

FINISHING AND POST-CURING PROCESS

VARSEO INDICATIONS

Specified curing times with BEGO Otofash (Two xenon stroboscopic lamps, flash frequency 10 Hz, light spectrum 300–700 nm)

We recommend by using of the BEGO Otofash light curing device, the use of the protective gas function for medical devices. The protective gas prevents the inhibition of oxygen, guarantees a completely adhesive-free surface hardening and thus a more efficient reduction of the residual monomer content. To do this, set the protective gas switch to position 1. Observe the operating instruction manual of the post-curing device.

VarseoWax CAD/Cast

1. Remove the supports.
2. Check the accuracy of fit on the model.
3. Post-cure on the model for 1 × 500 flashes.
4. Prepare object for casting.



VarseoWax Tray

1. Remove the supports and finish the tray surface.
2. Check the accuracy of fit on the model.
3. Post-cure the outer tray surface without the model for 1 × 2,000 flashes.
4. Turn the tray and cure the inner surface for 1 × 2,000 flashes.
5. Smooth and clean the tray surface.



VarseoWax Surgical Guide

1. Remove the supports.
2. Post-cure without the model for 1 × 1,000 flashes.
3. Finish the object and check the accuracy of fit on the model.
4. Insert the drill sleeves. Apply a thin layer of liquid VarseoWax Surgical Guide material to the exterior of the drill sleeves with a brush to secure them in place. When doing so, ensure that no material reaches the inside of the sleeves. If necessary, these should be checked again for patency once hardened.
5. Post-cure the object for 2 × 2,000 flashes (without model). Turn it and, if applicable, allow it to cool between the exposure cycles.



VarseoWax Model

1. Post-cure the model for 2 × 2,000 flashes, turn between the exposure cycles.



VarseoSmile Temp

1. Remove the supports.
2. Sandblast the surface of the objects carefully with Perlablast micro (REF 46092 / 54302) at a maximum blasting pressure of 1.5 bar.
3. Check the accuracy of fit on the model and finish the objects completely.
4. Optional step: High-gloss polishing of the objects and subsequent customisation with stains such as els paintart* from Saremco Dental AG, Switzerland.
5. Post-cure the objects without the model for 2 × 1,500 flashes. Turn between the exposure cycles, followed by cooling off.
6. Polish the surface of the non-customised objects with pumice stone and polishing compound. Optimal surface quality is achieved by polishing after post-curing.



The times given only apply to regularly maintained equipment that guarantees a corresponding light intensity. Further information and comprehensive tutorials can be found at: <https://www.bego.com/media-library/videos/3d-printing/>

* This symbol is a commercial designation/registered trademark of a company which is not part of the BEGO company group.

FINISHING AND POST-CURING PROCESS

VARSEO INDICATIONS

Specified curing times with HiLite power (Heraeus Kulzer*; one xenon stroboscopic lamp, flash frequency 20 Hz, light spectrum 390–540 nm)

VarseoWax CAD/Cast

1. Remove the supports.
2. Check the accuracy of fit on the model.
3. Post-cure on the model for 1 × 90 seconds.
4. Prepare object for casting.



VarseoWax Tray

1. Remove the supports and finish the tray surface.
2. Check the accuracy of fit on the model.
3. Post-cure the outer tray surface without the model for 1 × 180 seconds.
4. Turn the tray and cure the inner surface for 1 × 180 seconds.
5. Smooth and clean the tray surface.



VarseoWax Surgical Guide

1. Remove the supports.
2. Post-cure without the model for 1 × 90 seconds.
3. Finish the object and check the accuracy of fit on the model.
4. Insert the drill sleeves. Apply a thin layer of liquid VarseoWax Surgical Guide material to the exterior of the drill sleeves with a brush to secure them in place. When doing so, ensure that no material reaches the inside of the sleeves. If necessary, these should be checked again for patency once hardened.
5. Post-cure the object for 2 × 180 seconds (without model). Turn it and, if applicable, allow it to cool between the exposure cycles.



VarseoWax Model

1. Post-cure model for 2 × 180 seconds, turn between the exposure cycles.



VarseoSmile Temp

1. Remove the supports.
2. Sandblast the surface of the objects carefully with Perlablast micro (REF 46092 / 54302) at a maximum blasting pressure of 1.5 bar.
3. Check the accuracy of fit on the model and finish the objects completely.
4. Optional step: High-gloss polishing of the objects and subsequent customisation with stains such as els paintart* from Saremco Dental AG, Switzerland
5. Post-cure the objects without the model for 2 × 90 seconds. Turn between the exposure cycles, followed by cooling off.
6. Polish the surface of the non-customised objects with pumice stone and polishing compound. Optimal surface quality is achieved by polishing after post-curing.



The times given only apply to regularly maintained equipment that guarantees a corresponding light intensity. Further information and comprehensive tutorials can be found at: <https://www.bego.com/media-library/videos/3d-printing/>

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