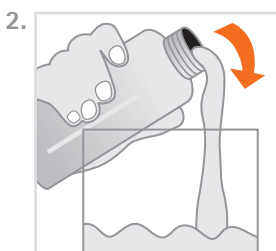




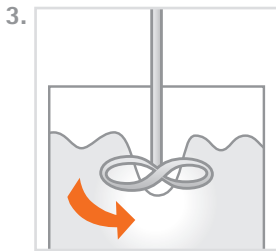
### 1. Product description

pro3dure's generative resin **GR-15 gingiva** is a resin for the generative production of dental objects based on image projection systems ( $\leq 405$  nm). The formulation of **GR-15 gingiva** is optimized for the requirements of a robust production guaranteeing constant high quality. The material can be used for build processes with layer thicknesses from 25-100  $\mu\text{m}$ . It is recommended to use the **CD-1** or **CD-2** curing device from pro3dure medical for post curing.



### 2. Processing

- **GR-15 gingiva** bottles should be well shaken before use (fig 1).
- Make sure that **GR-15 gingiva** material is adjusted to temperature range 23 °C to 30 °C.
- Carefully pour **GR-15 gingiva** into the vat of the image projection unit (fig 2).
- Bubbles can be removed with a cleaned spatula or by a recoater routine.
- If it is possible, always store a bottle **GR-15 gingiva** in your production unit in order to avoid temperature differences during refilling.
- For the build parameter adjustment please refer to the machine data sheet.
- After the build process is finished a direct post treatment is recommended. If this cannot be done at the time leave the produced objects in the liquid **GR-15 gingiva** resin.
- After cleaning the parts with isopropanol  $\geq 97$  % (approx. 3-5 min. in an ultrasonic bath) the objects are postcured in a light curing unit (e.g. pro3dure's **CD-1** or **CD-2** for a period of 3-4 min.) in a protective gas atmosphere.
- The dental objects generated out of the generative resin **GR-15 gingiva** can be repaired with **GR-15 gingiva** resin.
- Impurity due to operation mistakes cannot be excluded. With respect to the low viscosity of the resin it is possible to filtrate the **GR-15 gingiva**. It is recommended to filter and stir up the resin on a regular base (fig 3). To avoid bubbles let **GR-15 gingiva** rest for 1 hour before usage.



Contains: Urethanedimethacrylates, initiators, dyes and stabilisers.

### 3. Important

- To avoid detrimental effects on material quality do not expose the liquid material to irradiation under any circumstances.
- Deviations from the described manufacturing process may lead to different mechanical and optical properties of the **GR-15 gingiva** material.
- Wear personal protective gear during processing.
- Caution: Polymerised resins are chemically resistant - avoid stains on clothing!
- Avoid any contact with skin and eyes. In case of accidental contact, rinse with adequate running water. Consult a doctor if necessary.
- The lot number and the expiration date are indicated on each bottle of **GR-15 gingiva**. In case of claims please always indicate the lot number of the product. Do not use the product after expiry of the best before date.

**GR-15  
gingiva**

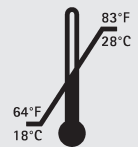
### Safety advice

pro3dure medical GmbH is not liable for any damages caused by improper application of the material. To be used by trained specialist personnel for the purpose indicated only.

**Product description:**  
photopolymerizable resin for the production of dental objects by image projection systems ( $\leq 405$  nm)

#### Technical data:

- Colour: orange red transparent
- Density: ca. 1.1 g/ml
- Viscosity: ca. 2,5 Pa s
- Post cured material: (depends on postcuring unit)  
Hardness: ca. 60 Shore A
- Storage:



#### Ordering information:

Standard packing:

1kg bottle,  
orange red transparent  
item no.: D1000340

These data result from measurements of a representative sample, which were determined within the scope of our quality assurance.