


Contact	<p>HPdent GmbH Erwin Dietrich Str. 5 D - 78244 Gottmadingen www.hp-dent.com kontakt@hp-dent.com +49 (0)7731 3811044</p>
Product Name	<p>InovaCAM Esthetica / Clear</p>
	<p>DentalPlus GmbH Kohlgrub 5 D - 83122 Samerberg email: info@dentalplus.info</p>
Field of Application	<p>Esthetic Long term Prosthetics / Esthetic Temporary Prosthetics InovaCAM Esthetica is a multilayer or transparent high performance PMMA</p>
Intended Use	<p>suitable for cemented and screw restrained dental prosthetics for long term and provisional prosthetics.</p>
Composition	<p>Acrylic Polymer of mehtyl methacrylate</p>
Instructions for use	<p>Milling needs to be processed with a designated PMMA strategy (Feedrate, Speed). Please contact the manufacturer of your machine. Do not use diamond coated tools resulting in overheating the material (smearing). Use a crosscut tungsten carbide bur for cutting connector without using to much pressure. Use suitable silicon polisher and goat-hair bristle to pre-polish. High luster can be obtained easily with suitable polishing compound.</p>

Important Notes Avoid overheating during the machining and finishing.

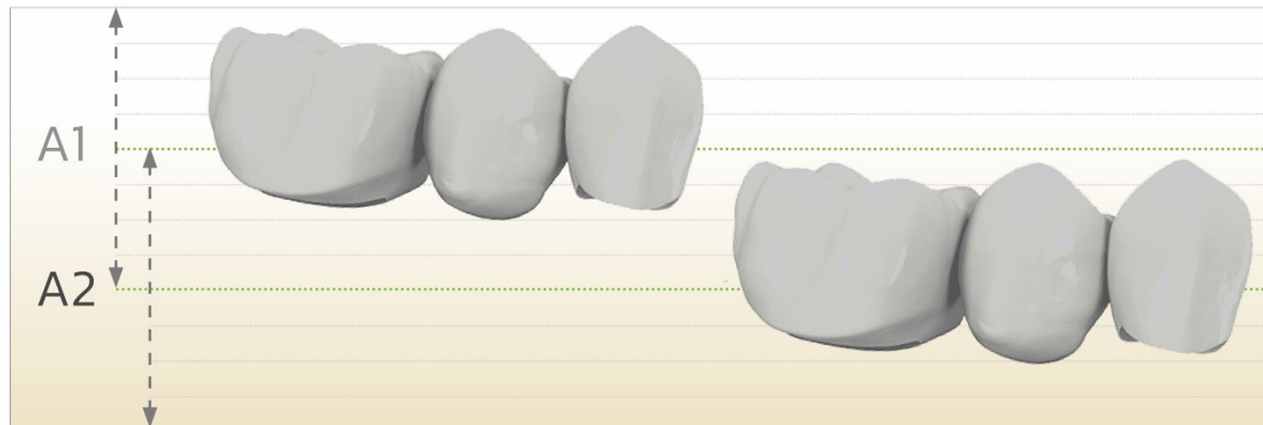
Alcohol and Benzol in high concentrations cause micro cracks on PMMA's.
Please do not use Cleaning or Disinfecting Agents containing these substances.

Cleaning / Disinfecting Steam cleaning may cause overheating of the material and should be avoided. Please clean manually, or use an ultrasonic cleaner.

Storage Store at room temperature and avoid direct sunlight.

Typical mechanical properties	Score	Normative / Test method
E-modulus	3370 Mpa	
Tensile strength	76,3 Mpa	acc. to DIN EN ISO 527
breaking tension	70,3 Mpa	
Flexural strength	136 Mpa	
Water absorbtion	19,36 µg/mm³	acc. to DIN EN ISO 10477
Water solubility	<0,8 µg/mm³	24h at 37°C / 30 min. in air
Residual monomer	<0,4%	--
Benzoyl peroxide content	--	--

Positioning / Nesting



Suggested Milling Parameters Score

Roughing out

Speed (rpm)	2 (2,5) mm
Feedrate (mm/min)	17.000 - 19.000
Z-axis infeed	1.000 - 1.200
	0,5 mm

Finishing

Speed (rpm)	1 mm
Feedrate (mm/min)	20.000 - 25.000
	1.100 - 1.500

Details

Speed (rpm)	0,6 mm
Feedrate (mm/min)	20.000 - 28.000
	900 - 1.300

Suggested Distance to outer
edge

2 mm

Suggested cutter geometry

1 - Flute

Limits

min. wall thickness - 0,6 mm (cervical) - 1,0 mm occlusal

min. connector diameter Anteriors - 4,0 mm

min. connector diameter Posterteriors - 5,0 mm

Certification

CE 0481 / Medical device class IIa acc. 93/42/EEC