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from unnecessary
tasks and learn
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[kulzer.com/
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Application Guide for dima Print C&B temp

Don't mill it, print! For faster temporaries and provisionals.

05.2021

Giving a hand to oral health.



KULZER
MITSUI CHEMICALS GROUP

dima Print C&B temp

With dima Print C&B temp you can produce temporary crowns and bridges



1. Design notes

The recommended settings and design recommendations here only apply when used in combination with 3Shape. You can download the parameter as a DME file to import into 3Shape in the cara download area:

[kulzer.com/cara-print-3shape-dme](https://www.kulzer.com/cara-print-3shape-dme)

With CAM 2.0 most of the settings are generated automatically. The following details will help you with your design in CAM 1.0.

Register and get
your free CAM
licence!

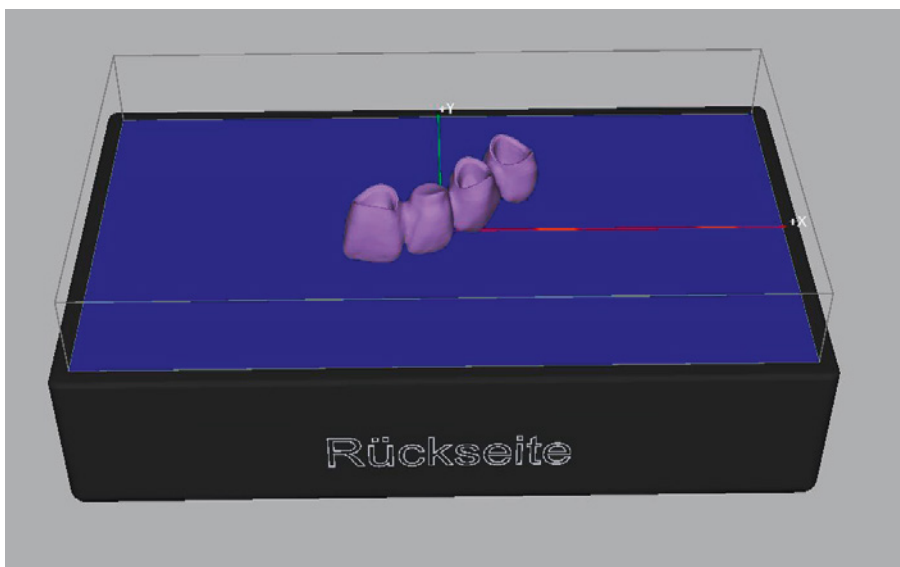


2. Recommended setting

- Minimum wall thickness: 2 mm
- To maintain a certain wall thickness is especially recommended in the occlusal area and the connection area of units; The edge of the crowns can be designed tapering thinly
- Anterior bridges up to 6 units and posterior bridges up to 4 units

3. Print position (angle and orientation)

- Position crowns/bridges on the build table with the basal surface facing up toward the build table (see below images for reference).
- Distance from appliance to building platform min. 5 mm

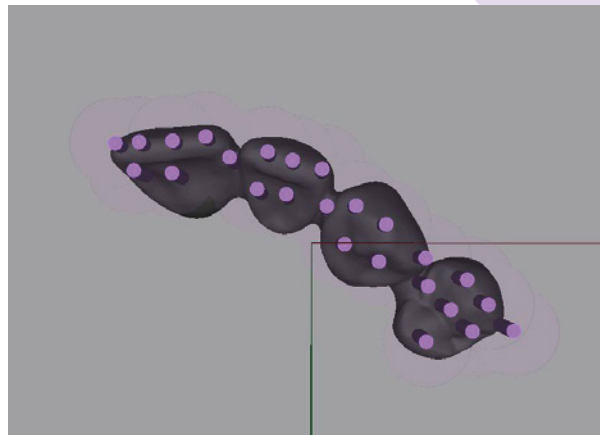
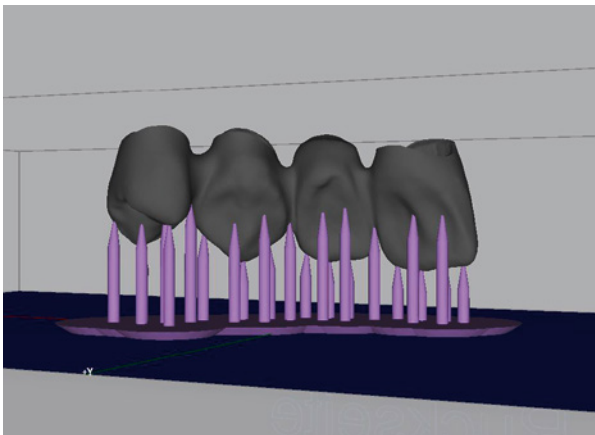


Place the intaglio surface upwards as shown

- We recommend to then manually add supports, also on the connector of each unit (5–8 in total, depending on the size and shape of the tooth)
- Supports Top shape should be "Cone 25%" and support bottom "Cone 75%" (for easier removal after printing)

