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Flexite plastics are [FDA Type II class registered](#) ISO 9001:2000 certified, CE compliant

FLEXITE PLUS

FLEXITE PLUS Chemical family (Polyamide Nylon)
Comparable with Vasplast but more Flexible and color stable than
Valplast

Characteristics

1. Unbreakable
2. Bio Bompatible
3. Can be added and repaired in non flexible areas with Rapid set and using Aron Alfa as a adhesive
4. Can be relined and added mayor areas by re injecting and using Repair liquid as an adhesive
5. Can be relined with a soft reliner silicone based using Flexil
6. Requires less precision in the design and blockout of undercut areas

due its flexibility.

7. Designs are mostly tissue supported
8. Can add esthetic clasps using Clasp Eze and Aaron alfa as an adhesive
9. Variety of shades and three ethnic colors
(Lt. Pink, Dk. Pink, Translucent Pink, Con pink, Clear translucent
Ethnic Brown, Purple Maharry, and Coe Ethnic Moderate)



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FLEXITE SUPREME

FLEXITE SUPREME Chemical family: Co-Polyamides (Casted Nylon)
Comparable with TCS (just for the polishing conditions. Flexite Supreme is way superior in color stability, shrinkage , tensile strength and dimension stability (more memory))
Comparable in its properties to FRS (Dentsply)

Characteristics:

1. True cast thermoplastic with excellent dimensional fits, comparable to alloy castings.
2. Clasps and roach type clasps feasible
3. Gum retainers can be done due its flexibility
4. Designs can be Tooth and Tissue supported (Dento-muco supported)
5. Requires a careful design in blocking out undercuts areas , clasp positions, retainers and supports, like in the alloy frames in Chrome cobalt for example.
6. Can be relined and added mayor areas by re injecting and using Repair liquid as an adhesive
7. Can be added and repaired in non flexible areas with Rapid set and using Aron Alfa as Adhesive
8. Acrilyc will stick and chemically glue on it with the use of Aaron alfa.
9. Can be relined with a soft reliner silicone based using Flexil
10. Polishes to a high gloss
11. Bio-compatible,
12. Clinically unbreakable.
13. Can be re adapted to the stone model with the Heat gun with great stability



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14. Can add esthetic clasps using Clasp Eze and Aaron alfa as an adhesive
15. Almost No Shrinkage comparing with Plus
16. Shades: Lt. Pink, Dk Pink, Natural tooth color, Natural Clear Ethnic Brown, and Ethnic Coe22
Tooth Color Shades: 61, 62, 65, 66, 67, 69, 77, 81 and cross link to Vita shades too (A1 A2 etc)

FLEXITE MP

FLEXITE MP

Chemical family: Methyl Methacrylate Blend (Multi-Polymer Acrylic)

Compared with regular High Impact heat cure acrylic like Lucitone but Monomer free, faster and easier to manipulate

Recommended

Fulls, TMJ's Bruxism, Provisionals for Impants in progress, Anti-Snoring Devices, and Silicone-Acrylic Combinations.

Characteristics:

1. Hi-impact Acrylic. Above average impact and dimensional fit.
2. Perfect Crystal clear comes easy
3. Can be relined or added to with standard repair acrylic
4. Can be relined with a soft reliner silicone based using Flexil
5. Monomer Free
6. Can be added and repaired with regular monomer acrylic
7. Standard colors: Pink, Lucitone Pink, Ethnic Coe Brown and Clear.



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FLEXITE ACETAL

FLEXITE ACETAL

Chemical Family: Acetal Resins
Compared with Duracetal

Recommended

1. Acetal Frames (like alloy frames)
2. Clip on Veneers
3. Tooth color clasps
4. Provisional Splints

Characteristics:

1. Inherent strength , will never break
2. More flexible than alloy frames
3. Can be re adjusted / adapted to the stone model with the heat gun (this
4. could never be done in an alloy frame)
5. Can be thinned down without loss of memory or shade.
Allowing
6. delicate clasps designs
7. Clasps and roach type clasps feasible
8. Requires a careful design in blocking out undercuts areas , clasp
9. positions, retainers and supports, like in the alloy frames in
10. Chrome cobalt .
11. Nothing will stick to it (like in alloy frames either)
12. Acrylic will stick on it based on mechanical retentions (like in alloy
13. frames)
14. Can not be easily repaired (like alloy frames either)
15. Tooth Color Shades: 61, 62, 65, 66, 67, 69, 77, 81 and cross link to Vita shades too (A1 A2 etc)
16. No Pinks or Clear shades available



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FLEXITE GUARD

FLEXITE GUARD Chemical Family: Styrene-Ethylene Block Co-polymer
Elastomer (Thermoplastic Rubber)

Recommended

Mouthguards in sports

Characteristics

Elasticity

Flexibility

Easy Processing

Nothing will stick to it (thermoplastic rubber)

No usable as a reliner since will not stick to the denture

Keeps shape and form

Shades: Blue, Pink, and Natural





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GENERAL INSTRUCTIONS

MODEL DUPLICATION

1. MATERIALS:

A. Duplicating Flasks

B. Any top grade duplicating materials specifically for stone models. If you get a film of stone that remains on duplicating gel, you may be using the duplicating gel meant for the chrome department. Discard and do not use!!

C. Duplicating apparatus can range from the most sophisticated (ex: C.M.P. duplicator) to a Microwave oven. For labs starting out, we have **Flexite Ez-Dup** available in convenient packages. All that is required is a 1000-1200 watt microwave oven and a 64 oz. plastic pyrex container.

2. TECHNIQUE:

A. Soak the model in water for a minimum of 30 minutes. But do not cover teeth. Prolonged soaking of models completely submerged in water will result in smaller teeth as minute stone particles will dissolve into the water.

B. A quick alternate method: Put model in pressure pot filled with slightly warm water. Cover completely.



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Build pressure up to 15-20 lbs. and allow to stand for only 7 minutes.

C. Blow excess moisture off model, set on base.

D. Dip bottom of flask into duplicating gel and place on base. This will seal flask to base or flat pan.

E. Pour duplicating gel and allow to harden for 15 minutes.

F. Refrigerate or allow cold water to run through flasks for 30 minutes. Entire time is 45 minutes.

G. Separate and pour. Try to use different color stone, if feasible, to differentiate between master and duplicated casts.

