

Finishing and Post-Curing Process Varseo Indications

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

VarseoSmile Crown ^{plus}



- 1 Remove the supports.
- 2 Sandblast the surface of the objects carefully with Perlablast micro (REF 46092 / 54302) at a max. blasting pressure of 1.5 bar.
- 3 Check the accuracy of fit and finish the object. Carbide cutters or diamond grinding tools can be used for finishing and contouring.
- 4 Post-cure the objects without the model for 2 × 1,500 flashes, turn between the exposure cycles followed by cooling off.
- 5 Optional: Individualization with stains. Individualization is possible with composite stains and is the responsibility of the user. It may affect the color result. Please follow manufacturer's instructions. If the this step is not considered, please follow the next point.
- 6 Polish the objects with pumice stone and polishing compound. Avoid overheating of the resin during polishing. Optimal surface quality is achieved by polishing after post-curing.

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.

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 and finish the object. Carbide cutters or diamond grinding tools can be used for finishing and contouring.
- 4 Post-cure the objects without the model for 2 × 1,500 flashes. Turn between the exposure cycles, followed by cooling off.
- 5 Polish the surface of the objects with pumice stone and polishing compound. Optimal surface quality is achieved by polishing after post-curing.

VarseoWax Model



- 1 Remove the supports.
- 2 Post-cure the model for 2 × 2,200 flashes, turn between the exposure cycles

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 post-cure the inner surface for 1 × 2,000 flashes.
- 5 Smooth and clean the tray surface.

VarseoWax CAD/Cast (REF 41136, 41137)



- 1 Remove the supports.
- 2 Check the accuracy of fit on the model.
- 3 Post-cure the object for 2 × 500 flashes. First post-exposure on the model, second post-exposure with the surface matching the light source.
- 4 Prepare object for casting.

We recommend by using of the BEGO Otoflash 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.

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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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)

VarseoSmile Crown ^{plus}



- 1 Remove the supports.
- 2 Sandblast the surface of the objects carefully with Perlablast micro (REF 46092 / 54302) at a max. blasting pressure of 1.5 bar.
- 3 Check the accuracy of fit and finish the object. Carbide cutters or diamond grinding tools can be used for finishing and contouring.
- 4 Post-cure the objects without the model for 2 × 90 seconds, turn between the exposure cycles followed by cooling off.
- 5 Optional: Individualization with stains. Individualization is possible with composite stains and is the responsibility of the user. It may affect the color result. Please follow manufacturer's instructions. If the this step is not considered, please follow the next point.
- 6 Polish the objects with pumice stone and polishing compound. Avoid overheating of the resin during polishing. Optimal surface quality is achieved by polishing after post-curing.

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 and finish the object. Carbide cutters or diamond grinding tools can be used for finishing and contouring.
- 4 Post-cure the objects without the model for 2 × 90 seconds. Turn between the exposure cycles, followed by cooling off.
- 5 Polish the surface of the objects with pumice stone and polishing compound. Optimal surface quality is achieved by polishing after post-curing.

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

VarseoWax CAD/Cast

(REF 41136, 41137)



- 1 Remove the supports.
- 2 Check the accuracy of fit on the model.
- 3 Post-cure the object for 2 × 90 seconds. First post-exposure on the model, second post-exposure with the surface matching the light source.
- 4 Prepare object for casting.

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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