



A Brand Division of American Tooth Industries

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DENTURE RELINER
(Heat Cure)
with alternate Heat Cures

The Justi Denture Reliner material, in conjunction with the Justi Denture Base, is a rapid heat curing method when used with the Justi Miracleflask microwave oven technique.

Processing Procedure:

- 1. Prepare normal denture wax-up but make it slightly heavier along the periphery to allow for the soft lining material.
2. Invest the model and wax-up in lower section of Miracleflask in plaster. Keep periphery of waxup clear from investment.
3. Invest second half in either stone or half plaster and half stone. Assemble flask together with plastic bolts in position.
4. After investment is hard, place flask in microwave oven for 1 minute at 400-500 watts.
5. Open and remove wax. Boil off any excess wax. Brush out with Justi Wax Solvent #20. Rinse with warm water.
6. Paint surface of investment with a tin foil substitute liquid.
7. Prepare spacer before mixing denture base. After desired thickness of spacer is made, mix Micro-Liquid with Justi Fibered Denture Base.
8. After Denture Base is packable, trial pack several times with spacer in position. When fully packed, let flask sit for several minutes.
9. Prepare soft lining material for normal reline using 15cc powder to 5cc. liquid or 3 to 1 by volume.
10. After soft lining material reaches a consistency where it can be handled, remove the spacer and then pack and trial pack with wet cellophane or polyethylene sheets.
11. Completely close flask. Place plastic bolts in position while keeping the Miracleflask under pressure. Tighten nuts finger tight and then give them a one quarter (1/4)



turn with the wrench from the Miracle Flask Kit. Bench cure for 30 minutes before irradiation.

- 12. Place flask on end in the center of a microwave oven. Set the first phase on the warm cycle (85-90 watts) for thirteen minutes. Set the second phase on the high cycle (500 watts) for 1 1/2 minutes. (Rotate flask midway through the cure).
13. Remove flask from the oven and bench cool for 30 minutes. Cool in cold tap water to room temperature.
14. Remove invested case from flask and finish.
15. Use low speed on soft lining material with gentle pressure.
16. A cured denture that is to be relined should be ground out for the desired amount of material to replace the tissue bearing surface. This is done prior to taking an impression.

Alternate Curing Methods:

- A. Hot water bath cure. One and one-half (1 1/2) hours in hot water at 163°F (73°C) then boil at 212°F (100°C) for one-half (1/2) hour.
B. Cure for eight (8) hours in hot water at 163°F (73°C) temperature.
C. Bench cool for 30 minutes. Cool to room temperature in cold tap water.
17. NOTE: Store raw materials in a cool, dark atmosphere for extended shelf life.

PACKAGING AVAILABLE:

Table with 2 columns: Grp/Item # and Description. Lists various denture reliner kits including Semi-Rigid, Soft, Very Soft, and Powder options in 8 oz and 1 lb quantities.

Products for Better Dentistry

Additional questions, to place your order, or for the Dealer nearest you, please call the Tooth Express Order Desk at 800-628-1437.