



AESTHETIC-PRESS

EFFICIENCY THROUGH SIMPLICITY

The AP 400g ring

Press-technique without limits!



Introduction:

With the development of the AP 400, it is finally possible to press either full arch restorations, or multiple colors in the same ring in every oven on the market.

The AP400 ring comes with three individual pistons, a base parts with parallel walls, a white ring and an additional top, which identifies the segments and also shapes the bottom part to improve heat distribution in the burning furnace.

Step one:

Before starting to connect the restoration with the pistons, it is important to place the round cylinder rubber ring to the bottom part.

Step two:

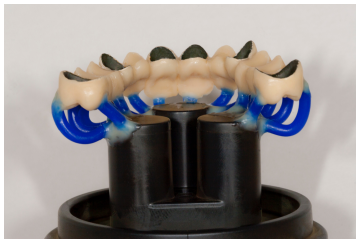


Connect all three pistons with a 3 mm sprue, so that the material can flow from compartment to compartment in case that one side has completed the press procedure while the others still needs further material to flow into their objects.

Fig1. sprues connecting each piston

Step three:

Aim the framework at the three pistons and find out which position will offer the shortest sprueing technique. It is helpful, if the sprue are as short as possible, since it will shorten the duration of the press cycle. The shorter the press cycle, the better the quality of the porcelain will be.



Use 3 mm sprues to connect the units with the ring.
Apply the sprue onto the incisal edge for all anteriors. For posteriors, please use 2 sprues, one on the buccal and one on the lingual.
Note: in this photo the cylinder ring is missing to better illustrate the spruing technique!



frontal view from spruing technique

Step four:



To get a good result for the plunger maker, pour the form and let the material set for 1 hour. Then trim to top off to get a clean parallel ceiling.
Gently remove the plunger out of the silicon matrix
Push each piston up with your thumb, then lift equally all three to the upside.
Preheat the plunger with the ring in the burn out oven to dry any moisture in the investment material.

When pressing a full arch, one needs to use 3 x 3 of the 2.5g ingots. This should be sufficient to press a 14 unit bridge. Gently insert the ingots into the ring and make sure that the ingots are flat on the bottom before adding more.

The maximum capacity for the AP400 ring are 4x 3 of the 2.5g ingots which equals 30g of porcelain. The maximum of crowns and bridges which can be pressed are around 20 units or 30 Veneers all at once.

The bottom of the ring is 8 cm in diameter, which should fit in all major ovens.

Individual press oven settings:

Dekema Press-i-Dent:

Start 700 C

Hold time 40 min

Press Temp 970 C

Press Temp increase by +40° C to the normal press temp.

Rising temp 60 C / min

Press Level 7

Ivoclar furnaces:

When using the Ivoclar EP 3000 or 5000, remove the bottom part of the oven to reduce the total height of ring and piston.

Change the settings to the following:

E = Stop Speed - to 50!

Start 700 C

Hold time 40 min

Press Temp increase by +40° C to the normal press temp (970° C) .

Rising temp 60 C / min

Zubler Vario Press 300

Start 700 C

Hold time 40 min

Press Temp increase by +40° C to the normal press temp (970° C)

Rising temp 60 C / min

Press time: adjust press time to 25 min. It might be possible to abort the program before the 25 min have passed.

Press Pressure: set to "high"

Press results:



perfect press result and sharp porcelain margins



AP Press furnace powered by Dekema



multiple colors pressed onto the same frame.