



Flexi - J

type "1" and "2"

Instructions for use

- MANUFACTURER:** Pressing Dental S.r.l.
Via Edoardo Collamarini 5/d - 47891 Dogana (Repubblica di San Marino)
- CONTENT:** Polyamide resin for pressure - injection indicated for the production of dental prostheses
- BATCH:** Check on the package
- STORING:** To be used by the expiry date indicated on the container.
Store the product in its package, do not keep the product exposed to direct sunlight,
keep the package away from heat sources, in a dry place. **STORE IN A DRY PLACE**

USE PROVIDED FOR:

Material to be used in the pressure - injection of particulars for dentistry.
For ex: partial prostheses, post - surgical space retainers.

SPECIFIC INSTRUCTIONS FOR USE:

The product Flexi-J can be used with the specific equipment manufactured by the company Pressing Dental s.r.l.

- Processing specifications with Pressing equipment:
Processing specifications provide for the following variable data:

	Type 1 ref. code A, B, C,D,E-00800	Type 2 ref. code : from F-00800
Melting point	260 °C	265 °C
Melting time	12 min	12 min
Heating time after injection:	02 min	02 min
Cooling time:	05 min	05 min
Injection pressure:	5,5 bar	5,5 bar

These parameters vary according to the dimensions of the prosthetic item to be manufactured, for further information, ask for the specific technical tables.

- Use of the material on equipment not manufactured by the company Pressing:

The melting point must be:

Type "1" ref. code A, B, C,D,E-00800: 260°C ± 2 °C and the melting time must be exceed 12 minutes,

Type "2" ref. code : from F-00800: 265°C ± 2 °C and the melting time must be exceed 2 minutes,

for other parameters abide by the instructions provided by the manufacturer of the equipment; in particular for pressure - injection equipment with compression of the cartridge the indicative injection pressure can be of 6/8 atm.

The user of the material (a dental mechanic), in order to know its correct use, must attend a course (theory and practice) at the manufacturer's premises, or at authorized sellers.

During such a training course the user gets to know all the current processing techniques for the correct use, as well as on the advantages and the limits of the product; in addition he is trained on the specific use of the machines necessary for its production.

During the course the user is given all the necessary information in order to use the product in combination with other devices.

In case it is needed to combine the product Flexi-J with metal parts and/or acrylic resins (artificial teeth), since there is no adherence between the materials, it is necessary to create mechanic retentions.

Note:

If the amount of product to pressure-inject is lower than the 9 high disks (0,5 cm each), in order to ensure the correct melting of material it is necessary to insert 1 teflon caps and 1 **metal caps code "A-21"** after the material.

Such procedure allows for a more even melting of the product, in that it is closer to the oven's thermal centre.

Leave always 2 cm. Between the caps and the retention for close the tube for guarantee the space for the gas that during the melding will be generate inside the tube.

RECOMMENDED COLOUR SCALE: Flexi-J colour scale

FINISHING AND POLISHNG:

- Use non-aggressive polishing pastes (for ex: Universal Polish).

- Use only low - revolution cotton brushes to prevent the material from overheating (for ex ample a handle brush with a 20 mm diameter on a 20.000/40.000 - revolution handle, polish at 5/10 second intervals exerting a slight pressure; follow the same procedure with 80 mm - diameter brushes with 2800 revolution / min equipment).

See the instructions for use of equipment J-100 J-200 and Actio.

The product must only be cleaned with water and with the use of non-abrasive materials, do not use ultrasound equipment with acids that can modify their requisites.

The material may undergo colour changes in the following cases:

- As the material is based on Nylon and is sensitive to humidity, over time it tends to absorb part of the fluids in which it is soaked.

- If the material remains in the melter longer than the time indicated;

- If a good polishing is not carried out;

- If it is pigmented superficially with photosensitive lakes, which favour the adherence of bacterial plaque and can get wasted with time, leaving under them a non-smooth surface.

CAUTIONS:

The product does not resist to chemical agents with oxidant effect, nor to strong acids (pH<4).

During the finish use an aspirator and/or a mask to avoid breathing the powder.

During the finish and polishing stages, take care not to overheat the product, being this a thermoplastic material, an undesired change of the prosthetic item and a liberation of irritant gases.

In case of manufacturing of small dental appliances take care not to leave sharp parts (in the case of hooks), and that the dimensions of the finished appliance are not such as to favour its swallowing, if it is a mobile appliance.

