

# primoflex CLEAR

## Manual

### Product description:

primoflex CLEAR is a transparent, thermoplastic PMMA plastic for the production of functional therapeutic bite splints with memory effect.

As a PMMA powder / liquid plastic system, it is used in pack pressing technique and casting technique.

### Indication:

Fabrication of function therapy bite splints.

## General information primoflex CLEAR

### Mixing ratio:

11g (15ml) Powder zu 7,2g (7,5ml) Liquid

### Storage:

Liquid must be stored in a refrigerator at a temperature of 5-9°C.

- Powder must be stored at room temperature of 20-23°C.
- Both components should be cooled for approximately 15 minutes before mixing.

### PLEASE NOTE:

The **mixing ratio** and **temperature** must be strictly adhered to, as otherwise the plastic cannot cure correctly. To prevent uncontrolled chemical reactions only use a mixing bowl and mixing spatula that do not come into contact with any other plastic. Repairs are performed in the customary manner.

The area is first roughened, then wetted with a little primotec primoclean fluid and finally processed with fresh „primotec primoflex CLEAR material.

### Care instructions:

Clean the primotec primoflex CLEAR splint with a toothbrush and toothpaste under running water. Please do not allow to dry by evaporation! Disinfect with an alcohol-free cleaning agent before first use.

### Working instructions:

#### Pack pressing technique

1. Prepare the model in the normal way, measure and mark the tooth equator. As primotec primoflex CLEAR is a flexible material, the splint can be arranged slightly above the tooth equator.

2. The splint to be created is waxed-up in the articulator taking into account the chewing movement (for example with pink wax sheet), and then bed the model into a cuvette. Now cool the required amount of powder in a refrigerator, (both components must be cooled before mixing).

3. Isolate all exposed plaster parts of the embedding with alginate isolation. As soon as the isolation is dry the counterpart can be produced from the modelled wax splint. Once the counterpart wax has set completely hard the complete cuvette is warmed in a hot water bath. This aids opening the two halves of the cuvette.

4. Remove the wax from the modelled wax splint, scald the model and the counterpart, water and isolate with alginate isolation.

**TIP:** Severe undercut areas and interdental spaces should be sufficiently blocked off so that when the splint is completed it can be lifted without damage to / from the model.

5. Remove the liquid from the refrigerator immediately prior to processing.

6. Mixing ratio: 1 part powder / 0.75 parts fluid  
**IMPORTANT:** Strictly adhere to this ratio! - 12 ml powder and 9 ml liquid are required for a small splint. - 16 ml powder and 12 ml liquid are required for a large splint.

7. Measure the primotec primoflex CLEAR material in the dosing cups (remove the liquid using the pipette provided), bring together in a separate rubber mixing cup, mix rapidly with the spatula excluding any bubbles for 5 to 10 seconds, cover and leave to stand.

8. As soon as primotec primoflex CLEAR adopts a paste-like consistency, (approximately 5 minutes), the plastic in the cuvette is placed over the row of teeth and the upper part of the cuvette is positioned. Any visible white spots

in the stirred paste result from the production process and are no longer visible after polymerization.

9. Now quickly screw down under the press and then leave to polymerize in a bath of water at 2 bar and 50°C (maximum 53°C!).

10. The cuvette must be completely cooled down before opening! This is ensured by placing the cuvette in a cold bath of water for approximately 15 minutes.

11. Now carefully lift the splint from the model and perform the usual finishing and polishing.

**TIP:** Before lifting off from the model and before setting in the patient's mouth the splint must be made slightly flexible by exposing to lukewarm water.

#### Casting technique

1. Prepare the model in the normal way, measure and mark the tooth equator. As primotec primoflex CLEAR is a flexible material, the splint can be arranged slightly above the tooth equator.

2. The splint to be created is waxed-up in the articulator taking into account the chewing movement (for example with pink wax sheet), and then bed the model into a cuvette. Now cool the required amount of powder in a refrigerator, (both components must be cooled before mixing).

3. Now prepare a silicone counterpart and allow to cure. Once the silicone counterpart is fully cured it can be carefully lifted off. Cut an excess channel free with a sharp scalpel on the tuber or both sides on the retromolar triangle.

