

# Instructions for Use – Flexcera® Smile Ultra+ for Carbon® Printers Light Curable Resin

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## 1. – Introduction

*Flexcera® Smile Ultra+* is a light-curing resin for the additive manufacturing of:

- artificial teeth for dental prostheses, which are one of the main components in the fabrication of removable permanent full dentures.
- individual permanent full single crowns and permanent partial crowns in anterior and posterior region, including inlays and onlays.
- temporary bridges including implant supported bridges.
- individual permanent veneers.
- individual and removable monolithic full and partial dentures for later individualization by light curing color composite pastes or liquids.

It has been optimized for use with Carbon® M2, M3 and M3 Max printers and may only be used together with these printers and the corresponding software systems **Flexcera® Smile Ultra+ is a medical device classified as class IIa according to Regulation (EU) 2017/745**. Dental applications from *Flexcera® Smile Ultra+* may only be manufactured by dental technicians and dentists and must be inspected by authorized practitioners, such as dentists, before they are released to the patients.

Temporary applications from *Flexcera® Smile Ultra+* are custom-made products that may be used up to one year, under consideration of their application and intended exclusively for one patient. Dental applications from *Flexcera® Smile Ultra+* are custom-made products for long-term use, under consideration of their application and intended exclusively for one patient.


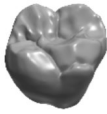

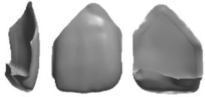
The target group is patients which need restorations or optimization of the teeth, whereby high-risk patients are excluded (see Section 3). The use of the medical device is independent of the age and sex of the patient. The decision related to the patient application is at the discretion of the respective medical specialist. The following Instruction for Use includes safety and environmental information, manufacturing instructions, and post-processing procedures of the product, which must be strictly adhered to.

## 2. – Indication


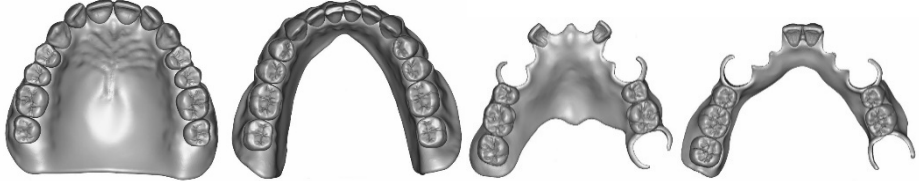
**Flexcera® Smile Ultra+** is an alternative to traditional heat-curable and auto polymerizing resins. The resin is intended exclusively for professional dental work. Fabrication of dental applications with **Flexcera® Smile Ultra+** requires a computer-aided and manufacturing (CAD/CAM) system that includes the following components: digital dental files based on a digital impression or, in case of artificial teeth for dental prostheses, digital dental files based on manufacturer's data, a digital light processing (DLP) printer, and curing light equipment.

### Authorized applications:


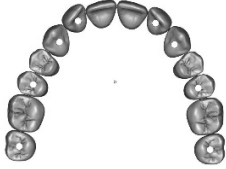

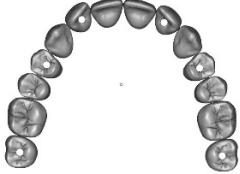
#### Crowns, Veneers:

			
Full anatomical single crown in anterior region	Full anatomical single crown in posterior region	Partial crown (Inlay/onlay /overlay)	Veneer





#### Artificial teeth, monolithic full and partial dentures:

	
Artificial teeth for dental prostheses	Monolithic full and partial dentures* * monolithic full dentures even implant supported

**Bridges:**

<p>Full anatomical monolithic bridge for anterior and/or posterior region <u>with no pontic</u> (e.g. 6-unit bridge)</p>	<p>Full anatomical monolithic bridge for anterior and/or posterior region with pontics and/or implant supported (e. g. implant supported full arch bridges such as “Toronto bridge” or other implant supported bridges)</p>
	
	

**Flexcera® Smile Ultra+** is available in the following colors:

- Bleach 
- A1  **Flexcera® Smile Ultra+ A1** is comparable to VITA® classical, colors A1, C1, D2 Dentin
- A2  **Flexcera® Smile Ultra+ A2** is comparable to VITA® classical colors A2, D4 Dentin
- B1  **Flexcera® Smile Ultra+ B1** is comparable to VITA® classical color B1 Dentin

### 3. – Contraindications

**Flexcera® Smile Ultra+** should not be used for purposes other than those identified herein. Any deviation from these instructions for use may have negative effects on the physical and/or chemical qualities of the resin and the biocompatibility of the end product. Dental applications from **Flexcera® Smile Ultra+** should not be used in patients if there are known allergies to any of the ingredients (see Section 4). Possible side effects may include shortness of breath, gastrointestinal complaints, dizziness, anaphylactic reactions, or shocks, itching and tearing (watery) eyes, headaches, or reactions of the skin or mucous membranes such as irritation, rash, swelling, inflammation, redness, wheals or blisters or other allergic reactions.

