



St. George Technology
Performance Polymers

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

CADMIUM FREE

Excel Formula®
Ultra-Hi
Heat Cure
Denture Base Material

DIRECTIONS FOR USE

Our high performance polymers have been formulated to achieve their unique properties and working characteristics through the specific combination of base powder and corresponding monomer liquid. Curing, handling and color cannot be guaranteed if another liquid is used.

Indications For Use

Excel Formula® Ultra-Hi heat cured denture base material is indicated for use in the fabrication, repairing, relining and or rebasing of full or partial removable prosthetic devices.

Waxing & Investing

Follow normal laboratory procedures. A good quality flasking plaster is recommended.

Wax Removal

Immerse flask into boiling water for 3-5 minutes. Remove and bench stand for 2-3 minutes. Open flask, remove softened wax and clean thoroughly with clean boiling water. If using a cleaning agent make sure it is recommended for plaster cleaning and no film/residue is left behind on model or teeth. For separator, use one even coat of the Excel Formula® Isolating Solution to all plaster surfaces. Be sure to remove any excess from around teeth. Allow to dry thoroughly before packing denture base.

Isolating Solution (Tm Foil Substitute)

Coat all plaster surfaces with isolating solution. Be sure to remove any excess from around teeth. Allow to dry thoroughly before packing.

Mixing

Dispense sufficient liquid (approximately 5-10ml) into suitable mixing pot (polyethylene or glass) and gently sprinkle powder into liquid until slight excess is present. Always add powder to liquid. Tap vessel 3-4 times and remove excess powder, then spatulate (mix) for 45-60 seconds. Cover vessel. The recommended powder/liquid ratio is 21g/10ml.

Dough & Working Time

Excel Formula® Heat Cure denture acrylic reaches the snap dough consistency in 5-6 minutes at 23°C ± 2°C (73°F ± 4°F) and remains in a working consistency for 15 -20 minutes. Lower or higher ambient temperatures will affect these times.

Packing

Mold the dough to ensure homogeneity and pack into flask with slight excess. A trial pack procedure is optional, but recommended. Cover with polythene separating sheet, replace flask lid and apply pressure slowly under bench press. Open flask, remove polythene and trim away excess "flash" with a sharp instrument. Replace lid and close completely under bench press. Finally, clamp securely prior to curing.

Curing

Method A

Bring the water to a boil. Turn off heat and place flasks into water ensuring that they are covered with at least 5-7cm (2-3 inches) of water. Do not replace lid of water bath at this time. Leave in the bath for 30 minutes. After 30 minutes turn on the heat and bring the bath back to a boil within 5-10 minutes (not less than 5 minutes). Next, boil the immersed flasks for at least 15 minutes. Remove from the bath and allow to bench cool for a minimum of 15 minutes, before immersing in cold water to cool completely before deflasking.

Method B

Place flasks in warm water ensuring that they are covered with at least 5-7cm (2-3 inches) of water. Heat at 85°C (185°F) for 8 hours. After 8 hours ensure flasks are covered with at least 5 mm (2 inches) of water and boil for a further 15 minutes. Remove from the bath and allow to bench cool for a minimum of 15 minutes, before immersing in cold water to cool completely before deflasking.

Finish and Polish in the usual manner.

Additions & Repairs

For maximum strength, any fractures or additions are best made using the heat cure technique. Auto-polymerizing repair resins such as the St. George Technology Excel Formula® Auto-Cure denture repair material may also be used.

Storage

Dental acrylics based on methyl methacrylate should be stored in a cool (16-26°C, 61-79°F), dry place. Avoid prolonged exposure to sunlight. Keep containers closed when not in use.

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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