H. Separate after surface has hardened. Copy design in pencil and remove all artifacts. I suggest you survey with red pencil and clasp design in black pencil.

TOOTH PREPARATION

A. Retain as much bulk as possible when setting teeth to allow room for burring Diatorics into plastic teeth. Never use short bite teeth.

B. Diagram shows a X ray view example of molar tooth. Dark area indicates retention prepared with burr, similar to porcelain diatorics.



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C. Anterior teeth diatorics are cut toward lingual so that holes are not visible anteriorly.



D. Wire loops may be added for close bites and add retention .

*Vacuum fired porcelain teeth may be used but never next to a clasp.



Note: Use #8 round burr for a center hole. Open generously when feasible. Open other holes with #4 round burr from mesial to distal. Connecting with center hole if possible

DO NOT SET TEETH ON HEAVY BASEPLATES. USE THIN WAFER OR SETUP WAX WITH RE-ENFORCING WIRE SO THICKNESS OF TOOTH IS PRESERVED FOR RETENTION.



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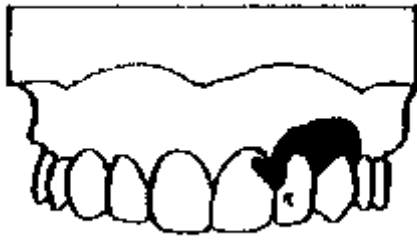
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PREPARING FOR CLASPS AND MATRICES

After design is marked off in red pencil, mark approximate position of clasps. Using a heatless stone, cut in at least 1-1/2 mm of space for Flexite broadening towards the lingual.



Note cut-outs on lower quadrant showing approximately how much space should be provided.



To transfer teeth to duplicate model, use full occlusal arch matrices.

*For free-end saddles where no natural molar teeth are present, be sure to have the plaster matrix rest on saddle.



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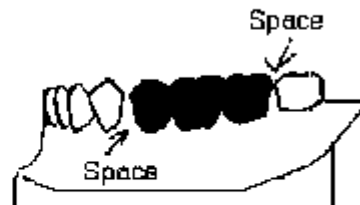
Alternate Technique:

Survey, design and blockout undercuts. Duplicate model and articulate with counter model. Put in retention holes and setup teeth on duplicated model. You will have one counter model and two working models. No transferring of the teeth will be necessary. Complete on duplicate model.

5. SPACING FOR CLASPS



Note the occlusal space.



Note spaces in buccal area.



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Note the occlusal space Note spaces in buccal area.



DESIGN FOR ACETAL FRAMES

Due to the Acetalic resin properties . We follow same principles as any alloy frame desing for chrome cobalt.





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DESIGN FOR SUPREME FRAMES

These type of designs can be done also in Supreme (little bit weaker) but more flexible , it can be bonded to acrylic, and could be done also in Clear and Pinks color, in which case we would be shooting the complete partial in one shot .
(comparing with the Acetal option)



In the case of Using Supreme, it should be a little bit more tissue supported like it is showed on the previous picture.

Here some samples of Supreme designs.



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DESIGN FOR FLEXITE PLUS DEVICES



Note there are mostly supported by the soft tissues

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WAXING TECHNIQUES

1. MATERIALS:

- A. Baseplate wax. (Use thin gauge for partials and heavier gauge for Fulls)
- B. 1/4 inch Boxing wax for sprues only in metal and Flexite combinations.
See Page 10
- C. Usual waxing instruments
- D. Abbots brushes
- E. Odorless Mineral Spirits. (wax solvent) Can be purchased at Home Depot.

2. TECHNIQUES:

Assuming design has been copied on to duplicate model, proceed as follows:

- A. With small spatula fill in clasp areas with a light flush. For full uppers, flush palate lightly with wax from wax pot. Soften spruce wax and mold into center of palate with fingers to provide a rib for added support and flow.
- B. Soften baseplate wax and apply to palate. Try not to nick or dent palatal area.
- C. When **waxing upper partials extend posteriorly as if for a full palate.**
- D. Apply wax to buccal areas by heating baseplate wax and pressing on. One sheet



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thickness usually will suffice. Double when necessary.

E. Trim gingival around teeth but leave interdental papillae convex rather than concave.

F. Use abbots brush with wax solvent to clean excess.

G. Apply odorless mineral spirits to wax surface, then burnish wax with soft paper towel.

(Bounty or Viva brands are durable and work best)

h. High shine with cotton dipped into soapy water, or use Flexite Debubblizer.



IMPORTANT TIPS:

A. Follow taper principle for clasps. Observe buccally as well as occlusally to insure proper taper.

B. Buccal and lingual clasps may be connected when the bite is very close and the tooth has been ground excessively.

C. This is particularly so when processing a Flexite saddle against a metal frame.



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If there is not at least 2 mm of space between tooth and metal retention, carry an extra sprue toward buccal saddle.

SPRUNG

Standard Procedure For All Flexite Cases.

UPPERS:



Use a flat sheet of base plate wax. Wax all uppers as if they were full dentures. Extend to end of model and tape to the entry hole in Flask. Plastic will be cut back later to bead line.

LOWERS:



Take sheet of base plate wax, and trim to fit into entire lingual. Be sure to trim stone in center platform section so baseplate wax is flat and can be sealed down low at periphery.



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Heat and roll ½ inch strip of baseplate wax into entry hole. (Entry hole remains plugged in wax)

Compress upper flask into position. Trim excess wax till flasks close properly, remove and pinch and taper wax into center.



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BRUXISM and TMJ's:

Bruxism and TMJ's are sprued differently because of the heavier than usual occlusal. To avoid bubbles, connect a heavy 1/4" inch sprue from the entry hole to the distal of both saddles.





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INVESTING

***IMPORTANT:**

Vaseline is used only one time to lubricate inside of flasks so stone can be extracted easily.

Make sure that no excess Vaseline remains on platform or entry hole.

"Paint & Pour" spray is recommended as the separating medium between stone in the flasks.

DO NOT USE VASELINE! With Vaseline the risk of contaminating the teeth is too great.

Spray with "Paint & Pour" plaster separator. With "Paint & Pour" this is eliminated. No teeth will shift out of position. Vaseline affects the plastic.

1. Soak cases in water to eliminate dryness.
2. Trim points of stone teeth and any protruding stone areas that are undercut.
3. Mix stone to a smooth creamy texture and invest in lower half of flask.

