



Factor II, Incorporated

Inventing and Innovating...

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ONLINE ORDERING www.factor2.com

PRODUCT INFORMATION HEAT CURED ACRYLICS

PROCESSING PROCEDURE

The flask is prepared in the usual manner, then immersed in boiling water to remove the wax. Boiling water containing a small amount of detergent is added in small portions until all of the wax is removed. As soon as the mold is comfortable to the touch tinfoil or tinfoil substitute (F-901) is added to the mold. The tinfoil substitute must be dry before proceeding with the packing of the denture.

PROPORTIONS

Measure 24.4 gm. (40 cc, single unit) powder to 10 cc liquid for an average to large denture **Avoid** using less than one-half single unit as this will cause a dry mix.

The powder and liquid must be measured accurately for the best results. Do not add extra liquid to the mix. This will cause porosity in the finished denture.

MIXING

Shake the powder to eliminate any fiber clumping which may have occurred during shipping. The liquid must be poured first into the mixing jar to allow for a complete wetting out of the subsequently added powder. Mix for thirty seconds, making certain to wet out all of the powder. The mix will quickly gain body as it gels. Place the cover on the mixing jar for approximately eight minutes at 23°C (71-75°F), until the mix forms a non-tacky soft dough texture. A cold mixing jar will retard the gelling of the mix.

PACKING

Pack the flask at a flask temperature of 90°-110°F (slightly warm). The dough should be packed when it is free from stickiness, but not rubbery. The dough is made into a roll and condensed with finger pressure into all areas around the teeth, from the base up. Trial pack using moistened cellophane. After the trial pack, remove the excess flash and clamp flask.

FAST CURE

The flask is immersed in a water bath at 72°F (room temperature) and raised slowly to 160°-165°F for a minimum of 1.5 hours, then the temperature of the bath is raised to boiling (212°F) for 30 minutes. The flask is then cooled as described below in the long cure.

LONG CURE

Immerse the flask in a water bath at 72°F (room temperature) and then raise the water temperature to 160°-165°F for a period of eight hours. Thick, bulky cases and thin cases require an additional hour of curing time. At the end of the cure the flask is removed from the water bath and allowed to stand for at least 30 minutes. The flask is then placed under running water for 15 minutes until the flask is at or near room temperature.

REPAIRS

Make repairs, using the appropriate color/fibered product combination. Use only the low temperature technique, if the denture is to be re-flashed. Boiling the flask will induce warpage of the denture. Cold cure denture base resins yield the best properties. For repairs using fast repair acrylics, follow the specific manufacturer's directions for best results.

CAUTION

The liquid contains Methyl Methacrylate (flash point 50°F TAG CLOSED CUP), and is flammable. Avoid inhalation, ingestion, or prolonged or repeated skin contact. Methyl Methacrylate and other acrylic monomers may induce an allergic reaction in susceptible individuals. Store the liquid at 60°-80°F in closed containers.