



## DUPLIFLEX 22

### Description

DUPLIFLEX 22 is a two component silicone elastomer that crosslinks at room temperature by a polyaddition reaction.

The components are available as viscous liquids, which cure after mixing to a flexible material.

### Use

DUPLIFLEX 22 is specifically formulated for reproduction of moulds in dental laboratories.

It is used for reproduction of resin, investment and gypsum moulds and masks.

### Advantages

- Easy processing: It is provided in two components that are mixed to equal parts ( 1 : 1 ) with no need to make complicated measurements. Due to the high fluidity of both components A and B, the mixture is made very easily and with the minimum risk of air content in the mixture
- Easy curing: DUPLIFLEX 22 begins to cure at room temperature right after blending the components A and B regardless of the thickness of the mould or possible confinement of the curing rubber
- Low linear shrinkage after complete reticulation
- Natural adherence
- Resistance to reversion
- High and constant precision when making successive moulds and duplicates.
- Without healthy risks : it doesn't produce toxic substances neither before nor after vulcanization.
- Great elasticity

### Characteristics

Appearance: viscous liquid  
Colour: milky white ( component A )  
apricot ( component B )

Viscosity at 23° C: 7 000 mPa·s

Mixing ratio: 1:1 ( A : B )  
Mixing time: 30 sec.  
Working time: 4 - 5 min  
Reticulation time: 15 min  
Demoulding time: 30 min  
Shore A hardness 20 – 22 ( 30 minutes )  
22 – 24 ( 24 hours )

### Application method

Dose 100 parts of DUPLIFLEX 22 - A and 100 parts of DUPLIFLEX 22 - B in a clean container, mix the two components until getting a uniformly colour dough.

The mixing must be done slowly to avoid the air trapping. It's recommended a slow and regular casting of the dough in a duplicating flask, forming a thin wire. Normally it's no necessary the use of a wetting agent. A moderate casting avoids the air inclusion.

Due to the short time of vulcanization of the mixing and the need to avoid the presence of air bubbles that can damage the mechanical properties, it's recommended a vacuum mixing, or the use of a dosing machine

The model must be at 5 mm of the duplicating flask walls and the silicon must cover the upper part of the model at least 4 mm .

If the hardening of DUPLIFLEX 22 is done under pressure, it's important to use exactly the same pressure as the duplication one.

Follow the instructions of the manufacturer when gypsum, investment or resin are used as duplicating materials . We recommend doing the duplication under vibration. Use a tension surface reducer as TENSIO SIL to obtain smoother and more exact duplicating models  
Depending on the used investment, it might not be necessary to hard the model ( as, for instance, CALIBRA-M ).



# WORKING INSTRUCTIONS

## Warning:

To do the mixing, use only plastic or stainless steel tools.  
The cross link can be delayed or stopped on contact with: metallic salts, amines, sulphide and derivate and catalyst of epoxy resins.

To clean the used tools, simply let harden the silicone

Vulcanized silicone can be re-used. Cut it in small pieces and use it as filler around the model, leaving enough space to allow DUPLIFLEX 22 to penetrate in all the empty spaces.

## Safety cautions

During the handling of component A and B of DUPLIFLEX 22, you must avoid the absorption, long and repeated skin contact. When cutaneous contact has been produced, wash with soap and water.

In the event of eye contact, wash immediately with plenty of water for at least, 15 minutes and consult a doctor.

For further information, see the safety security sheet.

## Storage and expiry

A and B components of DUPLIFLEX 22 are stables for 24 months after the fabrication date, following the storage conditions

Keep the product in its original packing and in a dry place away from moisture, sun light and maintain the temperature under 30°C

After each use, close the containers with its respective stopper, avoiding the exchange.

Avoid the contact of vulcanized product with the content of the container.

## Presentation

DUPLIFLEX 22

5034-10T	1000 g A + 1000 g B
5034-50T	5000 g A + 5000 g B
5034-M1T	Kit INTRO

## Guarantee:

Our recommendations referring to the techniques applied, whether verbally, in writing or in the form of practical instructions, are based on our own experiences and/or tests, and must therefore be considered only as instructions. Our products are subject to continuous development. We therefore reserve the right to make modifications.



**protechno**

Polígono Empordà Internacional  
17469 VILAMALLA, GIRONA, SPAIN  
Tel.: ( 34 ) 972 52 61 69  
protechno@protechno.com  
www.protechno.com