Note: The lower half contains the larger platform. Upper half does not contain threads for the Allen screws, therefore always screw top to bottom.

4. Draw all teeth over, unless butted.
5. Smooth and dry out stone. Prepare for Spruing.
6. Spray lower half with PNP separator, rinse with water and top with well mixed stone.
Vibrate in slowly rotating flask so teeth are covered, then add the rest of the stone.
7. Screw in 2 Allen screws diagonally opposed, making sure flasks have metal to metal



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contact.

8. When stone is set, remove the 2 screws and immerse flasks in boiling water for 7 minutes.

BOIL OUT TECHNIQUE

A. Remove bolts from flasks before putting into boiling water for **7 minutes**.

B. After 7 minutes separate flasks but allow the model side to remain in the boiling water until you complete boiling out the side containing the teeth.

C. Take the Odorless Mineral Spirits (Purchased from Home Depot- 1 Gal Container), put it into a convenient plastic bottle that you can squeeze.

D. Flush out wax with mineral spirits (a wax solvent) Then flush with clean boiling water.

(Repeat if necessary)

E. Spray with Fantastic (household cleaner purchased in super markets)
(OPTIONAL)

F. Flush with clean boiling water.

G. Allow to dry and paint with separator.

H. Put flasks under 100 watt flood lamp, but never directly.





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I. Use separator that doesn't peel, either Degussa or Flexite Acrylic Foil Separator. Two coats.

J. After opening case, put into ultrasonic cleaner with plaster stone remover and it will come out clean.

Use econo discs to cut off sprues. (You may cut off sprues before you put in cleaner)

HELPFUL HINTS:

1. Take an old tooth brush, shorten the bristle to less than one inch. Take heat gun and bend the handle at right angles so you can use it for the wax solvent.

2. Purchase basting brush in supermarket and shorten it slightly to use with Fantastic cleaner.

3. Open flask, trim sharp excesses and check teeth with fingers for any mobility. Set loose teeth aside and paint the mold with our plastic separator. Then carefully seat the teeth into place. The teeth will remain clean and you will not have to finish the occlusal surface as you would have to when using glue.

4. Place under lamps until ready to close. (Distance should be around 12 in.) Usually 25 minutes for a medium size cartridge and 30 min. for a large cartridge. A 100 watt flood light is O.K. **Flasks should be warm, not hot.**

5. Rotate occasionally so that acrylic teeth do not soften. Do not concentrate heat in one spot.

6. When ready to inject, use 4 Allen screws. Clean off all surfaces, especially the entry hole, and inject case.



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FINISHING

1. MATERIALS FOR FINISHING AND POLISHING :

A. Scraper or Bard Parker knife.

B. Nylon cutoff disc. (4 inches Econo Cutters Keystone # 1300500)

C. 2 Rubber Red Wheels – Keystone 3in x 3/8in # 1900050

Shape one to a V shape and the other to a U shape.

Use the round shape wheel for peripheral trimming and thinning.

Use the V shape wheel to trim lower anterior sections and where necessary.

D. USDD Red rubber points for flexibles (small and large # 101141)

E. 84TXC and 82TXC Carbide Bur

F. Buff 4 inches x 40 plies (# 100191) with any polish powder compound like pumice

G. Green Bar # 197-GREENBAR with 2 inches mounted buffs # 1180120

H. Flexite liquid Polish # 102091

2. SUGGESTED METHOD OF FINISHING:

A. Use nylon disc to cut off sprue.



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B. Trim to borders, and round out with Cutt off discs .

C. Check for undercuts (should have been blocked out in design) and trim back if necessary.

D. Smooth with rubber points , wheels and carbide burs

Note: Some technicians, finish entire case with rubber wheels.

POLISHING

**** Flexite M.P. and Northerm can be finished and polished in conventional Acrylic method.**

Flexite Supreme and Flexite Plus require a final step of rubber mounted pointing to create a glaze effect before polishing.

We recommend a flour pumice prior to our green compound for the ultimate hi shine.

DO NOT USE COARSE PUMICE!

ALL SCRATCHES MUST BE REMOVED BEFORE HIGH SHINING WITH MOUNTED RUBBER POINTS

USE GREEN BAR AND FLEXITE LIQUID POLISH FOR FINAL LUSTER.



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THE SECRET OF A GOOD HIGH SHINE

- A.** A Smooth wax up is imperative!
- B.** For Finishing, use acrylic trimmers to finalize the surface. (**Red mounted stone wheels for acrylic - 84TXC and 82TXC Carbide Bur**)
- C.** Rubber point entire surface with **USDD Red rubber points for flexibles (small and large # 101141)** A sheen will develop rapidly
- D.** Use any Fine Polishing Compound (**USDD Polishing powder** – Pumice) Apply slight pressure to rag wheel (**Buff 4 inches x 40 plies**) while pumicing and note quick results.
- E.** On the lathe, use now **Green Bar** with **2 inches mounted buffs**
- F.** **Flexite liquid Polish.**

HOW TO FINISH FLEXITE GUARD

Flexite Guard is an elastomer and cannot be finished in conventional methods. The procedure is as follows:

- A.** Cut and trim with a large Econo cutter (nylon disc).



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B. Take a felt wheel commonly used to polish chrome and roughen up the surface to soften slightly.

C. Start trimming the peripheral surface and shape.

D. For flat surfaces, use a rotary motion.

E. Wash off with soap and water. (Lava soap preferably)



Repairs and Additions to Flexite Plus, Ultra, Supreme & M.P.

Non Flasking quick cure method

Our Nylons can be added to and relined without flasking in non flexing areas.



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□ ***The Flexite Company developed translucent add-on powder that matches the underlying nylon plastic perfectly by incorporating the right amount of pink or ethnic color.***

A. Roughen the area or section where acrylic is to be added. We suggest you use a paper roll and put in minor grooves with a square #563 burr. Blow off and leave stubborn fibers in place. They will be absorbed and dissolved by the bonding agent. This technique is recommended for relining lower saddles or adding teeth in non-flexing areas.

B. Apply Flexite bonding agent (Aron Alpha 221) to the roughened surface and allow it to dry.

C. Prepare two dampen dishes. Select "Rapid Set" color of choice and fill one dampen dish with Rapid Set powder and the other with a quick cure monomer.

D. Apply with a brush. After build up, put the partial into a pressure pot for approximately (7) minutes at 140 degrees Fahrenheit.

