



Measure by volume 30cc of HI-I® powder to 10mL liquid. Add powder to liquid in a clean dry jar. Mix for 15 – 30 seconds; be sure all powder is wetted. While mix appears to be dry, do not add additional monomer, it will gel nicely. Place cap on jar. When material can be pulled away from the jar, and is no longer sticky, knead material and roll into a half-inch diameter, several inches long and place back in a clean closed jar.

Flasking

Use conventional dental compression molding methods and dental 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 which 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 trial pack sheet (Item no. 4020-00) in between flask halves – repeat until resin is properly compressed (indicated by “glossy” material surface) then make final closure. (Final Closure sheets, item no. 4010-00) Below temperatures are dependent on environmental temperature.

- Type and Class (according to ADA specification) 12.....Type 1 Class 1
- Storage Temperature for powder and liquid.....60°-80° F
- Powder / Liquid ratio.....30cc / 10mL
- Mixing Time (to wet all particles).....15-30 seconds
- 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

- Bench Set.....15-30 minutes after closure
- 1st Stage1 ½ Hours @ 165° F
- 2nd Stage½ Hour @ 212° F
- Alternate cure time & temp.Minimum 9 Hours @ 165° F

Method of cooling flask, time and temperature

- 1st Stage ½ hour in air @ 60°-80° F
- 2nd Stage¼ hour in cold water @ 50°-60° F

Repairs & Relines

We recommend that color matched HI-I® 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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MADE IN THE USA

Effective Date: 07/23/15
Approved By: R. Tekstar