Casting Alloy, Type 4
free of palladium

7309 3 001
Casting plates
Plastic veneering
inlays, onlays, crown technique,
large span bridges
milling-, cone- and telescope technique,
model casting

Alloy: Au 72 Ag 14

<table>
<thead>
<tr>
<th>Type</th>
<th>Colour</th>
<th>Density g/cm³</th>
<th>Composition content in % (m/m)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>15.6</td>
<td>Au + Pt metals</td>
</tr>
<tr>
<td>4</td>
<td>yellow</td>
<td>75.4</td>
<td>72.0</td>
</tr>
</tbody>
</table>

The alloy is free of Ni, Co, Cr, Be, Cd.

Technical data

<table>
<thead>
<tr>
<th>Vickers hardness HV 5/30</th>
<th>0.2% proof stress MPa</th>
<th>Elongation %</th>
<th>Modulus of elasticity MPa</th>
<th>Melting Range °C</th>
<th>Preheating Temp. °C</th>
<th>Casting Temp. °C</th>
<th>Annealing °C/min.</th>
<th>Hardening °C/min.</th>
</tr>
</thead>
<tbody>
<tr>
<td>g</td>
<td>w</td>
<td>a</td>
<td>g</td>
<td>w</td>
<td>a</td>
<td>g</td>
<td>w</td>
<td>a</td>
</tr>
<tr>
<td>220</td>
<td>150</td>
<td>210</td>
<td>540</td>
<td>330</td>
<td>515</td>
<td>16</td>
<td>42</td>
<td>21</td>
</tr>
</tbody>
</table>

g = after casting, w = weak, a = hardened

Solders

<table>
<thead>
<tr>
<th>Application</th>
<th>Solder</th>
<th>Working temp. °C</th>
<th>Composition content in % (m/m) (x=0.1%)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>Au</td>
</tr>
<tr>
<td>Primary solder</td>
<td>PLATINOR® PF-Lot 1</td>
<td>850</td>
<td>74.0</td>
</tr>
<tr>
<td>Secondary solder</td>
<td>PLATINOR® PF-Lot 2</td>
<td>720</td>
<td>74.0</td>
</tr>
</tbody>
</table>

Instruction for use
Instruction for use BEDRA DENT® GL-2.6 BIO

1. Modelling
   Create an anatomically reduced wax model, considering the planned veneering. Sharp edges are to be avoided, soft level crossings are to be striven at.
   Due to stability reasons, care has to be taken at bridge frames to achieve solid modulation of the connections and in the case of larger spans to create palatal and interdental strength of the connecting parts. Wall thickness of the modelled (waxed) single crowns at least 0.4 (0.3) mm, bridge pillar crowns at least 0.5 (0.4) mm.

2. Spruing System
   Single crown: Direct spruing with casting channel at least Ø 3.5 mm
   From 2 single crowns on and bridges:
   Running bars or rings with object spruing: 3.0 x Ø 3.0 mm
   Running bars/rings: Ø 4.0 – Ø 5.0 mm
   Casting channels: Ø 3.5 – Ø 4.0 mm

3. Position of the Wax Model in the Investment Mould
   Distance from the mould wall: The units should have at least 5-10 mm distance from the mould wall.
   Distance from the mould bottom: Direct spruing between wax units and mould bottom a distance of 10 – 15 mm has to be kept.
   Investment of running bars or rings: the middle of the running bar or ring should cover the middle of the mould.

4. Investment
   Cover investment mould with investment ring spacer.
   Investment mould X1 / X3: 1 layer
   Investment mould X6 / X9: 1 – 2 layers
   Cast bonded as well as phosphate bonded investment material can be used. The investment material manufacturer’s instructions for use have to be complied with.

5. Burnout / Preheating
   Conventional heating: the first preheating step at approx. 280 °C has to be hold according to the mould size for respectively 30/40/50/60 min.; further heating steps in compliance with the investment material manufacturer’s instruction for use. After reaching the final temperature (see data sheet), the holding time is according to the mould size respectively 20/30/45/60 min.
   If handling a greater number of moulds, the preheating time has to be extended accordingly.
   Speed heating: The instructions of the manufacturer of the investment material have to be complied with strictly.

6. Crucible Material
   Graphite and ceramic crucibles can be used.

7. Casting Units
   All common melting and casting units can be used.

8. Casting
   Check data sheet for casting temperatures.
   Further heating times after reaching the liquidus temperature according to the quantity of material used and unit output.
   Resistance heating: 20 – 60 sec.
   High frequency: 5 – 10 sec.
   Propane / Oxygen torch: 5 – 10 sec.
   In the case of torch melting, pay attention to the correct setting of the torch (danger of carbon damage) and melt with the reduced zone.

9. Casting Residues
   In order to preserve the alloy characteristics and the casting quality, no more than 50 % cleaned casting residues should be used.
   The weight used is calculated from: wax weight x alloy density (see Heimerle + Meule calculation sheet).

10. Cooling and Divestment
    Let mould cool down to hand temperature and carefully divest.
    This avoids deviations in fitting, change of alloy characteristics, and hot fissures. Sandblast with high grade corundum (approx. 100 μm) or with an market pickling agent to remove the investment material.

11. Finishing and Cleaning
    Finish frame with tungsten carbide burs and ceramic bonded milling tools with only little pressure; then sandblast surface with alumminum oxide (approx. 100 μm) at low pressure (max. 0.2 bar), then polish it. Polishing residues must be completely removed, e.g. steamclean and degrease it with a suitable pickling agent (e.g. AMISUL). During grinding sufficient protection against dust inhalation has to be taken

12. Soldering
    Soldering areas have to be sufficiently big and should be considered during modulation already.
    Soldering areas have to be metalically blank.
    The solder gap should be 0.05 – 0.2 mm.
    Recommended soldering:
    Primary solder: PLATINOR® PF-Lot 1 850 °C
    Secondary solder: PLATINOR® PF-Lot 2 720 °C
    Slowly cool down the soldering object.

13. Hardening
    After casting the alloy shows a sufficiently high density for its area of indication. If required, the maximum hardening can be reached through final tempering in accordance to the data sheet.

14. Pickling
    Remove flux residues or oxides by pickling in AMISUL at about 80 °C or by sandblasting. Then flush the object with water.

15. Veneering with plastic
    For the veneering with plastic please observe the instructions of the manufacturer of the plastic.

16. Polishing
    Final polishing can be effected with pastes, brushes, buffing wheels and felt.

Our recommendations and instructions for use are based on our experience. They do not, however, replace professional knowledge and experience of dentists an dental technicians who hold sole responsibility for their decisions to select and process particular alloys. Our customer service is a non mandatory service not establishing any liability. Warranty and damage claims are limited to the contracted contents of our General Terms and Condition.