For Relines:

After coating the surface with the brush method, pour powder into the liquid and mix until it thickens slightly. Then add the acrylic to the saddle.

FLEXITE M.P. REPAIRS:

Flexite M.P. can be added to and relined with our Rapid Set Pink acrylic powder and our Flexil silicone. ***With Flexite M.P. no bonding agent is required for the Rapid Set powder.*** A bonding agent is required for Flexil or silicone soft liner.



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Adding Flexil Silicone to Flexite Supreme, Plus and Ultra:

- 1) Apply #221 bonding agent to roughened surface.
- 2) Repeat steps A, B, and C above.
- 3) Roughen the acrylic surface and follow the Flexil Kit instructions.

Reinjecting Or Repairing A Fractured Lower Partial

Some strange things do happen. A patient complained her dog chewed her denture when she inadvertently left it on the bathroom sink. **WHAT TO DO?** Do not attempt to repair the fractures. If you can, pour a model from the broken denture and duplicate the original. Here is the procedure:

A. Cut bar section completely off.



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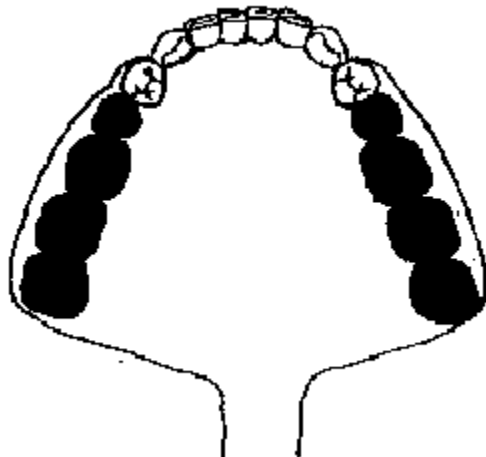
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B. Hollow out lingual, carry to necks of teeth.

C. Do not touch buccal periphery or clasp.

D. Wax lingual completely with one sheet of baseplate wax.





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E. Keep low at periphery.

F. Taper to entry hole of flask.

G. Invest and flask as usual.

H. Increase temperature 5-10 degrees for additions or add some additional minutes to oven time.



I. Trim back creating new lingual area.



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ANTI-SNORING STRAP DESIGN ONE PIECE

- (1)** Bite is to be in slight protrusive or tip to tip depending upon age of the patient. Dentist should determine opening and protrusive. Older patients require larger vertical openings. Articulate models from dentist.
- (2)** Block out undercuts on upper and lower. Provide spacing on lingual of bicuspid or grind out later for lateral movement. The fit on lower bicuspid is to be passive.
- (3)** Duplicate models and re-articulate. (two articulations)
- (4)** Wax upper full palate. We will cut it back after processing to a horseshoe shape.
- (5)** Wax lingual strap on duplicated model. Extend waxup onto bicuspid occlusals. Build up to occlusion to create two opposing flat surfaces on the bicuspid regions.
- (6)** Inject upper and lower strap separately. Do not connect.
- (7)** After processing, polish completely — sand both occlusals and lute together with Rapid Set Clear powder. Put in pressure pot and complete finishing and polishing. Seat on original articulation for final adjustments.



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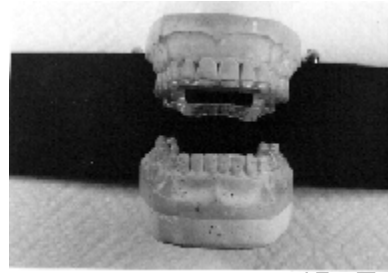
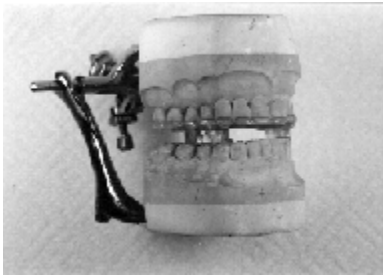
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(8) If doctor wants a tryin to check position, lute the upper to lower lightly with pink acrylic. When he makes final adjustments, cut out the pink and replace with Rapid Set clear.

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INSTRUCTIONS FOR CLASP-EZE

FLEXITE SUPREME READY MADE CLASPS



USING A SMALL FLAME: (OPTION #1)

A small flame attached to your bunsen burner is all you need. Brush your flame up and back, but never directly on the plastic. Wrap around buccal of tooth and hold momentarily in place. Cut excess off clasp and brush flame tailpiece section; press into place.



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Roughen tailpiece and dovetail for retention. A plaster index may be used to hold buccal allowing access to the retention area easier.





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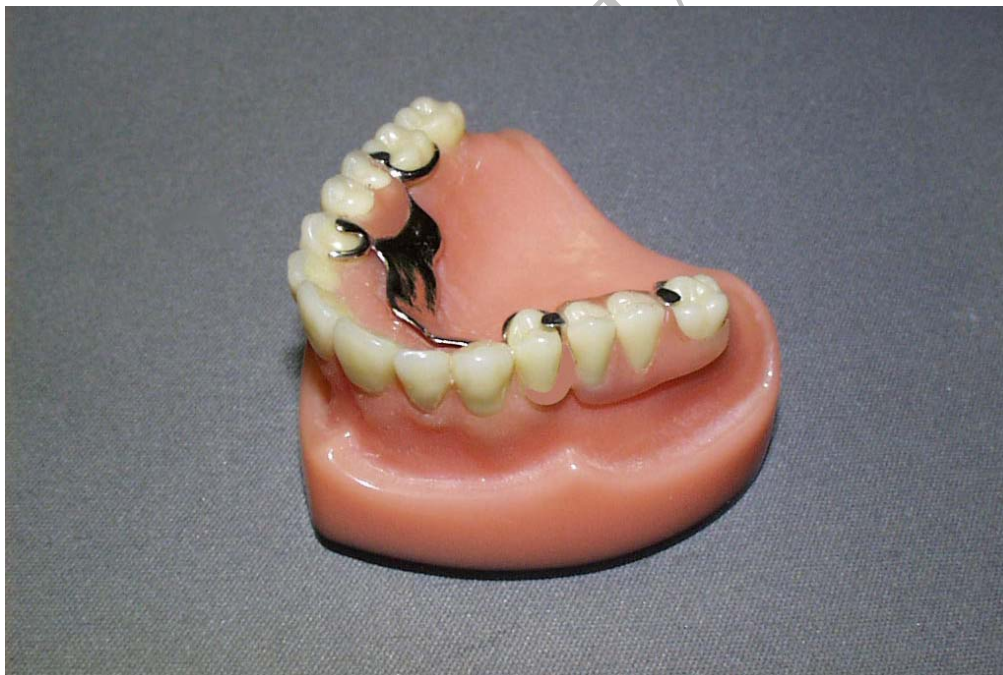
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USING THE ELECTRIC R.I.S. SELF-CONTAINED HEAT GUN: (OPTION #2)

