

Trim teeth at set up. To:

- expose softer inner layer for better bonding
- provide sufficient thickness of acrylic to support teeth and resist fracturing



1

Boiling out

- soak flask in hot water for approx. 6 mins. (do not allow wax to liquify)
- remove softened wax
- boil out **thoroughly**



2

Separating

- let flask cool for 3-5 mins
- separate
- pour separator into mould to allow optimum absorption to occur



3

Mixing ratios 3:1

By volume

- 30cc powder : 10ml liquid

By weight

- 22g powder : 10ml liquid



4

Mixing consistency

Slowly add powder to liquid. Mix thoroughly to evenly disperse fibres. The mixture may appear dry, resist the temptation to add more liquid.



5

Roughening

After the separating solution has dried, roughen teeth to ensure clean surfaces for optimum chemical bond. Gently blow grindings off.



6

Packing

Acrylic dough is ready for packing when it no longer sticks to the sides of the mixing vessel or the spatula. Estimated time to reach packing stage is 7-14mins, depending on ambient temperature. Acrylic should be packed at the doughy stage to ensure excellent adhesion between the teeth and denture base. **Do not let acrylic reach snap stage.**

Trial pack 2 to 3 times to ensure minimised contraction porosity and maximum acrylic density. Estimated working time 10-12mins.

Thick dentures - Leave packed and clamped denture on bench for 15 - 20 mins (bench cure) prior to processing.



7

Processing

Water temperature is critical in the processing of all denture acrylics. Polymerisation generates high temperatures inside the flask. If the flask is immediately immersed into boiling water, the liquid resin may boil and cause porosity in the denture base.



8

Recommended curing cycles

Short

- Place clamped flask into 75°C water and maintain for 90 mins
- Bring to boil and hold at boil for 30 mins
- Remove and bench cool for 15 mins, then place in cold water for 10 mins, and then deflask

Long (overnight)

- Place clamped flask into 75°C water and maintain for 7 to 9 hours
- Cool slowly to room temperature, and then deflask

Following these recommended curing cycles results in less than 2% residual monomer and ensures porosity free dentures.

For further information and a full list of products used, please contact your representative at:

Deflasked, ready for finishing

