

IMPORTANT SAFETY INFORMATION

Inhalation: Avoid breathing vapors from heated material. In case of inhalation, immediately move to fresh air. Evaluate need for artificial respiration and seek immediate medical attention.

Eyes: If contact occurs, Rinse opened eye for several minutes under running water. If symptoms persist, consult doctor.

Skin: The product is not skin irritating.

If contact with the molten product, cool rapidly with cold water.

Do not pull solidified product away from the skin. Cover affected area with clean cotton sheeting or gauze and obtain prompt medical attention.

MSDS at: www.perflexltd.com

Dear Customer,

Thank you for choosing our top innovative line of thermoplastic materials for aesthetic dentures.

Our product line will provide you with countless options, to create aesthetic designs and comfort for your patients.

For any question, please feel free to contact us. We are dedicated to providing you with excellent products, service and support.

Manufactured by Perflex Ltd.

ISO:13485:2003, ISO: 9001:2008

CE CA010953

Registered by: Acc. 93/42 EEC – MHRA IN UK

For reorder refer to Perflex Catalog.

CONTACT

PERFLEX LTD.

10 Smilansky St., Netanya 42432, Israel

Tel: + 972-9-8825473 Fax: + 972-9-8614474

e-mail: info@perflexltd.com

website: www.perflexltd.com



The Natural Choice

Perflex Acry Free®

Acrylic Denture Base Thermoplastic
For Injection Molding Systems.

Chemical Composition:

PMMA compound

Class I according to EEC/93/42

Product form: Pellets

For professional use only.

Features:

- ◆ Monomer free acrylic
- ◆ Biocompatible - Non-allergic
- ◆ Aesthetic
- ◆ Translucent
- ◆ Comfortable
- ◆ No shrinkage
- ◆ High impact resistance
- ◆ Excellent Dimensional Stability
- ◆ Light weight
- ◆ High color stability
- ◆ Repairs: hot/cold cure conventional acrylics

Applications

For the production of Full dentures, Partial dentures, Metal frames combinations with **Acry Free®** non-allergenic acrylic for people that are sensitive to normal acrylics.

Acry Free can be repaired and relined by the same material Acry Free by injection molding or with conventional acrylics hard or soft cold or heat cure conventional acrylics.

COLORS:

Light Pink, Standard Pink, Purple pink

RECOMMENDED PARAMETERS FOR INJECTION

MOLDING ON SMART 101 AUTO-INJECTOR MACHINE:

Temperature	270°C
Time	20 Min
Pressure	9.5 Bar
Cooling under pressure	5 Min *with furnace switched off

Parameters for other types of injectors:

www.perflexltd.com, under: "Technical Manuals".

INSTRUCTIONS

1. At the wax-up stage, provision must be made for a Flattened 5mm red-double-sprue at both sides of the denture.
2. After investment and boil-out, proceed with suitable preparation holes for retention on the artificial acrylic teeth.
3. Glue the artificial acrylic teeth into the gypsum cavities.
4. Turn on the injector furnace and set program: temperature to 270°C for 20min.
5. Lubricate the cartridge tube with LUBRIGEL or LUBRISIL LIQUID high heat resistant tube lubricant, taking care not to touch the top or bottom of the cartridge with lubricant.
6. When the Furnace reaches 270°C, Now insert the lubricated cartridge tube with its cap facing outwards into the furnace, start the timer 20min.
7. Pre-heat the 2 halves of flask in a bath of boiling water (100°C).
8. 8 minutes before injection, wear protective heat resistant gloves, take out the flask from boiling water, dry out the remaining water, and Place isolating separator liquid ISOSEP FILM 2 coats, on to Plaster surfaces corresponding to the Denture area only.
9. Close the flask with 4 screws and place into the Injector machine, 1 min before injection or when alarm sounds.
10. At 20 min. mark inject the material.
11. Keep the flask inside the injector under pressure, cooling (furnace switched off) for 5 min.
12. Release the flask from the injector, and bench-cool to lukewarm close to room temperature.

13. Deflask and proceed with processing and polishing as for conventional acrylics, no special burs or instruments needed. For best results use POLIFAST PUMICE, BLUE BAR pre-polish and WHITE BAR for a High-shine luster finishing polish.

IMPORTANT

For detailed information on the Construction of thermoplastic prosthetics, please consult the manual or your local dealer.

For correct use of the material, along with the entire line of PERFLEX thermoplastic compounds we strongly recommend PERFLEX'S training courses, at PERFLEX LABORATORY and at authorized dealers.

WARNINGS

Inject the material when flasks are still hot.

If necessary the 6 anterior teeth may need a cold cure acrylic mask if too dark.

Remove the sealing plastic cap from cartridge, prior to pre-heating or melting stage.

Melt Perflex – ACRY-FREE according to manufacturer's instructions for your type of furnace.

Proceed as with other thermoplastic nylons systems for the standard methods, practices and polishing techniques.

Pay attention on the pre-heating process and heating parameters that are not the same as for conventional nylons.

Do not use higher temperatures than the recommended ones as there is a risk that the material could suffer heat decomposition which can cause dangerous fumes.

Always and only use virgin material.

Do not mix with leftover pieces from previous melted material, which could pollute the material, compromising its physical and mechanical characteristics.

STORAGE

Store in cool, dry place in tightly closed containers, at room temperature. Make sure that the box or the jar is well sealed after removing each cartridge or material.

If the material is moist, the cartridge can be opened during heating time inside the furnace, in this case we recommend to dry the material or the full cartridge 40°C – 60°C - 160°F for 6 hours prior to use.

Do not expose to sunlight.

Keep away from sources of heat and combustible materials.

Keep out of the reach of children!

CLEANING

Prosthetics manufactured of **Perflex Acry Free®** may be cleaned and disinfected Using **Flexi Clean® Concentrated Denture Cleaner Powder** a product of **Perflex Ltd.**