

Finishing and Polishing Recommendations



NOTE: Keystone Industries recommends polishing only the edges and occlusal surfaces of a KeyDenture® Base. Polishing the intaglio surface can adversely impact the fit of the printed device. Keystone Industries provides all materials and items needed for a perfect high-shine polish through your preferred distributor.

SUPPORT REMOVAL



PROCESS

 **TIME: 5-10 MINUTES**

- Grind supports down with a Scotch-Brite Dremel bit
- Optional: you can take steps to remove remaining printing lines/texture from print with an Abrasion Disc sanding wheel (Fine Blue)
- This process is fast and can eliminate any trace of layer lines/surface defects on the edges and the occlusal surfaces prior to polishing (below). This makes polishing process quicker, more consistent, and with limited defects

MATERIALS

- Scotch-Brite Medium Wheel – removal of support pin marks
- Fine Blue Abrasion Disc - elimination of remnant print lines and residual material from surface



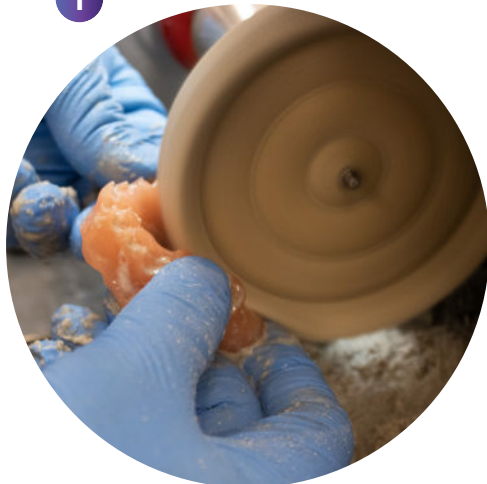
Fine Blue Abrasion Disc
(1670099)



Scotch-Brite Medium
(1670092)

POLISHING

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STEP 1: PUMICE

 **TIME: 5-10 MINUTES**

- Fill lighted shield tray with pumice
- Add sufficient water so that the pumice is more than damp and slightly flowable to make reapplication of pumice during polishing easier
- Use the 4x42 cloth wheel surface to reach all edges and occlusal surfaces.
- Dampen the wheel with some water before pumice application for optimal results
- Coat the part in pumice and begin to finish the occlusal surface.
- Firm and consistent pressure is recommended for consistent and predictable results on low speed for pumice. If speed is too fast, you risk burning fibers into the material due to friction.

MATERIALS

- Coarse pumice, or synthetic pumice substitute
- 4x42 cloth wheel (1180170) - larger and flatter surface area is best



Coarse pumice



4x42 cloth wheel
(1180170)

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STEP 2: HIGH-SHINE POLISH

 **TIME: 3-5 MINUTES**

- Install new 5x45 cloth wheel dedicated to high-shine materials
- Apply high-shine polishing compound to the wheel until fully coated and repeat as necessary through the process
- Begin to polish the device by applying firm pressure as you polish the entire occlusal surface, looking to achieve a uniform finish with a high shine
- Be sure to avoid too much pressure in areas where surface details and contours are desired as detail may become smooth, especially with any bonded teeth.

MATERIALS

- Polishing options:
 - White or light beige polishing compound (Beige 90g polishing bar 1670110)
 - Other available light or white dental high-shine polishing compounds
 - High-Shine Emulsion Liquid (1670200)
- 5x45 cloth wheel (1180190) - larger and flatter surface area is best



Beige polishing bar
(1670110)



5x45 cloth wheel
(1180190)