



St. George Technology  
Performance Polymers

Excel Formula®

Dupaloid

Reversible Duplicating Material

## DIRECTIONS FOR USE

1. Cut material into small pieces.

2. Melting:

**A. Automatic colloid processor**

i. Set cook down temperature to 195°F - 200°F (91°C - 93°C).

ii. Set cook holding temperature to 130°F - 140°F (55°C - 60°C).

iii. Follow instructions of the manufacturer for colloid conditioner concerning cook down and storage of hydrocolloid.

**B. Use stainless steel double boiler**

i. Never use aluminum containers to melt the material. Stainless Steel, glass or porcelain-covered containers may be used to melt the colloid. Stir frequently during melting, using a thermometer until the colloid reaches 195°F - 200°F (91°C - 93°C).

ii. If the material is to be used immediately, allow it to cool to 130°F (55°C), stirring occasionally.

iii. If a storage-type duplicator is used, the material may be poured into the duplicator as soon as it is melted. Check the temperature before use, making sure the colloid temperature is 130°F - 140°F (55°C - 60°C).

**C. Microwave**

i. Use approved microwave container, with a cover.

ii. Cook colloid until it reaches 195°F - 200°F, or until all lumps have dissolved, stirring the material occasionally. Do not allow the material to boil while cooking in the microwave.

3. Caution should be exercised to insure that excess water is not lost from the duplicating material. When duplicator lid is removed, allow condensation on underside of the lid to run back into the material. Water left on the duplicating material during washing, after duplications are made, should be sufficient to replace any water lost through evaporation.

4. Clean material thoroughly after use removing any foreign matter such as investment particles. Rinse under cool water. Store in an air-tight container. Be sure container is not aluminum.

THIS MATERIAL IS SUITABLE FOR STONE MODEL DUPLICATIONS.

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