Instructions

Instaflex™ Concentrate duplicating material

Properties*

Color	Melting Temperature	Idle Temperature	Hold Time
Pink	192°F (89°C)	131°F (55°C)	≤10 minutes

**These results are based on the testing methods, frequency and procedures of Ransom & Randolph or its approved suppliers. The levels referenced herein are only for general guidance and do not constitute a firm specification.*

Step 1: Model Preparation

Model

1. Soak the model in water for 20 minutes so it becomes fully hydrated.
2. Place the hydrated model in a duplicating flask. Do not use containers made from aluminum, copper, iron, or alloys containing these materials.

Step 2: Prepare & Melt Instaflex Concentrate

Choose your preferred melting method below:
**Do not use a microwave to melt Instaflex Concentrate.*

Option A: Neycraft™ Multizone™ duplicating unit	Option B: Hotplate
1. For first-time preparation: Fill the duplicating unit to the 2-gallon mark with water. Scoop the Instaflex Concentrate into tablespoon-sized portions and add them to the water. For best results, prepare the entire pail at one time. 2. Set the unit to 192°F (89°C). Melt completely and hold for no more than 10 minutes. 3. Reduce the unit to the idle temperature of 131°F (55°C).	1. For first-time preparation: Combine Instaflex Concentrate and water using one of the following ratios: • *By weight: 1 part concentrate to 1.66 parts* • *By volume: 1 part concentrate to 2 parts water* 2. Place the mixture in a suitable heat-resistant glass beaker on a hotplate. Stir continuously while heating until completely melted and smooth. 3. Heat to 192°F (89°C) and hold for no more than 10 minutes. Remove from heat and cool to 131°F (55°C) while stirring.

Step 3: Pour & Cool

1. Pour the melted material into the prepared duplicating flask.
2. Allow the mold to cool at room temperature for 60–90 minutes before removal.

Step 4: Model Removal

1. Gently remove the original model from the mold, and wash under cold running water.
2. Gently blow dry with air jet.
3. Place the mold open-side down on a clean bench surface to help prevent drying and shrinkage.

Step 5: Duplication

Stone Model

1. Mix stone as per manufacturer's instructions.
2. Pour the mixture into the mold.
3. Allow the material to set according to the manufacturer's instructions.
4. Tear mold away from duplicate model.
5. Trim model and rinse with water.

Refractory Model

1. Follow manufacturer's instructions for mixing and setting time of the refractory material. Do not use Instaflex duplicating material if Protective Coat is specified in the technique.
2. Pour the mixed refractory material into the mold.
3. At the proper time, remove mold with duplication from the flask.
4. Tear mold away from duplicate model.
5. Trim model and rinse with water.

Fluid Resin Pouring

1. Properly soak model with wax pattern and position in a flask as required.
2. Fill the flask with molten material.
3. Chill in a cold water bath at 50 ± 10°F (10 ± 5.6°C) for 40 minutes. Position flask in the water bath on slats or ribs to allow proper water circulation.
4. After chilling, disassemble the flask and remove the mold.
5. Make three or four relief cuts in the mold, taking care not to cut into the waxed area. Gently remove the model.
6. Cut desired sprues and venting holes.
7. Rinse mold in rapidly running cold water.
8. Blow dry with an air jet and cover mold not being worked on with a damp towel.
9. Follow resin manufacturer's technique for casting dentures.

Step 6: Clean-Up

1. Rinse the used mold to ensure it is free of any gypsum or refractory debris.
2. Store the material in a closed, airtight container until the next remelt cycle.

Step 7: Remelting Procedure

1. Using a knife, cut the cleaned and thoroughly rinsed Instaflex into small pieces, approximately 1 inch (25 mm) cubes, and place into the duplicating unit or a sealed plastic bucket for reuse.

Proceed to **Prepare & Melting selection.*

Tips

- If material becomes thick, slow-pouring, dry, or brittle after several remelts, add 5 fl oz (150 mL) of deionized water per pail at the beginning of the remelt cycle.
- Do NOT exceed Instaflex duplicating material above 195°F (91°C).
- To speed up the cooling process, place 1/3 of the flask in cold water bath at 50 ± 10°F (10 ± 5.6°C) for 45 minutes. Chill longer if water temperature is warmer than 60°F (16°C).

Storage

Keep container tightly closed when not in use. Store at room temperature. Shelf life is 2 years from the date of manufacture found in the first six digits of the lot number on the label in MMDDYY format.

Safety

Warning. Causes skin irritation. Causes serious eye irritation. Avoid contact with skin and eyes. Wash hands thoroughly after handling. Wear protective gloves and eye protection. See SDS for more information.

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