The modified heat gun is designed to maintain a level of hot air that will not burn or damage the clasp. The heat gun will reach operating temperature immediately. A small removable tip allows you to direct the flow of air into interproximal areas. Heat clasp until it becomes limp. Adapt to buccal and hold for a moment. Cut off excess and finish adapting tailpiece section. A plaster index may be used to hold buccal section in place.

PROCEDURE FOR INJECTING TO CLASP-EZE CLASPS

- A.** Survey abutments, block undercuts, duplicate model, contour clasps and dovetail tailpiece. Shorten tip a few millimeters if you want a heavier clasp.
- B.** Wax palatal area as usual but extend onto shoulder of clasp for extra strength.
- C.** Invest in lower half of flask, paint **Denture Sep Insulating Paste** on clasp to protect clasp before adding stone in second half. (Denture Sep Available from American Dental Supply)
- D.** Do not put flasks in boiling water for the usual 7 minutes. If you have a pre-warmer, put flasks on top until wax is softened. If you must put the flask into boiling water,, then no more than 2-3 minutes. **Do not cook for 7 minutes.**
Flush out wax as usual.

Please Note: No bonding agent is required to bond Flexite Supreme to Clasp-eze.



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Bonding agent (#221 Aron-Alpha) is used to bond Clasp-eze or Flexite plus,,,,,, to our Rapid set only.

Do not use Aron Alfa on metal frame, Acetal or acrylic

- *Prepare tail by flattening out and dovetailing slightly.*
- *Add #221 Aron Alpha to the tail (top & bottom).*
- *Let dry and brush on with Rapid Set acrylic powder and any fast cure monomer.*

Helpful Hints and Designs for FLEXITE

ESTABLISHING PATH OF INSERTION AND TILT FOR ALL THERMOPLASTIC PARTIALS

I. ACHIEVING PATH OF INSERTION:

A. Draw longitudinal line through long axis of abutement teeth.

B. Adjust base so that lines are perpendicular to table.

C. Observe abutement teeth and tilt till undercut on proximal wall is minimized.

Proximal wall will be used as reciprocation and the mesial buccal for retention.

D. When using a Roach type clasp, a distal undercut is permissible.

E. When extending clasps as in a double clasp, the interproximal is utilized for retention.



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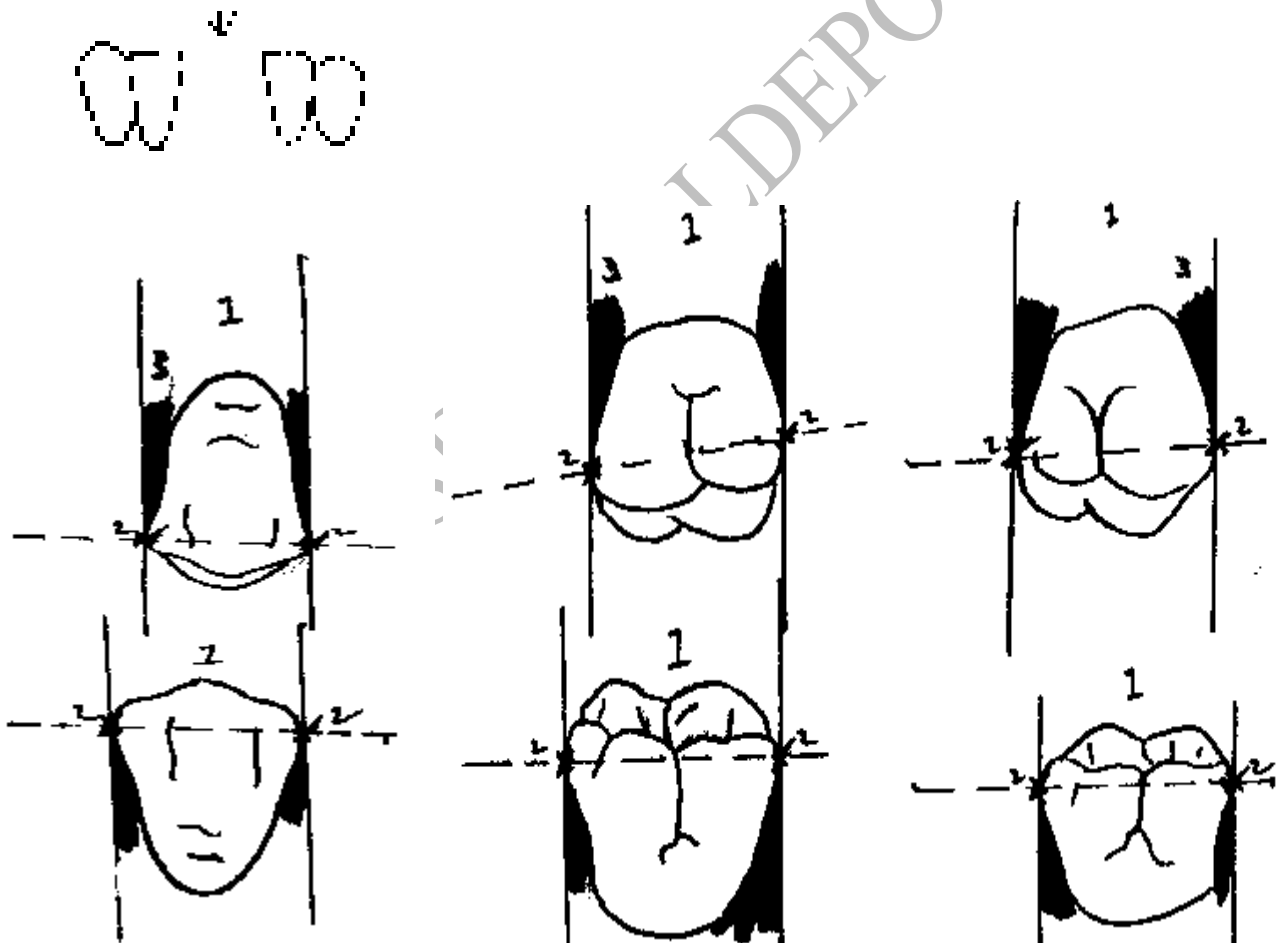
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II. a. Aesthetics #1

