



#### Waxing

The denture should be waxed to simulate the finished appliance as closely as possible.

#### Flasking

A good grade of dental stone should be used. Soften the wax for removal and flush remaining wax residues from flask with boiling water containing a dye free, fragrance free, granular detergent. Then rinse with clean boiling water. Use no wax solvents. Apply Vita-Sep™ to flask halves, following Vita-Sep™ instructions no. IN.723.009.R0.

#### Mixing

Measure by volume, 3 parts of HI-I® LW powder to 1 part of Vitacrilic Crosslink monomer. The average size denture requires 30cc of powder to 10ml of monomer. **ALWAYS ADD POWDER TO MONOMER!** Mix vigorously for 15 to 30 seconds in a clean jar and keep in closed jar until ready to pack. The time necessary before proper packing consistency is approximately 15 minutes at 70° F and 10 minutes at 85° F. When material can be pulled away from the jar and is no longer sticky, knead material and roll into 1/2 inch diameter several inches long. Place back in a clean closed jar. The mixed resin can be used for approximately 1/2 hour.

#### No Trial Pack

Make sure Vita-Sep™ is applied to both halves of flask, and dry before packing. Place the material in the mold carefully, using a polyethylene sheet around the fingers to prevent sticking. The dough is placed in the mold using an excess and the mold is closed without using a separating sheet. Close the mold applying pressure very slowly until the two halves make metal to metal contact, approximately 1 1/2 minutes should be required for full closure. Place the flask in compress. Allow to bench set for 15 minutes before curing.

#### Curing

**Fast cure:** Place compress in warm or room temperature water, bring up to 165° F for 90 minutes, then bring to a rolling boil (212°F / 100°C) for a full 30 minutes. Bench cool for 30 minutes and place in cold water. Deflask and finish in usual manner.

**Slow cure:** Place compress in warm or room temperature water, heat to 165° F for a minimum of 9 hours. Bench cool for 30 minutes and place in cold water. Deflask and finish in usual manner.

#### Repairs and Relines

We recommend that color matched HI-I® self-curing polymer and Vitacrilic 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.

FRICKE DENTAL INTERNATIONAL, INC.  
165 Roma Jean Parkway  
Streamwood, IL 60107  
800-537-4253  
Visit our website at [www.frickedental.com](http://www.frickedental.com)  
MADE IN THE USA