



FLASKING

Use conventional dental compression molding methods and gypsum material for flasking.

WAX ELIMINATION

Soften wax in boiling water for approximately 6 minutes. Separate flask halves and remove wax by flushing with a solution of boiling water to which a dye free, fragrance free, granular detergent has been added. Use clean boiling water for final flush. **DO NOT USE WAX SOLVENTS!** Be sure case is free of wax and detergent film.

TRIAL PACKING

Use excess of resin mix on initial pack, close flask slowly with polyethylene sheets in between flask halves - repeat until resin is properly compressed (Indicated by “glossy” material surface) then make final closure.

- Type and class (According to ADA spec.) 12.....Type 1 Class 1
- Storage temperature for powder and liquid60-80° F
- Powder/liquid ratio.....30cc/10mL
- Mixing time (Time to wet all particles).....15-30 seconds (**SLOWLY ADD POWDER TO LIQUID!**)
- Time to reach packing plasticity @ 23+1°C.....Approximately 10 minutes
- Working time.....Approximately 12 minutes
- Temperature of mold when packing.....Room temperature

Recommended cure time and temperature

- 1st stage.....1 1/2 hours @ 165° F
- 2nd stage.....1/2 hour @ 212° F

Alternate cure time and temperature.....Minimum 9 hours @ 165° F

Method of cooling flask, time and temperature

- 1st Stage1/2 hour in air @ 60-80° F
- 2nd Stage.....1/4 hour in water @ 50-60° F

REPAIRS AND RELINES

We recommend that color matched Vitacrilic® self-curing polymer and crosslink colorstable self-curing monomer be used for all repairs and relines.

Caution: Avoid prolonged handling of uncured mixture and inhalation of monomer vapors. Wear protective gloves when packing resin mixture.

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