

The HATHO Polishing Guide

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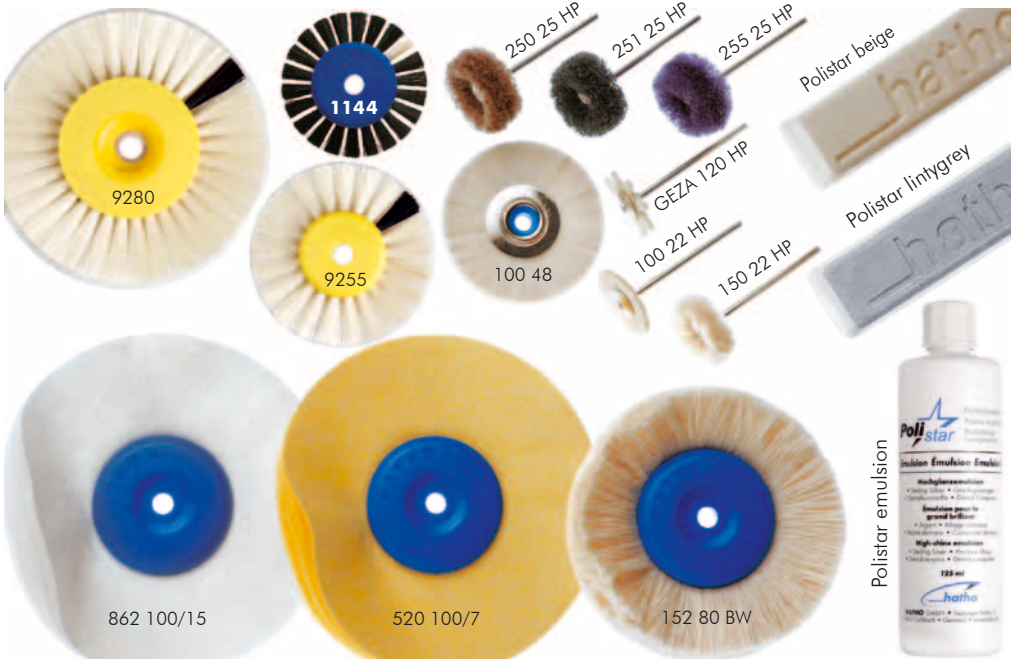
ACRYLIC DENTURES





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Item number	Description	Intended use	Pages
250 25 HP	SB Wheels, coarse	pre-polishing	1
251 25 HP	SB Wheels, medium	pre-polishing	1
255 25 HP	SB Wheels, fine	pre-polishing	1
GEZA 120 HP	White bristles, geared	pre-polishing	2
100 22 HP	White goat hair	pre-polishing	2
Polistar lintygrey	Acrylic pre-polishing compound	pre-polishing	2
9280	Poly-Buff, big wheel	pre-polishing	3
9255	Poly-Buff, medium wheel	pre-polishing	3
1144	Chungking bristles, 1-row	pre-polishing	3
100 48	Goat hair, Slimline brush	shine polishing	4
862 100/15	Zeta-Polishing disc	shine polishing	4
520 100/7	Microfiber - leather	shine polishing	4
150 22 HP	Cotton thread	High shine polishing	5
152 80 BW	Cotton thread	High shine polishing	5
Polistar beige	Acrylic high shine compound	High shine polishing	5
Polistar emulsion	Acrylic high shine emulsion	High shine polishing	5

Pre-polishing using Hatho Scotch Brite™ Wheels

After deflasking, remove excess material and finish to desired shape using carbides and other rotary instruments.

The surface of the prosthesis is now covered with scratches from finishing which have to be smoothed without altering the carvings.

The HATHO manufactured SB Wheels utilized in different variations is used for this application.



The rough brown wheel (ArtNo. 250 25 HP) has the strongest abrasion and is also excellent for finishing soft liner acrylics. The grey wheel with medium granulation (ArtNo. 251 25 HP) and the purple, fine grained wheel (ArtNo. 255 25 HP) leave a silk matte surface.



Avoid high speeds during polishing. The best results are achieved using 5,000 rpm's under light pressure. This ensures that the acrylic does not overheat due to friction.

Using the Scotch Brite™ wheel, a polishable surface is achieved without ruining carefully carved anatomical surfaces.

The surface is now ready for optimum polishing, using HATHO brushes.



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Pre-polishing with a micro-motor



The denture is now ready for polishing with the Brushes.