### 4. – Composition

Acrylates, methylacrylates, methacrylated oligomers and monomers, photo initiators, colorants/dyes, fillers and absorbers.

### 5. – Warnings

- Review the SDS prior to use.
- **Flexcera® Smile Ultra+** may only be used for the production of:
  - artificial teeth for dental prostheses, which are one of the main components in the fabrication of removable permanent full dentures.
  - individual and fixed temporary or permanent full single crowns and temporary or permanent partial crowns in front and posterior area.
  - temporary bridges including implant supported bridges.
  - individual and fixed single veneers.
  - individual and removable monolithic full and partial dentures for later individualization by light curing color composite pastes or liquids.
- Any deviation from the Instruction for Use can negatively affect the chemical and physical properties and biocompatibility of the finished product.
- Do not substitute any of the components of the device system, i.e., device photopolymer materials, scanners, 3D printers, post-curing units, CAD/CAM software, templates, and tools. Use only those specifically identified in this labeling. Unauthorized changes may result in a device that is outside of specification. Contact the manufacturer for compatible components.
- Maintain and calibrate equipment according to manufacturer instructions.
- Products from **Flexcera® Smile Ultra+ light curable resin** cannot be sterilized. See section 12 for disinfection procedure.
- Wear protective gloves, protective clothing, eye protection, face protection while handling **Flexcera® Smile Ultra+ light curable resin**.
- In case of skin contact with the resin, wash with plenty of water.
- In case of eye contact, rinse cautiously with water for several minutes. Remove contact lenses, if necessary and easy to do. Continue rinsing. Consult a physician.
- If swallowed, immediately call the poison center.
- Any patients who come in contact with products from **Flexcera® Smile Ultra+ light curable resin** must be informed of potential side effects before use (see Section 3).

## 6. – Precautions

- Wear protective gloves, protective clothing, eye protection, face protection.
- Use in appropriately ventilated area. Avoid breathing dust/fume/gas/mist/vapors/spray.
- **Flexcera® Smile Ultra+ light curable resin** must be stored in the original material bottle between 5°C and 30°C.
- **Flexcera® Smile Ultra+ light curable resin** must be protected from exposure to light, as spontaneous polymerization is possible. The bottle must be tightly closed after every usage and material removal. The resin must be used prior to the expiration date printed on the label.
- Dental applications from **Flexcera® Smile Ultra+** must be protected from exposure to light while not in use.

## 7. – Storage Conditions, Expiry Date and Re-use of Material

- **Flexcera® Smile Ultra+ light curable resin** must be stored in the original material bottle between 5°C and 30°C.
- While removing the resin it must be protected from exposure to light, as spontaneous polymerization is possible. The bottle must be tightly closed after every usage and material removal.
- An expiration date is displayed on the label of every material bottle. The use of expired material is not permitted.
- The resin inside the cassette can be re-used for several build jobs. If the level in the cassette is too low for subsequent jobs, resin from the bottle can be added as necessary. If the material is not in use, the remaining material in the cassette must be thoroughly mixed and filled back into the bottle. For further information on re-using and mixing material, please check the printer's *User Manual*.
- Dental applications from **Flexcera® Smile Ultra+** need to be protected from exposure to light before the final use, while not in use and during storage.

## 8. – Notes on Disposal

Dispose of **Flexcera® Smile Ultra+ light curable resin** and material bottle in accordance with local regulation. Manufactured dentures which are used on patients must be disposed of in accordance with local regulation due to the risk of contaminated by substances of human origin.












## 9. – Use of Software Systems and Products from Other Manufacturers

The use of certified software systems for generating the STL data, as well as the use of any other additional medical products or auxiliary products to manufacture crowns, veneers, artificial teeth for dental prostheses and monolithic full and partial dentures, such as e.g. light-curing stains and composites for individualization, bonding agents for fixing artificial teeth with denture base, luting composite for bridge, crown or veneer fixing, material for full denture bases or implants and abutments as retaining element inside patients mouth etc. depends on the user(s) assessments.

