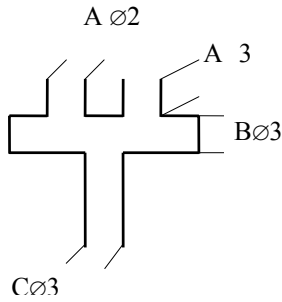


INSTRUCTIONS FOR USE C&B ALLOYS

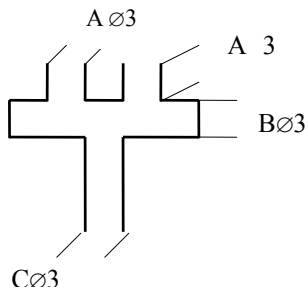
Spruing :

A valid example or standard diagram is as follows:



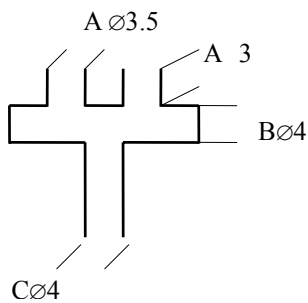
A length 3mm, diameter 2mm.
B diameter 3mm.
C diameter 3mm.

gold - resin (high count)



A length 3mm, diameter 3mm.
B diameter 3mm.
C diameter 3mm.

Alloys with medium Pd content (medium count)



A length 3mm, diameter 3.5mm.
B diameter 4mm.
C diameter 4mm.

Alloys with high Pd content (low count)

Do not position the model in the centre of the furnace. Recommended minimum model thickness 0.4 mm.

Investment* :

Use a C & B* investment, follow the Manufacturer's instructions. A final preheating temperature is recommended (see indications in the Nobil Metal Spa Alloys & Solders table and/or the manufacturer's instructions) for 20-40* minutes, according to the size and number of cylinders.

INSTRUCTIONS FOR USE C&B ALLOYS

Crucible : see Nobil Metal Spa Alloys & Solders table and/or the safety data card available.

Casting :

It's possible to use the various casting techniques known, always adding at least 50% of a new alloy. When casting with a torch, use the neutral area (reducing) of the oxygen-propane flame; the alloy is ready to cast when the ingots pool and roll. Follow the same procedure when casting with an electrical or induction centrifuge.

Casting temperature*: see Alloys & Solders table and/or the Manufacturer's instructions.
Leave to cool at room temperature.

Finishing:

Use usual abrasive instruments.

Hardening: see the Nobil Metal Spa Alloys & Solders table and/or the Manufacturer's instructions.
Allow to cool at room temperature.

Softening: see the Nobil Metal Spa Alloys & Solders table and/or the Manufacturer's instructions.
Allow to cool in water.

Pickling :

The elements can be pickled by immersing them in a Nobil Metal ECOX solution, pickling salts (can be neutralised using the Nobil Metal NEUTROX product).

Soldering :

For each alloy, Nobil Metal has predisposed a primary and secondary soldering, taking into account the casting interval and the electrum-chemical features.

** All above mentioned data relevant to temperature and execution time are to be considered as approximate.*

Each alloy has an individual property and data, the user is therefore requested to refer to the data indicated in the Nobil Metal Spa Alloys & Solders table and/or the Manufacturer's instructions.