B. Priority is given to the most anterior abutment by tilting tooth to create undercut near gingival.

C. When anteriors are to be replaced, tilt is determined by path of insertion of anterior teeth being replaced.





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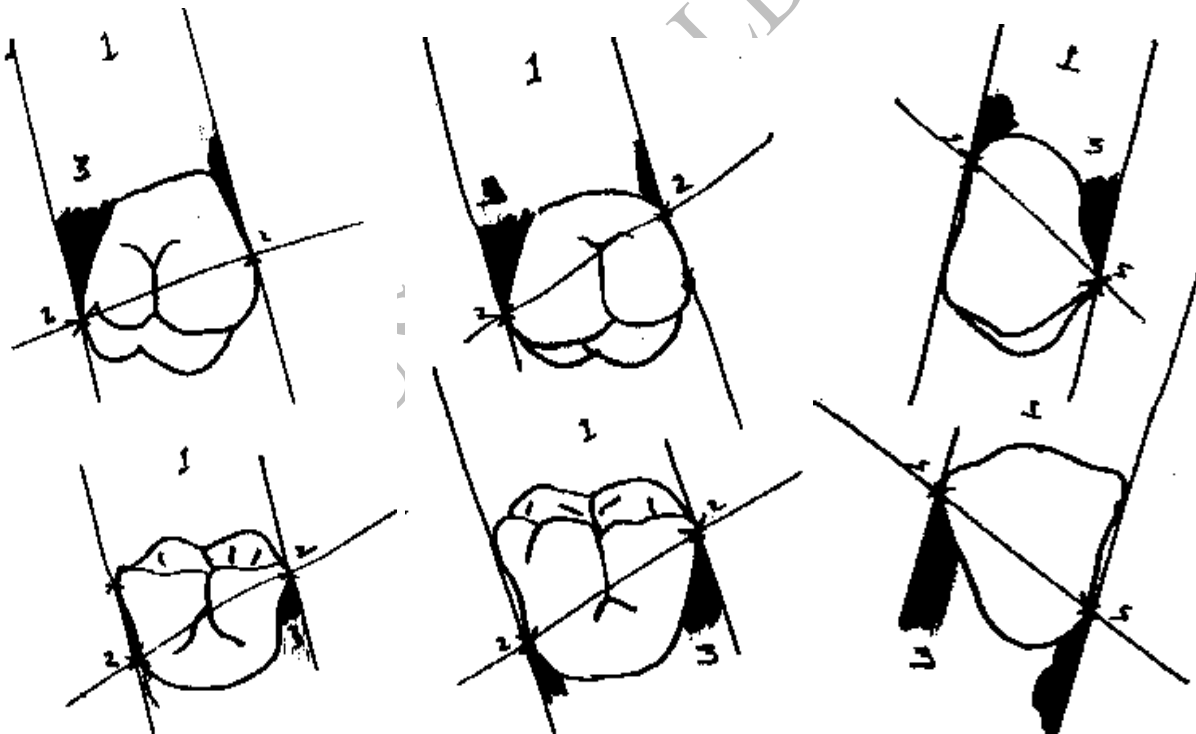
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Illustrates path of insertion

Note:

1. Straight up and down tilt of surveyor.
2. High survey line at contact.
3. Darkened areas denoting blackout areas.

Illustrates by tilting platform how a new survey line creates different conditions.





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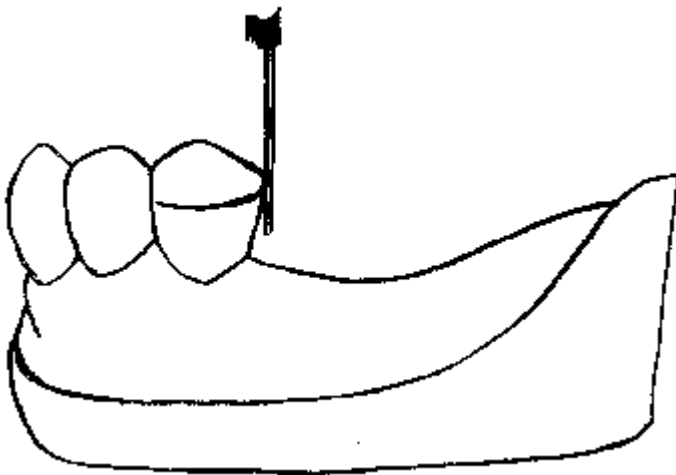
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Note:

1. More favorable tilt.
2. Survey line lower and closer to gingival.
3. Blockout areas.

EXAMPLE

START OUT WITH STRAIGHT UP & DOWN TILT.



EXAMPLE

ALWAYS TILT ANTERIORLY UNTIL YOU GET THE BROADEST CONTACT.



