

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

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The Natural Choice

Perflex Flexi Nylon®

Flexible denture base thermoplastic for injection molding systems.

Chemical Composition: Polyamide

Thermoplastic nylon compound

Class I according to EEC/93/42

Product form: Pellets

For professional use only.

Features:

- ◆ Metal replacement unbreakable thermoplastic
- ◆ Biocompatible - non-allergic
- ◆ Aesthetic
- ◆ Translucent
- ◆ Comfortable
- ◆ Excellent Dimensional Stability & elastic memory
- ◆ Light weight
- ◆ Immediate comfort
- ◆ Low water absorption
- ◆ High color stability
- ◆ Repairs welding & Fuse liquid technique

Applications

For the production of flexible removable partial dentures, Over-dentures, Mini dentures, Unilateral dentures, Space maintainers, TMJ splints, Night guards, Clasps.

PERFLEX FLEXI NYLON can be repaired and relined by the fuse liquid technique and by the welding technique.

COLORS:

Light Pink, Standard Pink, Purple Pink, Natural.

RECOMMENDED PARAMETERS FOR INJECTION

MOLDING ON SMART 101 AUTO-INJECTOR MACHINE:

Temperature	260°C
Time	11 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 5mm red-single sprue at both sides of the denture.
2. After investment and boilout, proceed with suitable preparation holes for retention on the artificial acrylic teeth.
3. Glue the artificial acrylic teeth into the gypsum cavities with FN CEMENT a PERFLEX product.
4. Turn on the SMART 101 Super injector furnace and set program: temperature to 260°C for 11 min.
5. Lubricate the aluminum 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 260°C, insert the lubricated cartridge tube with its cap facing outwards into the furnace.
7. Place isolating separator ISOSEP GLAZE 2 coats on to Plaster surfaces corresponding to the Denture area only.
8. Close the flask with 4 screws and place into the Injector machine, 2-5 min before injection.
9. At 11 min. mark inject the material.
10. Keep the FLASK inside the injector under pressure, cooling (furnace switched off) for 5min.
11. Release the flask from the injector, and bench-cool to room temperature.

12. Deflask and proceed with processing and polishing as for thermoplastic materials, using 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 cold.

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

Melt Perflex – FLEXI NYLON 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.

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 could 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 degrees 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 Flexi Nylon®** may be cleaned and disinfected Using **Flexi Clean® Concentrated Denture Cleaner** a product of **Perflex Ltd.**