The acrylic prosthesis now has an even surface without large scratches. The smaller, hard to reach areas such as interproximal areas, gingival margins, palate wrinkles, or the finishing line between metal and acrylic on partial frameworks may not have been reached by the first surface conditioning.

To achieve a high sheen in these areas, an additional step using the micro motor or a lathe is recommended before going to the polishing unit.



In this case, two different miniature brushes are used.

Their minor diameter and narrow shape allow them to reach nearly every area. The jagged brush (ArtNr. GEZA 120 HP), consisting of stable bristles, removes rougher finishing marks.

The softer goat hair brush (ArtNr. 100 22 HP) achieves a pre-polished surface.



Ideal results are gained using 10.000 rpm's and using our novel polishing compound (Polistar linygrey).

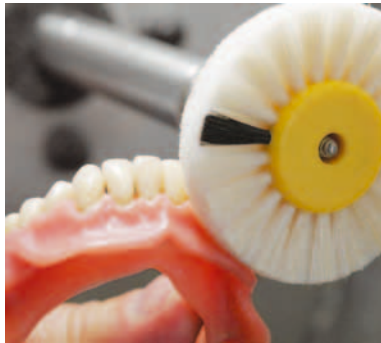
This innovative product from HATHO can be used , wherever pumice was used. Due to its soft consistency, it is easily taken into the slightly rotating brush and is very economical in application.

This also keeps your work station clean and is also a healthier alternativ to pumice or pumice free materials with free silica.



Pre-polishing at the polishing unit

The next steps are carried out at the polishing unit, using brushes with a disc inside (*Poly-Buffer*)
Due to its characteristics, such as stability combined with flexibility, this new type of brush preferably used for acrylic dentures.
For effective polishing of large surfaces it is suitable to use a *Poly-Buffer*. Two rows of white bristles with a layer of white Scotch Brite™ Ø 80 mm (*ArtNo. 9280*).



Smaller, bumpy surfaces, such as anatomically formed gingiva, especially in the anterior areas, are preferably polished with the medium *Poly-Buffer* (*ArtNo. 9255*).
Due to its smaller size of Ø 55mm, carefully carved anatomy is not worn away during polishing procedures when using the larger brush.

Small crevices are best reached by using the one row brush (*ArtNo. 1144*) on which the bristles have gaps in between. Also here we use the newly developed (*Polistar linygrey*) This is a vast improvement, compared to the splattering, unhygienic pumice.
Only using 1400 rpm 's and under light pressure, a distinct effect is achieved in a very short time.
The optimum surface polishing has been achieved and brought to a shine.



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Polishing to a shine



The prosthesis now has an even surface and is ready for first stage polishing.

We will now use the Polistar beige polishing compound, especially developed for acrylic denture base material.

(*Polistar beige*) This ultra fine polishing compound removes the fine marks originating from the pre-polishing compound.

To obtain optimal results, make sure the surface is clean.

All Brushes and polishing discs for shine polishing should be store separately.

It is best to use soft materials such as a compound carrier, which has the ability to pick up a lot of paste and gradually release it during the polishing process.

These features are found in goat hair brushes and discs made of microfiber-leather (*ArtNo. 520 100/7*).

The polishing disc is used for larger surfaces. The newly developed Zeta – Polishing cloth (*ArtNo. 862 100/15*) can also be used.



The narrow goat hair brush (*ArtNo. 100 48*) gets into hard to reach areas such as interproximal areas, gingival margins, palate wrinkles and the finishing line between metal and acrylic in combined cases with partial frameworks.

To reduce heat development, 1400 rpm 's have proven to give the best results. The acrylic surface is now ready for the final stage, polishing to a high shine.



Polishing to a high shine

Always use a cotton yarn buff (ArtNo. 152 80 BW) for polishing to a high shine. It reaches nearly every part of the prosthesis with its single flexible threads. The special wax of the Polistar beige seals the surface of acrylic.

In this procedure, only use 1400 rpm`s and light pressure to avoid overheating and damaging the acrylic.

After all put sparingly some Polistar emulsion on the acrylic surface. Together with the cotton buff you will create a perfect high shine.



For partials and smaller areas, it is recommended to use the micro-motor and the miniature cotton buff (ArtNo. 150 22 HP) The buff condense the surface, by using leftover polishing compound from the previous polishing Step. Use Polistar Emulsion to finalise you work of art.



The result is convincing. No scratches or "forgotten" matte areas. A prosthesis polished in this manner offers a surface, that dirt and plaque will not cling to. A high gloss, optimum condensed surface is apparent in a short time.





Polistar

polishing compound



hatho

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