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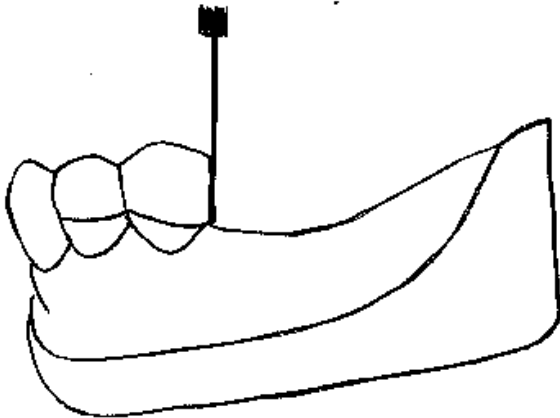
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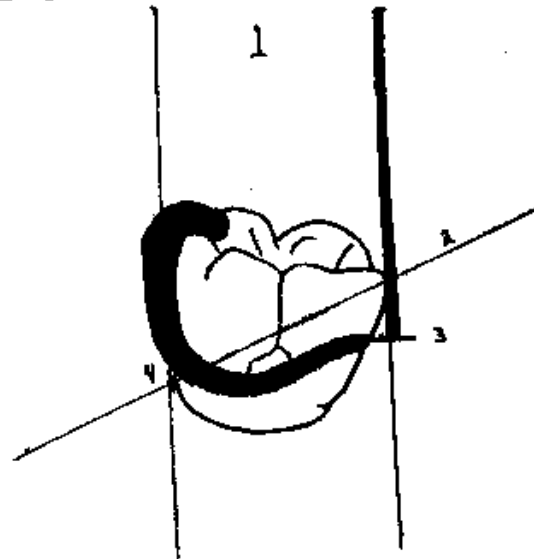
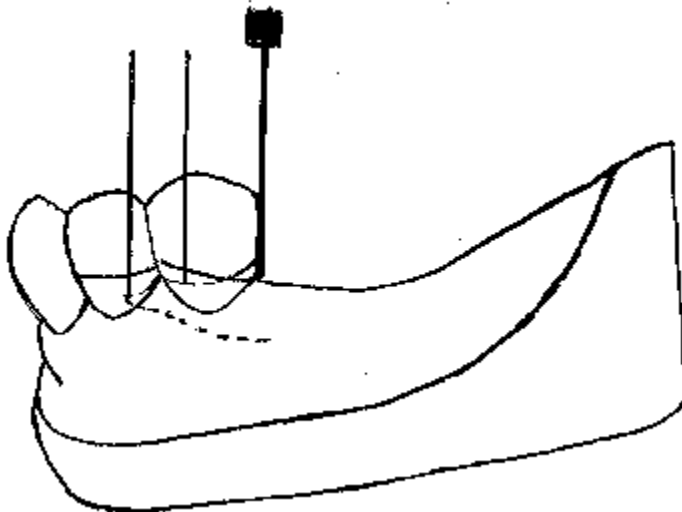
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RETENTION SHOULD BE PASSIVE, EASY TO INSERT AND EASY TO REMOVE: BUT ALWAYS RETENTIVE!

THERE SHOULD BE NO STRESS.
EXAMPLE: CLASP OUTLINE





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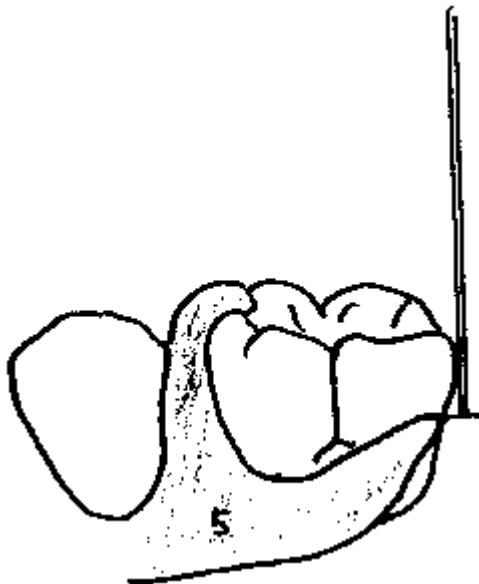
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Illustrates simple Bonwell clasp.

1. Tilt
2. Survey line
3. Undercut gage
4. Elimination of undercut in upright rest position by tilting of the molar until favorable tilt is obtained.
5. Similarity of Flexite clasp.



Illustrates using Flexite arms engaging gum mucosa areas. Though we do not recommend overall usage of arms engaging the mucosa, there are conditions that indicate the use of this retention.



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Note:

1. Point of contact with gauge.
2. Note "teardrop" type of roll at bottom of retentive arm. Bottom is rolled so that there is minimum irritation to the mucosa upon insertion.





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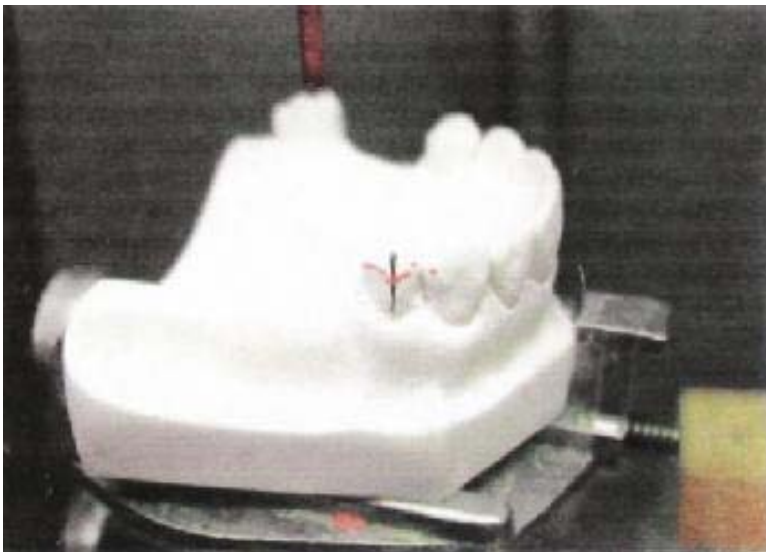
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HOW TO ACCURATELY AND CONSISTENTLY PLACE A ROACH CLASP ON A PARTIAL

Starting from the center of the buccal, draw a line through the long axis of the tooth.



Use undercut gauge to reference the two points with a pencil and connect.
Note: This principal applies to cast metal partials as well.



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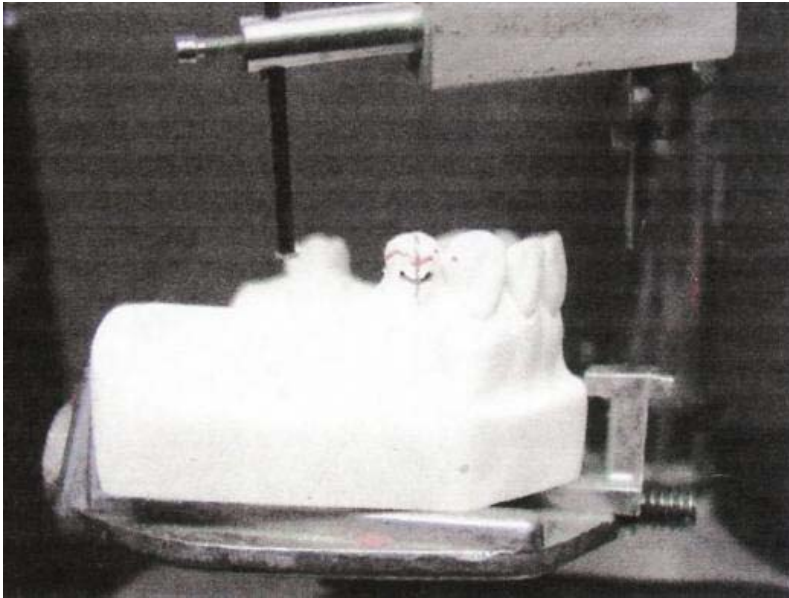
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You have now determined where the top of the clasp should be and also how far to extend the top portion of the clasp. Many chrome labs use the roach clasp forms and have a tendency to extend it too far mesial and distally resulting in a malfunctioning roach clasp.