4. Remove the wax from the modelled wax splint, scald the model and the counterpart, water and isolate the still warm plaster model with alginate isolation (the silicone counterpart is then isolated with a thin layer of Vaseline). Once the isolation is dry and the model is completely cooled down, (simply place it in the refrigerator), place the counterpart back on the model and secure.

**TIP:** Severe undercut areas and interdental spaces should be sufficiently blocked off so that when the splint is completed it can be lifted without damage to / from the model.

5. Remove the liquid from the refrigerator immediately prior to processing.

**IMPORTANT: The mixing ratio must be strictly adhered!**

6. Mixing ratio: 1 part powder / 0.75 parts fluid  
**IMPORTANT:** Strictly adhere to this ratio! - 12 ml powder and

9 ml liquid are required for a small splint. - 16 ml powder and 12 ml liquid are required for a large splint.

7. Measure the primotec primoflex CLEAR material in the dosing cups (remove the liquid using the pipette provided), bring together in a separate rubber mixing cup, mix rapidly with the spatula excluding any bubbles for 5 to 10 seconds, cover and leave to stand and immediately pour the free-flowing material into one side of the counterpart until the plastic can be seen on the other side of the counterpart.

8. Now polymerize the model with the filled silicone counterpart as quickly as possible - for 45 minutes - in a pressure curing unit at 2 bar and a minimum of 50°C (maximum 53°C!).

9. Then the workpiece is removed from the pressure curing unit and cooled in cold water before the finished splint is taken off.

10. Now carefully lift the splint from the model and perform the usual finishing and polishing.

**TIP:** Before lifting off from the model and before setting in the patient's mouth the splint must be made slightly flexible by exposing to lukewarm water.

#### Polishing:

primoflex CLEAR bit splints are polished with conventional brushes and compounds for acrylic. For pre-polishing pumice with an adequate polishing wheel or buff should be used at approx. 3000 rpm. For high-shine polishing a cotton buff with a conventional high-shine polishing compound is recommended.

Excessive heat generation during polishing always needs to be avoided. Careful high-shine polishing is necessary to achieve a perfectly smooth surface, thus avoiding plaque accumulation and its negative consequences. Before shipping to the dentist lightly coat the surfaces in contact with the stone model with paraffin oil.

#### Cleaning:

For cleaning, the finished bite splint is placed in a water filled ultrasonic cleaning unit for one minute at 35°C (95 °F). Cleaning solutions and denture cleaners are not recommended. Steam cleaning results in heat and compressive stress and must be avoided.

**TIP:** - A primoflex CLEAR bite splint must be thoroughly cleaned before it is inserted in the patient's mouth. To avoid taste irritation, the manufactured splint should be watered for min. 12 hours.

#### Safety instructions:

1. Primotec primoflex CLEAR bite splints may only be worked on under a local work bench dust suction unit.
2. Wear dust mask and protective glasses to prevent dust particles entering mouth and eyes or having contact with the mucosa.
3. Users who react allergic to acrylic resin materials should be especially careful when working with primoflex CLEAR.
4. A primoflex CLEAR bite splint must be thoroughly cleaned, before it is inserted in the patient's mouth. To avoid taste irritation, the manufactured splint should be watered for 24 hours.
5. Primotec primoflex CLEAR was especially developed as a material for bite splints in dentistry and must only be used by dental professionals as intended. The material is not suitable for denture bases.
6. A milled Primotec primoflex CLEAR bite splint can only be used for the one patient it was made for.
7. The Primotec primoflex CLEAR material is water insoluble, inactive and have no negative effect on ground water. Therefore it can be disposed in normal household garbage.
8. primoflex CLEAR is to be kept out of the reach of children.

#### Care instructions for the patient:

The Primotec primoflex CLEAR splint should be cleaned with toothpaste after each use. Do not use denture cleaners. Place the splint in warm water at 35-40 °C (95-113 °F) for 1-2 minutes before insertion. Protect the splint from extreme heat and coldness.

#### Hazard note:

H315 Causes skin irritation  
H317 can cause allergic reactions to your skin  
H319 Causes serious eye irritation  
H335 May cause respiratory irritation  
R43 May cause sensitization by skin contact  
R36 / R37 / R38 Irritating to eyes, respiratory system and skin

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Expiration date



Lot number



Read instructions

