



St. George Technology
Performance Polymers

Excel Formula™ Hi-Impact Pourable Denture Base Material

Complies with A.D.A. Specification No.12:1976 Type 1, Class I
1.5.0.1567:1988 Type I, Class I and ISO 20795-1:2008 Type I, Class I

DIRECTIONS FOR USE

STORAGE CONDITIONS

Close both Powder and Liquid containers tightly after use. Always store in cool, dry, and well-ventilated location away from any source of ignition and/or sunlight. Always store liquid in amber colored glass containers. Maximum storage temperature is 25°C (77°F).

PRODUCT USES

This material is an auto-polymerizing powder and liquid material used for fabricating complete or partial dentures or other removable appliances. Material can also be used for Repairs and Relines.

WAXING & INVESTING

Wax denture to required thickness. Trim a 1/8" shelf around the peripheral roll on cast making easy removal from hydrocolloid mold. Add 2 or 3 round wax sprues (6-8 gauge) dependent upon appliance (see diagram) before pouring hydrocolloid. Soak waxed model in cool water below 100°F to eliminate air. Also ensure all wax is removed from teeth, in particular the occlusal surfaces. Seat model and cast into mold with posterior teeth nearest to the sprue holes of flask. Condition hydrocolloid as instructed and pour carefully between model and flask wall. Avoid pouring directly onto wax surface. After flask is assembled securely, set aside for 5-7 minutes for hydrocolloid to gel before placing in cold water for 30 minutes to allow material to fully set.

WAX REMOVAL & SEPARATOR

Next remove waxed model and cast from mold, place damp towel over hydrocolloid to keep material from drying out. Remove wax from cast with clean boiling water. DO NOT use detergent to clean casts. Detergent residue can impact color uniformity. Clean teeth also with clean boiling water and add mechanical retention to increase bondage to PMMA. After cast is completely cleaned and soaked in warm water for 5 minutes remove and allow to dry for 1-2 minutes.

Next apply a thin coat of the Excel Formula™ Isolating Solution to cast and allow to dry until a slight sheen remains. Next carefully reposition teeth and cast back into hydrocolloid mold and reassemble flask.

MIXING & POURING

To ensure uniformity in the powder, shake the jar in a rocking motion before measuring.

(Note: Static-cling can sometimes clump fibers together so be sure to inspect prior to mixing). For fabricating a full denture measure out 20g of powder and 14mL of liquid. ALWAYS MIX POWDER INTO LIQUID. Stir mixture for 60 seconds at 74°F in a To-and-Fro method to avoid air entrapment. Pour immediately in a slow and steady stream through one of the sprue holes allowing air to be released from mold. Pour immediately until mixture is too thick. Remixing may extend the pour time if necessary. After pouring, stand flask upright at room temperature 73°F. Immerse in water no later than 12min after initial mixing and no earlier than 10min.