## 10. – Delivery Unit, Symbol Explanation

Delivery unit: **Flexcera**<sup>®</sup> *Smile Ultra+* is available in containers of 1 kg.

Symbol explanation:

	Batch number		Protect from sunlight
	Expiration date (YYYY-MM-DD)		Follow Instruction for Use
	Manufacturer		Temperature limit
	Catalogue number		Manufacturing date (YYYY-MM-DD)
	CE-Mark		Unique device identification
	Medical Device		

## 11. – Manufacturing Instructions

### A. SUPPLIES NEEDED

1. Carbon<sup>®</sup> M2, M3 and M3 Max printers.
2. Cassette for use with **Flexcera**<sup>®</sup> *Smile Ultra+ light curable resin* only.
3. **Flexcera**<sup>®</sup> *Smile Ultra+ light curable resin*.
4. **Flexcera**<sup>®</sup> *Baselight* curable resin, or conventional denture base materials, if fabricating artificial teeth for dentures.
5. Carbon Printer UI.
6. File in .stl format
7. Paper towels.
8. Cone-shaped funnel.
9. Personal protective equipment, as per SDS.
10. Magnetic stirrer with bar, or lab shaker.
11. Isopropyl Alcohol min. >96%.
12. Post curing unit:
  1. Otoflash G171
  2. Wicked Engineering CUREbox Plus
  3. Dreve PCU LED N2
13. Pipette.
14. Standard dental polishing equipment.

## B. DESIGN INFORMATION

The scanning and construction of patient(s) STL data is the responsibility of the customer. Only trained dental personnel must perform the scanning and design. Further, certified software must be used, such as from e.g., 3Shape A/S.

### Construction rules

#### Crowns and veneers:

Crowns made of **Flexcera® Smile Ultra+** must be adhesively fixed to a prepared natural tooth stump or an artificial tooth stump such as an implant abutment or post and core.

Veneers made of **Flexcera® Smile Ultra+** must be adhesively fixed to a prepared natural tooth stump.

#### Minimum wall thickness

Occlusal: 1.5 mm in central fissure

Circular: 1 mm

Parts must be built horizontally orientated to the platform, with supports connecting only to the occlusal or incisal surface e.g., to avoid manual post processing of the sides in direct contact with the mating surface.

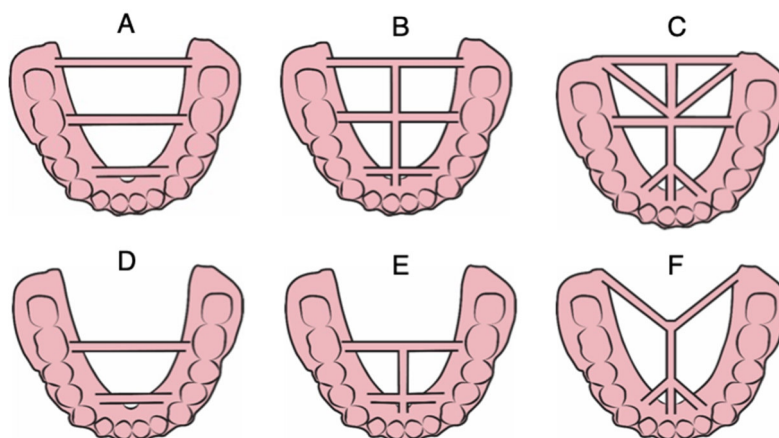
#### Monolithic full dentures:

Monolithic full dentures made of **Flexcera® Smile Ultra+** must be designed without any additional fixtures to increase holding force. Design the denture base using the certified software based on the digitalized data obtained from the bite registration process. **The minimum approved wall thickness is 2.5mm.**

Parts must be built vertically orientated to the platform, with supports connecting only to the labial border, to avoid manual post processing of the sides in direct contact with oral mucosa.

A connector must be added to the design of the lower denture base to ensure the stability of the part during fabrication and accuracy of the part(s) dimensions/fit once finished. The connector designs in *Fig. 1* are permitted (Figure 1 is recommended, as it will require the least amount of material while ensuring high accuracy).

