3 Acknowledgments
We would like to thank Mr. Marc Cristou, Mr. Laboratoire Cristou (FR-Paris), Mr. Phil Reddington, Mr. Lee Mullins and BDT Beever Dental Technology (GB-Leeds) for their valuable input and suggestions in creating this instruction manual.