



## ST. GEORGE TECHNOLOGY, INC.

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### Directions For Use

## Excel Formula Heat-Cure Denture Base Material

Complies with A.D.A. Specification No. 12:1976 Type I, Class 1  
I.S.O. 1567:1988 Type I, Class 1 and B.S. 2487:1989 Type I, Class 1

CADMIUM FREE

### Waxing and Investing

Follow normal laboratory procedures. A good quality flasking plaster is recommended.

### Wax Removal

Immerse flask in boiling water for 3-5 minutes. Remove and bench stand for 2-3 minutes. Open flask, remove softened wax and clean thoroughly with clean boiling water (a little liquid detergent may be used if so desired). Allow flask to cool.

### Isolating Solution (Tin Foil Substitute)

Coat all plaster surfaces with isolating solution. Be sure to remove any excess from around teeth. Allow to dry thoroughly before packing.

### Mixing

Dispense sufficient liquid (approximately 5-10ml) into suitable mixing pot (polyethylene or glass) and gently sprinkle powder into liquid until slight excess is present. Always add powder to liquid. Tap vessel 3-4 times and remove excess powder, then spatulate (mix) for 45-60 seconds. Cover vessel. The recommended powder/liquid ratio is 23.4g/10ml.

### Dough and Working Time

Excel Formula Heat Cure Denture Acrylic reaches the snap dough consistency in 5-6 minutes at  $23^{\circ}\text{C} \pm 2^{\circ}\text{C}$  ( $73^{\circ}\text{F} \pm 4^{\circ}\text{F}$ ) and remains in a working consistency for  $25 \pm 5$  minutes. Lower or higher ambient temperatures will affect these times.

### Packing

Mold the dough to ensure homogeneity and pack into flask with slight excess. A trial pack procedure is optional, but recommended. Cover with polythene separating sheet, replace flask lid and apply pressure slowly under bench press. Open flask, remove polythene and trim away excess "flash" with a sharp instrument. Replace lid and close completely under bench press. Finally, clamp securely prior to curing.

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## Curing

### Method A —

Bring the water to a boil. Turn off heat and place flasks into water ensuring that they are covered with at least 5-7cm (2-3 inches) of water. Do not replace lid of water bath at this time. Leave in the bath for 20 minutes. After 20 minutes turn on the heat and bring the bath back to a boil within 5-10 minutes (not less than 5 minutes). Next, boil the immersed flasks for at least 15 minutes. Remove from the bath and allow to bench cool for a **minimum** of 10 minutes, before immersing in cold water to cool completely before deflasking.

### Method B —

Place flasks in boiling water. Ensure that the flasks are fully covered with at least 5-7cm (2-3 inches) of water. Bring the bath back to boiling within 5-10 minutes (not less than 5 minutes). Boil for 20 minutes. Remove from the bath and allow to bench cool for a **minimum** of 10 minutes, before immersing in cold water to cool completely before deflasking.

### Method C —

Place flasks in warm water ensuring that they are covered with at least 5-7cm (2-3 inches) of water. Heat at 85°C (185°F) for 8 hours. After 8 hours ensure flasks are covered with at least 5 cm (2 inches) of water and boil for a further 15 minutes. Remove from the bath and allow to bench cool for a **minimum** of 10 minutes, before immersing in cold water to cool completely before deflasking.

### Method D —

Cure as per ANSI/ADA specification No. 12 for denture base polymers Sec. 4.3.2.

### Microwave Method —

Pack in microwaveable flask ensuring enough material to fully fill the flask. Process in a 600 watt microwave oven on a revolving table for 4 minutes. We would recommend 2 minutes on one side, turn the denture over and microwave for a further 2 minutes on the other side. For partials we would recommend a microwave time of 3 minutes, 1½ on each side. Bench cool for at least 15 minutes. Quench in cold water to completely cool before deflasking.

Finish and Polish in the usual manner.

## Additions and Repairs

For maximum strength, any fractures or additions are best made using the heat cure technique. Autopolymerizing repair resins such as the St. George Technology Excel Formula Auto-Cure denture repair material may also be used.

## Storage

Dental acrylics based on methyl methacrylate should be stored in a cool (16-26°C, 61-79°F), dry place. Avoid prolonged exposure to sunlight. Keep containers closed when not in use.

## Caution

Liquid contains methyl methacrylate monomer. Highly flammable, keep away from sources of ignition. NO SMOKING. Irritating to eyes, skin and respiratory system. May cause sensitization by skin contact. Keep container in well-ventilated area. Do not empty into drains. Take precautionary measures against static discharge. Wash hands thoroughly with soap and water after each use. In case of accidental contact with eyes, wash with warm water for 10 minutes and seek medical attention.

St. GEORGE TECHNOLOGY, Inc. warrants that the product(s) contained in this package shall conform to the specifications for this product as represented to the Federal Food and Drug Administration. When used in accordance with our directions and good laboratory practices, this product will achieve optimum results. St. George Technology, Inc. agrees to replace, at its option, any product which is found to be defective.

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