*FIG. 1 VALIDATED CONNECTOR DESIGNS FOR LOWER DENTURE BASE*



#### Monolithic partial dentures:

Monolithic partial dentures made of **Flexcera® Smile Ultra+** must be designed without any additional fixtures to increase holding force, except for the clasps. **The minimum approved wall thickness of the denture as well as for the clasps is 2.5mm.**

#### Bridges:

The temporary bridges made of **Flexcera® Smile Ultra+** must continuously consist of full anatomical crowns, need to be end pillar bridges and need to be adhesively fixed to the bridge pillars (prepared natural tooth stump and/or an artificial tooth stump) e.g. "Toronto bridge or other implant supported bridges".

Minimum connector cross-section

Anterior region: 12 mm<sup>2</sup>

Posterior region: 14 mm<sup>2</sup>

Minimum wall thickness

Occlusal: 1.5 mm in central fissure

Circular: 1 mm

Parts must be built horizontally orientated to the platform, with supports connecting only to the occlusal or incisal surface e.g., to avoid manual post processing of the sides in direct contact with the mating surface.

## C. PREPARING TO PRINT

### **Preparing the Material:**

**Flexcera® Smile Ultra+ light curable resin** must be properly mixed before use.

**Prepare the material:** Before using this material for the first time or after prolonged storage, it must be homogenized. Shake the material bottle vigorously for approximately 5 minutes. Be aware that vigorous shaking may cause air bubbles to form. Allow the material to rest in the bottle for an additional 5 minutes to allow any air bubbles to rise and dissipate before use.

### **Preparing the 3D Printer:**

Setup the 3D printer for **Flexcera® Smile Ultra+ light curable resin** (see the *User Manual for the specific 3D printer used*). Fill the cassette. Use a spatula (not sharp) or a material mixing card to carefully mix material in the cassette. Mix until there is a uniform color. Take care not to damage the surface of the cassette.

To avoid contamination, a separate cassette dedicated to **Flexcera® Smile Ultra+** material must be used.

### **Preparing the STL for 3D printing, Software Considerations:**

To prepare the .stl file for 3D printing and generate the support structures, use the Carbon Printer UI.

Select the appropriate resin shade in the Carbon Printer UI. There are two options in the printer UI resin menu:

- **Flexcera® Smile Ultra+** Bleach for use with the Bleach shade
- **Flexcera® Smile Ultra+** (A1, A2, B1) for use with the A1, A2, or B1 shades

Transfer constructed STL files of planned applications to the printer. See the *printer's User Manual / Software User Manual*.

## D. STARTING THE PRINT

Start the printing process as described in the *printer's User Manual*.



## E. REMOVE PARTS FROM PRINTER

When the printing process is complete, carefully remove the parts from the build platform.

**NOTE:** Always wear personal protective equipment when interacting with uncured material.

1. Open the printer's hood.
2. Remove the build platform from the printer.
3. Place the build platform on a sturdy surface. Use the provided scraper from the Starter Kit to carefully remove all parts from the build platform. Place parts on a clean paper towel and protect from ambient light.

## F. CLEANING THE PARTS

Set up the magnetic stirrer with a bar or lab shaker in the Post Processing area and add Isopropyl Alcohol (min. >96 %) into an appropriately sized container. *See the stirrer / shaker manual for setup instructions.*

Clean the parts using the following procedure:

1. Clean in Isopropyl Alcohol (min. >96 %) for a maximum of 5 minutes in the stirrer or lab shaker (no ultrasonic bath). Clean and rinse gaps separately under pouring conditions.
2. Dry with compressed air.
3. Clean in Isopropyl Alcohol (min. >96 %) for a maximum of 2 minutes in the stirrer or lab shaker (no ultrasonic). Clean and rinse gaps separately under pouring conditions.
4. Dry with compressed air.
5. Parts must be completely dry before post-curing, e.g. airdry @ 15 min.
6. Remove the supports with a scalpel or similar tool.

## G. WHEN PRINTING ARTIFICIAL TEETH FOR DENTURES:

### ASSEMBLING THE DENTURES:

Artificial teeth printed with **Flexcera® Smile Ultra+** may be bonded to denture bases printed with **Flexcera® Base light curable resin** or conventional denture base materials.