Light support parameters

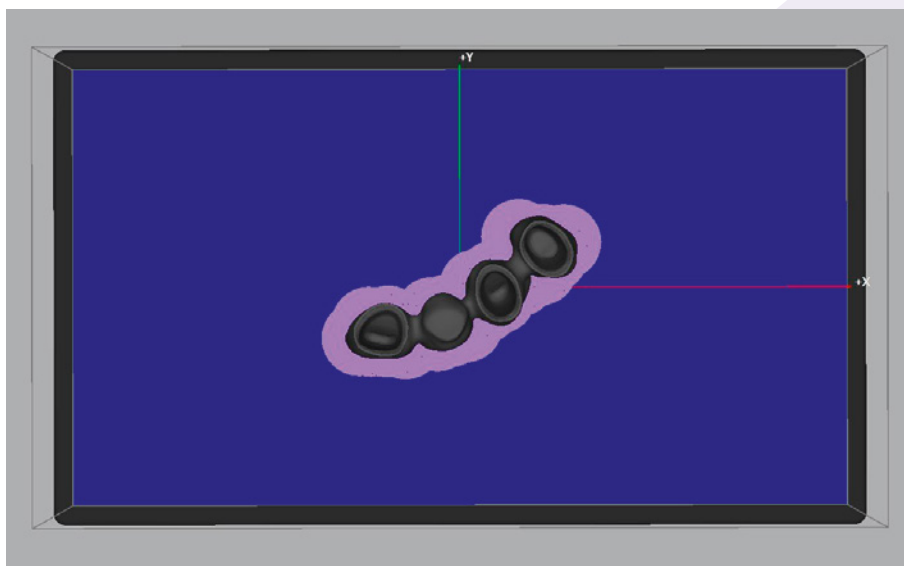
Top	
Shape	Cone 25 %
Radius (mm)	0.5
Length (mm)	2
Penetration (mm)	0.35
Angle Factor	100 %
Mid	
Shape	cylinder
Radius (mm)	0.5
Bottom	
Shape	Cone 75 %
Radius (mm)	5
Length (mm)	0.75
Penetration (mm)	0
Angle Factor	100 %



Full anatomic anterior bridge with fine supports, seen from the side and below

4. Foundation

- Adding a foundation is not necessary for printed crowns and bridges.



Full anatomic 4 unit bridge with fine supports, seen from above

5. Printing

- Files can be printed in 50µm and 100µm layer thickness

6. Cleaning and Postcuring

Cleaning recommendations:

- Before the usual cleaning, we recommend using compressed air to blow out any remaining liquid monomer inside the cavities.
- Remove supports before postcuring.

Curing recommendations:

- dima Print C&B temp must be post-cured with an oxygen inhibitor (glycerin) to remove unreacted functional groups and create harder surfaces. We recommend using 99% glycerin.

	Cleaning time in Isopropanol (cara Print Clean or ultra sonic bath)	Post-curing time (HiLite Power 3D)	Post-Curing time LEDcure (no turning of object necessary)
dima Print C&B temp	pre-cleaning: 3 minutes post-cleaning: 2 minutes	20 minutes (10 minutes front side +10 minutes reverse side) in Glycerin	C&B Temp program, cure in Glycerin

Using glycerin in Kulzer light curing devices:

Glycerin is a non-flammable liquid that can be used in Kulzer light curing devices when handled with care:

- To cure the objects in glycerin you need an up to 80°C heat-resistant glass bowl with a glass lid that fits in your light curing device. You can use microwave glassware, Pyrex glass or tempered glass for laboratory equipment but also most of normal glass table ware will be sufficient as well.
- The printed object must be covered with glycerin completely
- Glycerin can be reused and only needs to be changed when getting foggy

Special information for HiLite power 3D users:

- Never forget to use the model tray of your HiLite power 3D below the glass bowl. This prevents the curing device from overheating
- Open and close the curing department door carefully so that no glycerin spills inside the device
- We recommend a cool-down time for the HiLite Power 3D of 2–3 minutes after each 10 minutes operational cycle.
- Maximum height of the glass bowl 5 cm, maximum width 10 cm at the bottom



CAUTION: THE GLYCERIN WILL BE VERY HOT AFTER CURING. PLEASE USE AN INSTRUMENT TO FLIP THE APPLIANCE AND TO REMOVE THE APPLIANCE FROM THE HOT GLYCERIN ONCE CURING IS COMPLETE!



Use the model tray to carry the glass bowl for optimal ventilation


- Once curing is complete, wipe down the appliance with a paper towel to remove the glycerin and use compressed air to blow out any sockets and crevices or rinse the cured appliance under water.

7. Finishing

- Once post-curing is complete, grind the support spots and borders of the restorations.
- Polish the external surface of the crowns/bridges with pumice; then switch to a dry lathe disc and polishing paste for a glossy finish
- We recommend using Signum HP Diamond for achieving a high shine of the final restoration.

8. Cementation

- Crowns and bridges printed with dima Print C&B temp can be cemented using standard dental temporary cements
- If the crown/bridge requires adaptations for fitting, it can be easily grinded, but also relined with conventional auto cure acrylic

Available shades	
dima Print C&B temp	
7 shades	
	A1
	A2
	A3
	A3.5
	B1
	B2
	BL1

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with Kulzer's full range of 3D-Printing solutions.

kulzer.com/cara-print

dima Print Digital Denture:

Stress-free digital dentures with 3D printing



dima Print Stone beige:

3D print all dental model types with a traditional look & feel.



dima Print Stone teal:

The color for orthodontics: less eye strain and high heat resistance.



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Free up your milling machine from unnecessary tasks and learn about C&B temp!
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Contact in Germany

Kulzer GmbH
 Leipziger Straße 2
 63450 Hanau, Germany