











POLYconcept
polycam
USER MANUAL
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POLYCAM MONOCOLOR 

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SYMBOLS GLOSSARY
(UNI 15223-1:2017)

-  European conformity (CE) mark with notified body identification number for Class IIA.
-  Manufacturer
-  Catalog number
-  Batch code
-  Use-by date
-  Avoid humidity. Keep dry
-  Keep away from sunlight
-  Consult instructions for use

TYPICAL MATERIAL PROPERTIES AND CHARACTERISTICS

Chemical description	Synthetic material (PA) 99,9%-100%
Pigments and additive	<0,10%
Density	1,020 g/cm ³
Modulus of elasticity	2150 MPa
Vicat softening temperature	258°F
Solubility	<3,5 µg/mm ³

INTENDED USE

Polyamide resin blanks used to manufacture, after appropriate milling, permanent dental prosthetics to be inserted in the oral cavity.

STORAGE

Store the product in its box, protect against heat and direct sunlight.

INSTRUCTIONS FOR USE

Polycam requires milling with water or air cooling. When air cooling is used pay attention to keep the material cool during milling.

NOTES FOR DESIGN OF BRIDGES AND CROWNS

- occlusal wall minimum thickness 1,2mm
- cervical wall minimum thickness 0,6mm
- transversal section connectors anterior area 10mm²
- transversal section connectors posterior area 12mm²

In case of teeth in the posterior area, no more than two missing pontics between two abutments.

NOTES FOR MILLING

Different milling procedures from those used for PMMA are required, because the material has different impact strength and it tends to “burn”: you need to be faster in the tool movement and then go faster (more rotations per minute).

The following processing data, speed and movement of the tool must be “adjusted” from the dental technicians according to shape and thickness of the prosthesis to be processed. Indicative data for milling:

PROCEDURE	TOOL	Ø TOOL	ROTATION SPEED RPM	FEED RATE	CUTTING DEPTH	COOLING
ROUGH CUT	1 flute	2-2,5 mm 3 mm	22000 Rpm	24mm/min	0,4 mm	Water
ROUGH CUT	1 flute	2-2,5 mm 3 mm	16000 Rpm	22mm/min	0,4 mm	Air
FINISHING	1 flute	1 mm	20000 Rpm	24mm/min	0,2 mm	Water
FINISHING	1 flute	1 mm	16000 Rpm	20mm/min	0,2 mm	Air

DISPOSAL

Wastes of Polycam can be disposed of through the domestic residual waste system.

Polycam is insoluble in water, inactive and is not hazardous to ground water.