**If using Flexcera® Base (see Flexcera® Base IFU for manufacturing instructions):**

1. The 3D printed dentures and the printed artificial teeth must be uncured and unpolished prior to adding bonding agent (optional) and attaching to the denture.
2. Use the pipette to place drops of uncured **Flexcera® Base** in the alveoli.
3. Immediately after place the teeth over the liquid photopolymer.
4. Follow with the step "Post-cure the part"

**If using conventional denture base materials:**

1. The artificial teeth need to be post cured as described in step “Post-cure the part”.
2. The tooth neck may be sandblasted or ground with a dental milling machine prior to adding a bonding agent.
3. A bonding agent must be used to coat the tooth neck.
4. The Instruction for Use of the conventional denture base material has to be followed (Recommendation: Cold polymerization process).

**Post-cure the part** using the light curing unit: Otofash G171; Parameters: 2x3000 flashes (i.e., 3000 flashes per side); Recommendation: under inert gas (e.g., nitrogen) or the Wicked Engineering CUREbox Plus; Parameters: 2x 25minutes with 50°C. The Dreve PCU LED N2 can be used alternatively when using conventional denture base materials, Parameters: 90% Power for 18 minutes under vacuum.

### **Finishing the dentures:**

1. Use a commercial dental handpiece to clean the remaining support structures and remove excess resin around the teeth.
2. Optional: Individualize with light-curing coloring materials for a better cosmetic effect, according to the Instruction for Use of the color material manufacturer.
3. High gloss polish the surface with a commercially dental hand piece or dental polishing machine.
4. Post-cure the product in the Otofash G171 with 1000 flashes, with the Wicked Engineering CUREbox Plus for 5 minutes without temperature or in the Dreve PCU LED N2 with 90% power for 3 minutes under vacuum.
5. The product can now be used on the patient.

The post-curing process may cause minor temporary color deviation of artificial teeth built using **Flexcera® Smile Ultra+**. The color will stabilize within 6 days.

## **I. WHEN PRINTING CROWNS, VENEERS, BRIDGES AND MONOLITHIC DENTURES**

1. Post-cure the part using the light curing unit:
2. Otofash G171; Parameters: 2x3000 flashes (i.e., 3000 flashes per side); Recommendation: under inert gas (e.g., nitrogen), the Wicked Engineering CUREbox Plus; Parameters: 2x 25minutes with 50° or Dreve PCU LED N2; Parameters: 90% Power for 18 minutes under vacuum.
3. For lower full dentures only: Remove the connector with a scalpel or similar tool.
4. Optional: Individualize with light-curing coloring materials for a better cosmetic effect, according to the Instruction for Use of the color material manufacturer.
5. High gloss polish the surface with a commercially dental hand piece or dental polishing machine.
6. Post-cure the product in the Otofash G171 with 1000 flashes, with the Wicked Engineering Curebox Plus for 5 minutes or in the Dreve PCU LED N2 with 90% power for 3 minutes under vacuum.
7. The product can now be used on the patient.

The post-curing process may cause minor temporary color deviation of the printed dental parts built using **Flexcera® Smile Ultra+**. The color will stabilize within 6 days.

## **12. – Disinfection and Sterilization**

Printed dental parts made of *Flexcera® Smile Ultra+ light curable resin* can be disinfected with any of the following disinfectants:

- 70 % Ethanol solution in water
- Green&Clean AD
- MD 520
- PrintoSept-ID
- Dentavon

The disinfecting solutions must be used according to the manufacturer's instructions. Products from **Flexcera® Smile Ultra+ light curable resin** cannot be sterilized.

## 13. – Cleaning Instructions for Dentures

The denture can be cleaned by the patient with clear water, a toothbrush, and toothpaste. Avoid abrasive or whitening agents in some kinds of toothpaste which can damage the surface of the denture. After cleaning with clear water, the denture should be dried and not soaked in liquid.

**Note:** Care should be taken to ensure that the dentures are not shipped or stored soaking in water as this can adversely affect the mechanical properties.

## 14. – Reporting undesirable effects

In the event of adverse effects, reactions, or similar occurrences arising from the use of these products, including those not listed in this Instruction for Use, these must be reported immediately by opening a support ticket via the website <https://envisiontec.com/> and to the competent authority of the Member State in which the user and/or patient is established.

## 15. – Manufacturer

### EnvisionTEC GmbH

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45968 Gladbeck  
Germany

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E-Mail: [info@envisiontec.de](mailto:info@envisiontec.de)  
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## 16. – Legal Disclaimer

The manufacturer does not accept any liability for damages or injury caused by any other use of the material. Furthermore, before using the material, the user must independently check for its suitability and applicability for the intended use.

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