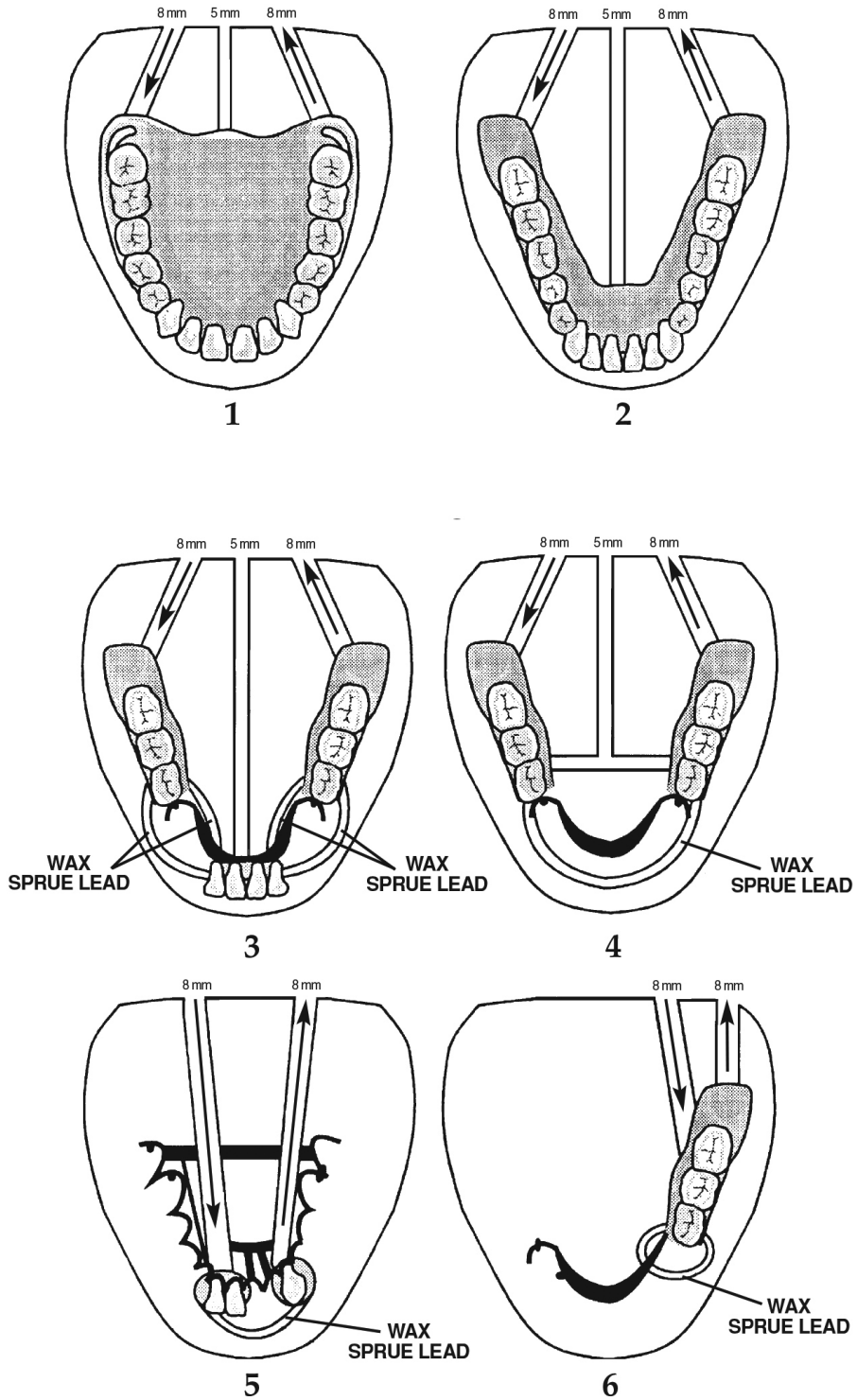


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SPRUE DIAGRAMS

FULL UPPER AND LOWER





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CURING

Preheat a pressure curing vessel to 120°F. Place assembled flask into pressure curing pot with the water level just reaching the Sprues in height. **DO NOT FULLY SUBMERGE FLASK IN WATER.** After placing flask into vessel increase the pressure to 35-40 psi. (Note: If the water temperature does not meet or stay at 120°F the curing time will need to be increased). Let cure for 20 minutes. Allow time to bench cool to room temperature before separating.

FINISHING

The Excel Formula™ Hi-Impact Pourable can be finished and polished using normal techniques as other removable appliances.

REPAIRING & RELINING DENTURES

The Excel Formula™ Hi-Impact Pourable can be used as a repair material if needed. Use the same mixing ratio as listed in the Pour technique but allow the material to set up longer after mixing to the desired viscosity needed for application. For Relines a jig is recommended. Use same curing instructions as Hi-Impact Pourable technique.

WARNING

Powder & Liquid may cause skin irritation. Avoid contact without proper safety precautions in place such as safety gloves & safety goggles. Avoid inhalation or ingestion of the material. High vapor concentration can induce headaches, nausea, and irritation to eyes and respiratory system. Excessive long-term exposure to material may be associated with other more serious health effects.

INHALATION

Move subject to fresh air. Give oxygen or artificial respiration as required.

INGESTION

Contact your regional Poison Control center immediately.

EYE CONTACT

Flush eyes promptly with copious amounts of water for 15 minutes, and consult a physician. Wash skin with soap and water.

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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