Issued: 30.06.05 Approved By: Technical Manager Rev: 5 Ref: 1-5

WHW Plastics

FAST CURE DENTURE BASE

PROCESS INSTRUCTIONS

TYPE 1 CLASS 1

A fast curing denture base polymer and monomer producing a workable dough 25 minutes after mixing at 23°C and capable of being cured within the maximum residual methyl methacrylate level of 2.2%, all applications are based on WHW powder / monomer and also process instructions for a Interlab Pro-Cure process unit. Other process methods should be suitable but refer to manufacture instructions.

SUGGESTED METHOD OF APPLICATION

Preparation of Mould

Prepare the plaster mould in the usual way ensuring all traces of wax are removed using boiling water. The necks of the teeth should be lightly ground to improve adhesion to the denture base.
Apply separating medium to all plaster surfaces.

Preparation of Dough

Shake the container well. Measure 10mls of liquid into a suitable vessel and add 24 grams of polymer. Spatulate the mix for one minute, cover the vessel until dough time is reached, at this time the dough will leave the walls of the vessel cleanly and not adhere to the fingers.
The dough will remain workable for approximately 15 minutes at 23°C.

Packing and Closing the Mould

The dough is packed into a warm flask at approximately 35°C the material is then covered with a polythene sheet.
The mould is then closed and re-opened, surplus dough being removed.
The flask is re-closed without the polythene sheet and placed in the clamp.

Standard Cure

The flask is placed in boiling water, the water is the brought back to the boiling point and continued for a minimum 60 minutes.

INTERLAB Pro-Cure Unit

Switch on the high temp timer for a period long enough to reach 99°C
When at 99°C place flasks into the water
Set the high temp timer for 90 minutes
After time cycle has finished the flasks can be removed and allowed to bench cool for a minimum of 30 minutes

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Reverse Cure

For thick specimens this method is more suitable. Place the flask in boiling water; turn off the heat for 20 minutes. Re-heat the water to boiling point and continue for a minimum 60 minutes.

INTERLAB Pro-cure Cure Unit

Switch on the low temp timer for a period long enough to reach 80°C
When at 80°C place flasks into the water
Set the low temp timer to 30 minutes and the high temp timer to 150 minutes
After time cycle has finished the flasks can be removed and allowed to bench cool for a minimum of 30 minutes

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Repairing Denture Base Polymer

This can be carried out using the same material and process, or by using WHW Rapid Repair Cold Curing Material.

Health & Safety

For general health & safety see overleaf, more detailed information consult relevant Manufactured Health & Safety Data Sheets

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SAFETY PRECAUTIONS

DENTAL METHACRYLATE MONOMERS

STORAGE
Store in a cool place away from direct sunlight, naked flames and sparks.
Providing the material is stored correctly the self-life is two years.

HANDLING
WHW polymer solutions containing flammable solvents and should be handled in a well-ventilated non-smoking area, away from heat and naked flames.

Contact with skin and eyes should be avoided and suitable protective clothing should be worn, i.e. overalls, gloves and goggles. In the event of contact wash immediately with copious amounts of water.

A spillage of solution should be cleaned up with sand and earth.

In the event of fire use sand, earth or suitable extinguisher.

The flash point of Methacrylate Monomer is 10’C

DENTAL BEAD POLYMERS

STORAGE
Store in a cool dry place. Providing the material is stored correctly the shelf life is 3 years.

HANDLING
Although these products present no toxic hazard care must be taken when handling to avoid the possibility of dust explosion occurring. Suitable protective clothing should be worn, i.e. Overalls, and dust mask if dust is created.

Electrical fittings in the immediate area should be dust proof.

Where exhaust systems are used they should be equipped with explosion relief panels and runs of ducting should be as short and direct as possible.