

Assembly Instructions SAE Special T Attachment



1. Start

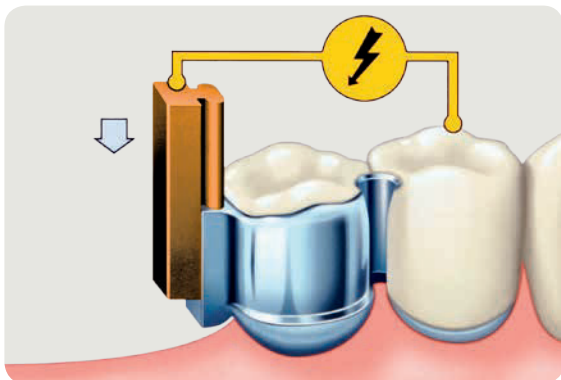
Position the plastic pattern using the parallelometer and incorporate into the crown model. Distance to abutment 0.5mm.

SAE plastic pattern is made of combustible plastic which leaves behind no residues (Order No. 30-1120).

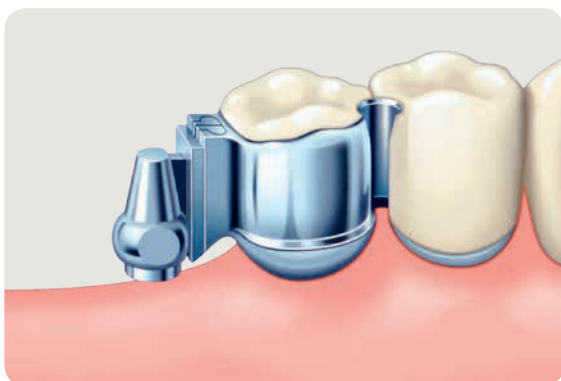


2. Preparing the cast pins

As the attachment matrix is produced subsequently through spark erosion, no particular technique is required. Apart from that, procedures from the manufacturer for the investment casting technique should be observed.

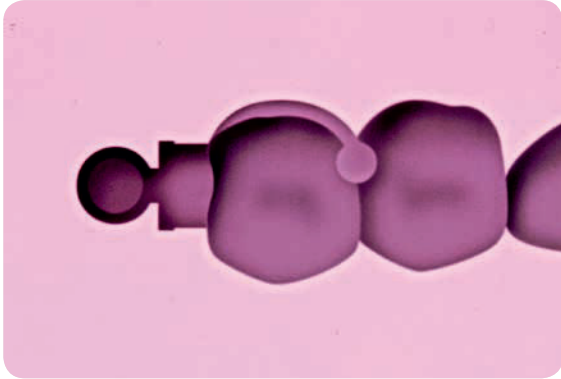


3. See chronological process of an attachment erosion using graphite and copper electrodes



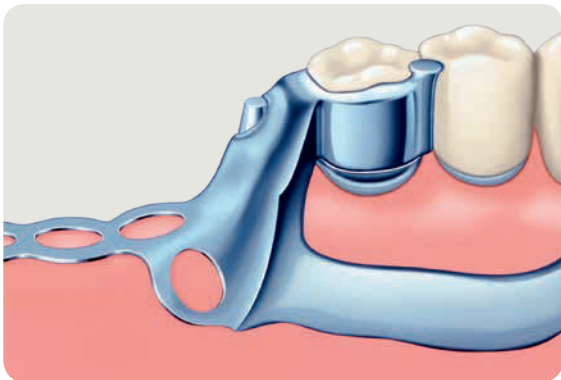
4. Preparation for duplication

Push original male part including the cone which has been inserted and screwed together into the matrix and wax over the gap to the alveolar ridge so that it is flush with the cone. Prepare the model for silicone duplication.



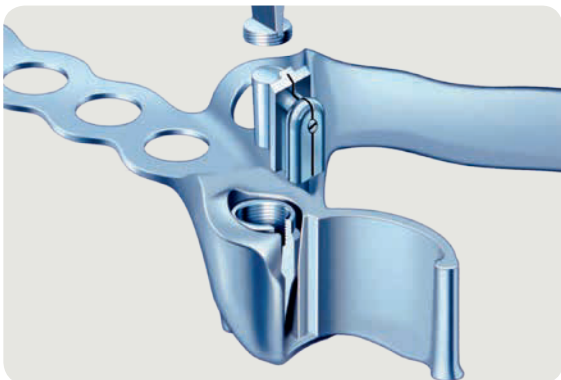
5. Once the duplication material has hardened

remove model with the secondary part and the attachment elements from the duplicating mould. Then pour the SAE Invest M2 material (Order No. 70-1033) into the mould. On the resulting model, coat the attachment element in wax and complete the modelling of the model cast. Finishing occurs following casting and divesting. When the steel cast has had a final polish, the Inox attachment cone is fastened into the model cast using composite or it is lasered.



6. Remove the investment model from the duplicating material

Modelling then follows. When modelling, clean the approximal surface of the cone as this gives the male component a certain level of stability. Do not locate the casting channels closer than 1 cm to the male component. Transfer model and proceed as usual.



7. Assembly of the male component

After completing the model cast, the male attachment is inserted into the cone.

The attachment is secured using the cone sealing screw. The cone screw can be dispensed with if the attachment male is secured in the cone using composite adhesive. It is recommended to lightly sandblast the inside of the cone and also the attachment cone with aluminium oxide (70 µm) and possibly to silanize the adhesive surfaces (Rocatec). The attachment male can be removed by way of selective heating.

Tool: Activating instrument mini screw driver (Order No. 30-5005).

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