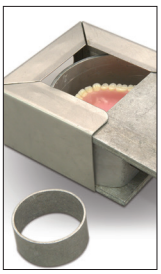
Lucitone® HIPA

High Impact Pour Acrylic Denture Base

Quick Start Guide

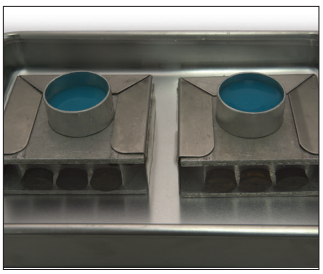
Soak the waxed stone cast in water for 10-20 minutes prior to pouring the mold material (hydrocolloid or silicone).

Use clay to hold wax-up in place.



Reassemble flask.

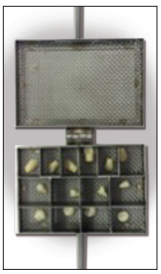
Use an all-purpose duplicating material such as Polyflex®. Melt and pour duplicating material at manufacturer's recommended temperatures. Clean and store duplicating material properly after use.



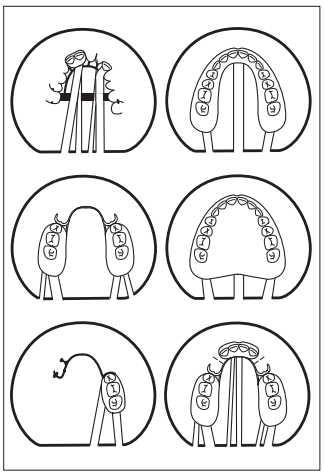
Chill in a cold water bath 10°C (50°F ± 10°F) for 40 minutes.

Boil-off wax with clean boiling water. Do not use detergent to clean casts. Detergent residue may impact color uniformity and could cause bleaching on tissue side of the denture.

Clean teeth with clean boiling water. Care must be taken to assure that all wax is removed from the teeth.



Immediately after boil out, place the cast in a bowl of water for 10 minutes to eliminate air; extend soaking time if needed until bubble free.



Spruing Techniques.

THE DENTAL SOLUTIONS COMPANY™

Dentsply Sirona

Bore sprue holes in the hydrocolloid or silicone mold as shown. Sprue diameter should be large to reduce tendency for air to be entrapped, for example 7-8 mm diameter where possible.

Add mechanical retention to the teeth. Remove only enough tooth material to enhance retention. Excessive removal of tooth material will weaken the tooth and may lead to fracture. Use a #4 round bur to cut diatorics.

Use a small amount of Aron Alpha Adhesive or cyanoacrylate on cusp tips to keep teeth from moving.

Remove the cast from the water and allow to dry for 1-2 minutes.

Use a brush to apply a thin coat of AL-COTE® Separating Agent to the cast. Do not allow the separator to puddle. Apply a second layer as needed. Make sure the separator is completely dry before placing it back in the mold.

Note: Blanching may occur if separator is not completely dry.

Assemble flask.

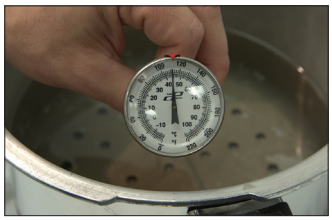
For the fabrication of one full denture, use one (1) Large Scoop (or 20g) of HIPA Pour Acrylic Powder and 15 ml of HIPA Pour Acrylic Liquid measured with the HIPA liquid vial. For the fabrication of a partial denture, use one (1) Small Scoop (or 11g) of HIPA Denture Base Powder and 8 ml of HIPA Denture Base Liquid measured with the HIPA liquid vial.

Add powder to liquid and mix thoroughly for a minimum of 15 seconds to completely wet out the powder. Avoid air bubble entrapment.

Note: Failure to mix well will cause white areas or spots in the denture. After measuring the liquid, invert the vial on a paper towel to allow residual liquid to empty from the vial.

Pour acrylic into mold. Pour time is about 3 minutes at 23°C (73°F).

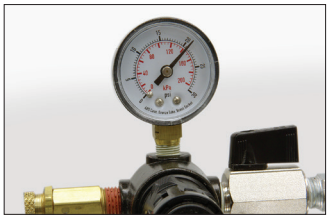
Note: For a full denture, only pour into one sprue hole. For partials, pour into sprue holes as needed.



Check the water temperature in the pressure pot with an accurate thermometer and adjust to 113°F ± 2°F (45°C ± 1°C).

Place the flask in the water with sprue holes upright at 113°F ± 2°F (45°C ± 1°C). The water level should be below sprue height but above 2/3 the height of the flask. Do not fully submerge the flask in the water. Immediately, close the pressure pot and apply 20 psi (1.4 bars) or greater pressure.

Note: Delay in applying pressure may introduce porosity. Cure for 30 minutes.



Cool flask and remove denture from the mold.

Finish and polish as normal.

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