The HATHO Polishing Guide 2

Partial Framework

hatho

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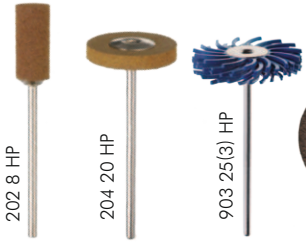

121 36 654 40x05 H 121 42

Polistar Green

Polistar White

1270 520 100/7 152 80 BW

Polistar Emulsion

PF1 - PF4

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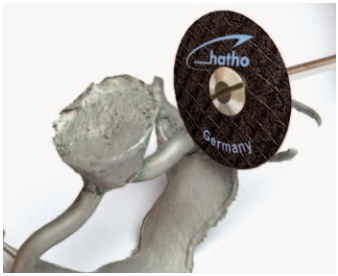
Trimming and Electrolytic Polishing



After cooling, the investment is removed carefully by using devesting pliers. Further residue is removed through sandblasting.
The sprues are separated and trimmed using fibre reinforced discs (Art.No 654 40x05 H).

Chrome-Cobalt-Molybdenum alloys used for partials usually have a hardness of around 330-370 Vickers.
Therefore ceramic grinders or tungsten carbide cutters are used to process fine pieces.

During the electrolytic polishing process, the surface is polished due to galvanic reduction. The partial acts as an anode and emits metal ions to the electrolyte solution.
Bumps, which have a larger surface, are reduced more in relation to the surroundings and therefore levelled out.
This results in an assimilation of the relief.

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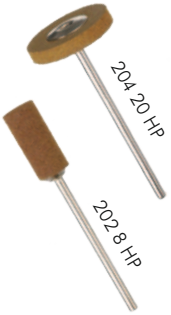
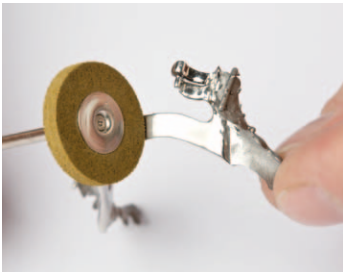
Pre-polishing

HATHOfex S plus P polishers are suited for finishing and pre-polishing. The specific combination of high quality abrasive components (corundum) and stable carrier material and the exceptionally high proportion on abrasive elements (60%), allow a good reduction and smoothening of the surface of extremely hard non-precious alloys.
The cylindrical polisher (Art.No 202 8 HP) has proven best on clasps and palatinal borders.



Die HATHOfex S plus P wheels with a diameter of 20 mm are mainly used for larger surfaces. They can be easily adjusted in size and shape and are therefore the all-rounder for lingual bars.

Recommended are 20,000 rpm.



The difficulties of processing a stippled plate are now a piece of cake due to the blue HABRAS Disc Pro with its fine granulation. (Art.No 903 25(3) HP)
At 5,000 rpm, the single bristle of the HABRAS Disc Pro, nestles itself into the pit of the stippled surface.

Shine Polishing

The pre-polished partial, can now be polished overall. Best suited is the Chunking brush (Art.No 1270). Its relatively large diameter of 70 mm lends the polishing process high efficiency, the short bristles provide the stability needed to apply enough pressure to the surface. To protect the fingers and hands from the developing heat during this process, it is recommended to use HATHO leather finger stalls (Art.No PF 1-4).

Use polishing compound Polistar White. The special composition achieves a uniformly polished surface, even on CrCoMo alloys. The handy Slimline brush with metal core (Art.No 121 42) offers high flexibility. Due to the high density of bristles, it's quick and durable.

A special development of the HATHO company, is the Slimline brush which is knife edge shaped (Art.No 121 36). It is the hardest brush with bristle trimming in the assortment. This product enables users to reach and polish difficult to access areas.

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High Shine Polishing

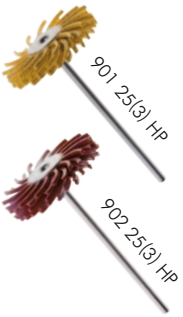
The now optimally prepared metal surface, can be processed with the Microfibre - leather (Art.No 520 100/7) using low rpm.
Best results on CrCoMo alloys can be achieved by using the polishing compound Polistar Green.
The polishing compound is absorbed nicely by the soft fibre and released little by little during the polishing process.

When changing to a finer polishing compound, it is essential to clean the object thoroughly of any residue from other polishing pastes, otherwise the high shine results will not be satisfactory. High shine buffers should therefore always be kept separate and used only with one kind of paste each.

Finish is achieved using the cotton thread buffer (Art.No 152 80 BW) and the HATHO Polistar Emulsion. Using low rpm and low pressure quickly shows clear results.

Only after a short time, a remarkable high shine is achieved.
Even the rough material of a CrCoMo partial framework can be polished quickly and effectively by using the phased products from HATHO.

Specials



Those who don`t have an electrolytic bath, or prefer to work without one, can pre-polish using the novel HABRAS Disc Pro. The coarse yellow disc (Art.No 901 25(3) HP) trims the stipples plate and the red HABRAS Disc Pro (Art.No 902 25(3) HP) polishes at 5,000 rpm the clasps and the palatial border.

The inner surfaces of conus crowns made of CrCoMo alloys are cleansed of small casting pearls and polished to a semi-gloss, by using the mini-bristle brush, made of crimped steel wire. (Art.No 193 p8 HP)

A real challenge is polishing the inner surfaces of attachments.
HATHO offers a large range of Mini bristle brushes with different trimming materials. Here a combi with CEKA-PRECI-LINE attachements

Polistar

Polishing Compounds

hatho

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