The clasp should end where the two reference points are.



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CONVENTIONAL CLASP CHART

FOR MORE SOPHISTICATED CLASPS CONSULT YOUR LABORATORY



ONE CLASP



TWO CLASP



THREE CLASP



THREE - TWO



ONE - TWO



ONE - THREE



HALF & HALF



RING CLASP



BACK ACTION

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TEMPERATURE CHART

INSTRUCTIONS FOR INJECTION FLEXITE

PLUS	475/250 FAHRENHEIT/Celsius	12-14 MIN
SUPREME	530/276 FAHRENHEIT/Celsius	30 MIN
M.P.	520/271 FAHRENHEIT/Celsius	25 MIN
GUARD	425/218 FAHRENHEIT/Celsius	15 MIN
NORTHERM	520/271 FAHRENHEIT/Celsius	20 MIN
ACETAL	475/246 FAHRENHEIT/Celsius	15 MIN
FLEXITE ULTRA	520/271 FAHRENHEIT/Celsius	18-22 MIN

Leave under pressure for 30 seconds and start the cooling process

REMOVE IMMEDIATELY AFTER THE COOLING PROCESS

Do not exceed more than 2-3 minutes in cold water

NEVER LEAVE CASES IN FLASK OVERNIGHT AS THE STONE GETS HARDER AND DIGGING OUT IS MORE DIFFICULT



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**TEMPERATURES AND HOLDING TIMES SUGGESTED
FOR USING FLEXITE PRODUCTS WITH VALPLAST
FURNACE / MACHINE.**

(as the Valplast furnace can not be changed in its temperature, we will work on the holding time for our Flexite products in order to get good results)

	<u>Temperature</u>	<u>Oven Time</u>	<u>Cooling Time</u>
<u>Flexite Plus</u>	550F	11 minutes	7 minutes bench
<u>Flexite Supreme</u>	550F	20 minutes	7 minutes bench
<u>Northerm</u>	550F	20 minutes	7 minutes bench
<u>Flexite M.P.</u>	550F	20 minutes	7 minutes bench
<u>Acetal</u>	550F	10 minutes	7 minutes bench
<u>Flexite Ultra</u>	500F	18 minutes	7 minutes bench
<u>Flexite Guard</u>	475F	25 minutes	7 minutes bench

Leave under pressure for 30 seconds and start the cooling process

REMOVE IMMEDIATELY AFTER THE COOLING PROCESS

Do not exceed more than 2-3 minutes in cold water

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For additional technical information call: 1954-874-6325

Suggested Air/Ni pressure:

Suggested 130 lb



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TROUBLE SHOOTING CHART FOR FLEXITE PLASTICS

TROUBLE POSSIBLE CAUSES REMEDY

Short incomplete

Wrong temperature Check Chart for Correct Temperature.

Cold Flasks Check lamps for proper heat. Flasks should be hot to the Touch.

Improper Sprues Use sheet of base plate wax for sprue. See page 10 in manual.

Waxup Too Thin Check areas where wax stretches in palate.

Not enough Pressure 145 lbs max. pressure for all plastics.

Left in oven too long Check proper time in oven.

Color Change

Overheating Bring Oven Down to Proper Temp.

Check proper length of time in oven.

Bubbles

Overheating Reduce Temperature or Time.



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Streak or Silicone Grease Do not put silicone near entry hole

Separations on Entry Side carry only to crimp on cartridge.
of Cartridge. Occasionally boilout steel chambers.

Raised Bites

Matrix Transfer Check Carefully. Cut away stone where

Not Accurate. interfering with bite.

Check Metal to Use Stone for Investing.

Metal Contact Follow Instructions in booklet, pge 8 on Flasks. Ditch stone around edges to make sure upper and lower flasks are flush. Using 1/2 & 1/2 Correct by using **all** stone.
plaster/stone

Teeth Popping out

No Diatorics present Create Diatorics. See page 6

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KITS

Polishing Kit

USDD - 101141 Rubber point Large Red

1 Buff #100191 - 1 kg Policryl #100461

1 Polishing Liquid Flexite #197

1 red Wheel 3 inches diam #034-1900050

1 greenbar(kit pulido kits) 197

84txc HP Carbide bur #365-120-84TXC

82txc HP Carbide Bur #365-121-82TXC

4 inches Econo Cutters Keystone # 1300500

2 inches mounted buffs # 1180120

FLEXITE- STARTER KIT

**- Flexite Starter Kit - Medium Cartridges -10
Flexite PLus**

- Light pink -10 Flexite plus

- Traslucent pink -10 flexite plus

- Traslucent Con - Supreme dark pink

- 5 Supreme natural clear

- 5 Mp Lucitone pink large

- 5 Mp Clear - 1 Flexite polish [100441]

- 2 burs [84TXC - 82TXC]

- 1 box red rubber wheels [034-1900815]

- 1 big rubber wheel for lathe [034-1900050]

- Printed Flexite instruction manual (60 pag)

- Printed Flexibles temperature chart

- Printed guides step by step for re- injecting and repairing

#100866





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FLEXITE - REPAIR WITH GUN

- 1 Heat Gun
 - 1 Rapid Set Pink and Clear
 - 1 Aron Alpha 221
 - 1 DVD Video
 - 2 Clasp Eze 12 packs (Pink and Clear)
- # 197-REPAIR-



FLEXITE - REPAIR KIT (NO GUN)

- 1 Repair liquid
 - 1 Rapid Set Pink and Clear
 - 1 Aron Alpha 221
 - 1 Dvd Video
 - 2 Clasp Eze (12 pack) (Pink - Clear by default)
- (no heat gun included)
- # 100865