Attention: the material is not visible with x-rays. Do not reuse the product.

Do not exceed the maximum temperature of: type "1" 260 °C. – type "2" 285 °C.. If there is a strong smell during the molding, check the set melting point and ask for assistance, if it is necessary.

Do not exceed the melting time (type "1" 14 minutes max; type "2" 14 min. minutes max.), because there could be mechanical changes of the material, with consequences on the final prosthetic item.

In case of manufacturing limiting parts (hooks, connections, etc.) avoid reactivating the material already formed by using heat sources.

Do not contaminate the product during the pressure – injection stage. Do not mix the product with other materials.

In case of allergic reactions to the material, immediately discontinue the application and contact a doctor.

RISK PHRASES INDICATED ON THE PACKAGE:

- R40/20 - Harmful: possibility of irreversible effects by inhalation (in case of decomposition of the product for the gases that stem from it);
 R42/43 - It may provoke sensitization by inhalation and contact with the skin (with reference to the powder during the finishing of items);
 R34 - It provokes burns (with reference to the material in the melted state);
 R36/37 - Irritant for the eyes and the airways (with reference to the powder during the finishing stage of the items and to the gases in the melted state).

INFORMATION FOR THE FINAL USER:

When delivering the finished device, the dental mechanic must give the user at least the following information:

- Do not clean the prosthesis with abrasive products, or with products meant for the cleaning of acrylic resin prostheses, or metal prostheses; only use products for the oral hygiene.
- Wash the prostheses with cold water only, at a temperature lower than 42°C.
- Normal oral hygiene.
- Non radio - opaque device.
- Waste of the material is due to bruxism and to the contact with abnormal antagonists.
- Flammable device (synthetic resin).
- The product may undergo a colour change due to absorption

In case of allergic reactions to the material, immediately discontinue the application and contact a doctor.

Technical working table Cod. T.T. Flexi.J 01/0

Laboratory stages:



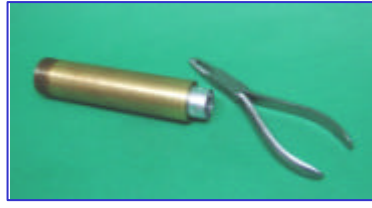
Before moulding, it is preferable to isolate the mould using the photopolymerizing varnish Giplux
 Wax moulding, minimum thickness recommended: 1 mm



Attention:

Create a mechanical retention to teeth, we recommend a hole.

Injection canals: N° 2 5 mm coupled canals



- a) Insert the product Flexi J in the aluminium tube by inserting the metal cap after the Teflon cap.
- b) Lubricate the tube using the specific product "Tube Lubricant red".
- c) Seal with the pliers, pay attention to leave at least two centimetres between the metal cap and the seal.
- d) Insert the cartridge up to rim of the metal tube. Clean the upper part of the tube so that no residues of tube lubricant remain.
- e) After lubricating the thread, assemble the centering device and ensure that it is well tightened (it is not necessary to tighten it too much)

Setting the equipment

Type "1"

Melting temperature : 260°C

Cooling time under pressure 5 min.

Melting time 12 min.

Injection pressure: 5,5 Bar

Oven switched on after injection: 2 min.

Injection speed screw completely open

NOTE: These times are calculated with the cartridge inserted when the oven has already reached the temperature of 260°C

Type "2"

Melting temperature : 265°C

Cooling time under pressure 5 min.

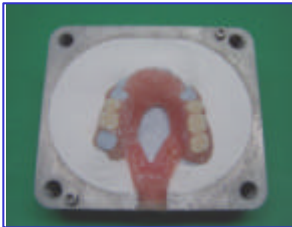
Melting time 12 min.

Injection pressure: 5,5 Bar

Oven switched on after injection: 2 min.

Injection speed screw completely open

NOTE: These times are calculated with the cartridge inserted when the oven has already reached the temperature of 265°C



View of the manufactured item after injection



NOTE

The J-100 equipment is calibrated so that when approaching the 300°C. the "manual restarting switch code 0107i" – a security system – starts working.

To use the J-100 equipment at a constant temperature of 260 °C. it is necessary to replace such component with model "Rj100-0107I -H", which is activated at 350 °C ca.

The company Pressing is not to be held responsible in case the component 0107i is excluded, as in case of a malfunctioning of the heating system, the security predisposed would not be guaranteed.