

01. Cut excess impression material from sides of the tray to lay flat.
02. Spray articulator with a release agent or apply Vaseline for easier removal of die stone.
03. Mark lines on buccal and lingual areas of the impression for dowel pin alignment.
04. Pour working (preparation) side of impression tray first with die stone.
05. While die stone is still wet, place pins in the center of marked areas of the impression tray. You can also use the Pindex machine to align the pins.
06. Allow to set.
07. Apply die separator on pinned side.
08. Mix die stone and cover pins.
09. Place remaining stone material in the same side of the articulator and invert. Slightly overfill to form a solid base to facilitate removal of stone material from the articulator.
10. Wipe off excess material while stone is still wet from the sides of the articulator to allow easy removal of the model.
11. When stone is set, pour other side of the impression and articulator then invert.
12. Wipe off excess material while stone is still wet from the sides of the articulator to allow easy removal of the model.
13. When inverting do not exert excessive pressure - only enough to close the articulator in its correct position. Overclosure and/or underclosure will cause a spring back action when the impression is removed from the articulator.
14. Do not remove the impression from the articulator before pouring both sides.
15. Remove die stone from articulator after complete setting of the material.
16. Follow usual procedures for sectioning, trimming of the dies, etc.
17. It is recommended to pour up a solid model of the prepared tooth (teeth) to double check for proper contacts of the final restoration(s).

01. Spray articulator with a release agent or apply Vaseline for easier removal of die stone.
02. Pour prepared side of impression first with die stone. Pour the same mix in the articulator, slightly overfilling it. Invert impression on the articulator while wet.
03. Wipe off excess material before it sets up from all sides of the articulator to facilitate removal. Allow to set.
04. DO NOT REMOVE impression tray from the articulator. Pour opposing arch impression and articulate the same way. Total setting time depends on type of die stone used. Follow manufacturer's recommendations.
05. Remove impression tray. Place the L.A.K. lab knife flat between the stone and rim of the articulator from the inside at the back of the articulator using a prying and twisting motion. When the seal is broken, move the knife forward until the model can be removed easily. DO NOT PRY ON THE ARM OF THE ARTICULATOR AS THIS WILL DISTORT IT.
06. Cut die(s). Start from the occlusal. Continue cutting buccally and lingually, to approximately two thirds the way. Follow the lines and cut from the bottom of the model leaving a very small area uncut and snap model apart. A thin diamond disc for cutting the model is preferred to prevent nicking the margins of the prepared die(s).
07. USE A BRISTLE BRUSH AND AIR TO REMOVE DUST FROM THE CUT PORTIONS OF THE DIE(S) AND STONE MODEL to facilitate assembly and prevent movement of the die(s).
08. TRIM DIES ONLY AROUND MARGINS.
09. Reassemble in order in the articulator from one end to the other.
10. If the bite is correct, remove opposing model from the articulator and trim base. Reset bite, add stone to the articulator and remount.
11. It is recommended to pour up a solid model of the prepared tooth (teeth) to double check for proper contacts of the final restoration(s).

01. SET-UP RECEPTACLE

Place the receptacle containing the lead pellets and screen on platform of the vacuum former.

02. PLACE DIES IN CENTER OF RECEPTACLE

Place the dies in the center of the receptacle so they are in alignment with the coping material. This technique can be used with dies that utilize the Pin or No Pin System. The dies should be placed so the margins of the preparations are just above the lead pellets. The lead pellets keep the dies in position. The wire mesh screen allows adequate vacuum and prevents the lead pellets from blocking the holes on the base of the receptacle.

03. PREHEAT VACUUM FORMER

To save time, preheat the vacuum former. If you are making 5 copings or less, use 1/4 of the coping sheet (5" x 5") by cutting it into 4 squares.

04. PLACE COPING MATERIAL

When using 1/4 of the coping sheet, place coping material between the stainless steel plates and lock into position. Stainless steel plates are not needed when using an entire coping sheet.

05. FINALIZE PROCESS

Raise the vacuum former holder and heat the coping sheet. As the plastic heats up it will first sag, then bend up and finally straighten. Bring down the coping material on dies with the vacuum on at this point. If correctly done, the plastic copings will be 0.3mm uniform thickness without any voids. Remove coping material from the dies and trim just short of the margins. Wax-up coping in the usual manner. The plastic material makes the copings more accurate with less chance of distortion, especially in long span bridges and abnormal temperature changes usually encountered in the laboratory environment.