HaHasmile Wax User Instruction

1. Application

HaHasmile wax is made for CAD/CAM fabrication of wax restorations. Applications include dental wax restorations made by CAD/CAM technology for the Press and Cast technology.

2. Product Composition

Ingredient	Approx % weight
Polythylene Waxed	99 to 100
Tiantanium Doxide	<1.0

3. Technical Parameters:

Property	Unit	Value
Melting Point	DSC	110°C - 115°C
Density	g/m ³	0.89 – 0.93
Hardness	D	45 - 55
Linear Expansion	%	0.5
Antistatic		□

HaHasmile®

4. Indications

HaHasmile wax discs are indicated for milling patterns from which custom made dental prostheses, such as crowns, bridges and dental CAD/CAM wax carving.

5. Contraindications

Keep product dust away from eyes. Not approved for use directly in mouth.
Do not inhale dust particles during grinding.

6. Storage

Sore at 10 -32℃ .
Protect from direct sunlight.
Store out of the reach of children.

7. Processing with CAD/CAM

HaHasmile wax discs can be processed in dental CAD/CAM milling systems. Only use milling tools recommended for this milling system when processing the material. The ambient working temperature should not exceed 35℃ .

8. Processing after milling
   After milling, separate the processed object from the disc using a suitable cross-cut tungsten carbide bur. Any finishing work or adjustments to the shape must be carried out using cross-cut tungsten carbide burs. The material can be enhanced using conventional modelling wax.

9. Maching Paranetes:
   Spindle speed: 18000 – 20000r/min;
   Rough machining: 0.5mm
   Finishing machining: 0.05mm

10. Notes regarding the design
    Limits:
    Posteriors: Do consider indications of materials to be done, as metal(casting); Ceramics pressing, etc.
    Minimum thickness: 1mm occlusal and cervical 0.6mm;
    Minimum diameter connection: Anteriors:3.6mm and Posterior: 4.4mm;

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