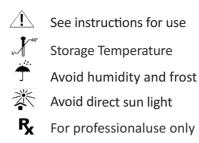


MEANING OF SYMBOLS



TYPICAL MATERIAL PROPERTIES AND CHARACTERISTICS

Chemical description	100 % PMMA (polymetil methacrylate)		
Density	1,19 g/cm3		
Modulus of elasticity	2390 MPa		
Vicat softening temperature	102°C / 215°F		
Ball indentation hardness	145 MPa		

INTENDED USE

PMMACAST is used as an alternative to wax. It is suitable for the manufacturing of models to realise the primary mold in the technique of lost wax casting for manufacturing crowns and bridges made of metal ceramic.

PMMA CAST is useful also for making structural test of the oral cavity before performing milling of final material, Zirconia or other

Warning! It's not a medical device, it can't be used for frameworks to be placed in the oral cavity.

STORAGE

Store the product in its box, protect from direct sunlight, keep far from heat sources and in a dry place, within ranges of temperature ($5^{\circ}C \div 40^{\circ}C$).

ADVANTAGES OF PMMA CAST

- Easy to be milled
- Burns out without residues
- Models realized with PMMA CAST have higher bending strength and higher dimensional precision if compared to wax. They can be used also for long bridges.
- Allow to achieve excellent thicknesses of walls and connectors in order to realise frameworks made of metal ceramic, reducing the adjustment processing.
- In case of repetition of fusion, the time to make the milled model again is short.
- Models realized with Pmma Cast can be tested on the oral cavity

INSTRUCTIONS FOR USE

PMMACAST is realised with millable Pmma and can be processed with the most common Cad-Cam systems.

NOTES FOR MILLING

The following processing data, speed and movement of the tool must be "adjusted" from the dental technicians according to shape and thickness of the prosthesis to be processed.

PROCEDURE	TOOL	Ø TOOL	ROTATION SPEED RPM	FEED RATE	CUTTING DEPTH	COOLING
	Tungsten carbide with 1 flute	Ø 2-2,5 mm 3 mm	18-22000 Rpm	18-22mm/min	0,5 mm	Air or water
	Tungsten carbide with 1 flute	Ø1mm	15-16000 Rpm	16-17mm/min	0,2 mm	Air

Use tungsten carbide burs with one flute.

The use of tools suitable for working with Zirconia (2 cutting edges), new or not, for the processing of PMMA is not recommended; this may cause overheating of the material.

In order to separate the milled frameworks from the blank, cross-cut carbide burs suitable for cutting acrylic materials must be used.

SPRUING

The rules for making sprues depend on the alloy or on the press ceramic used. Follow technical information of producers of alloys.

INVESTING

Use a ceramic ring liner. Mix the investment material using vacuum, following manufacturer's instructions for use. Heat the mold conventionally or with a rapid heating system up to 580°C (1076°F), with a holding time of 30 minutes. Then increase the temperature of the mold to the appropriate top temperature, according to the alloy or ceramic used. Follow the manufacturer's instructions for use for the investment material, alloy and/or ceramic used.

DISPOSAL

Wastes of Pmma cast can be disposed of through the domestic residual waste system. PMMACAST is insoluble in water, inert and presents no danger of pollution.