

DIRECTIONS FOR USE:

1. Flasking

Wax up, flask, and boil out in the usual manner. Make sure all surfaces are wax free before proceeding. When the cast has cooled slightly apply National Keystone KeFoil Tinfoil Substitute to all mold surfaces. Avoid coating teeth with this material since this can result in poor adhesion between teeth and denture acrylic.

2. Mixing

Powder/Liquid Ratio by weight: 9 ml monomer to 21g powder.
Powder/Liquid Ratio by volume: 9 ml monomer to 30 cc powder.
For optimal results, follow the above ratios. Measure liquid and pour into a glass mixing jar with lid. Shake the powder to evenly distribute the fibers. Stir enough powder into the liquid until the liquid is completely taken up. Tap the jar on the bench top to bring the remaining monomer to the surface and add the remaining powder. Stir with a stainless steel spatula until all the powder is moistened. Avoid entrapping air into the mixture when mixing as porosity may result. Cover and let the acrylic rest until it is no longer tacky, it pulls away from the sides of the jar and does not stick to the stainless steel spatula. Estimated resting time for Sledgehammer® Heat Cure Acrylic is 10-12 minutes depending on ambient air temperature.

3. Packing

The acrylic should be doughy but not tacky. Do not let it reach the “snap stage.” Acrylic that is packed too dry may result in brittleness and shade discoloration. The flask should be at room temperature. Remove the acrylic from the mixing jar in order to avoid trapping air bubbles. Trial pack denture 2-3 times to insure minimized porosity and maximum acrylic density. Use sufficient pressure with each trial pack and remove excess acrylic using polyethylene sheets as a separator between each trial pack. Remove the flash and close final pack without the polyethylene sheet. Process immediately.

4. Processing

Immerse the flask in boiling water and boil for 20 minutes. Remove from water and let cool to room temperature before deflasking or bench cool for 20 minutes then submerge in cool water for 20 minutes. Warpage may result if the case is deflasked prematurely.

Thicker cases should bench set for 15 minutes before being introduced into the boiling water. An alternative method would be to put the case into room temperature water and bring water to boil and let case cure for 20 minutes in the boiling water.

5. Deflasking

When the flask is cool enough to handle, deflask in the usual manner. In the case of undercuts, do not pry the denture with a knife or distortion of the denture could result. Section the cast instead to insure a superior fit.

6. Finishing

Trim excess material and finish using pumice, rag wheel and polish as per your standard techniques.

SLEDGEHAMMER®

20 MINUTE CURE ACRYLIC MONOMER

20 Minute Liquid / Powders For Pack Acrylic Techniques

SLEDGEHAMMER® 20 Minute Cure
Acrylic Monomer is a high-impact, dimensionally
accurate, color stable pack acrylic polymer system
useful for preparing both full and partial dentures.
Used in conjunction with our Heat Cure Acrylic
Powders it can be processed in less than 1 hour using
our Sledgehammer Acrylic Powders.

Caution: Irritation and sensitization have been reported in conjunction with products that contain methacrylates. To reduce the risk of such occurrences, do not use this product with patients who have demonstrated sensitivity. Avoid repeated and prolonged contact with uncured material, and discontinue use if sensitization occurs.

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