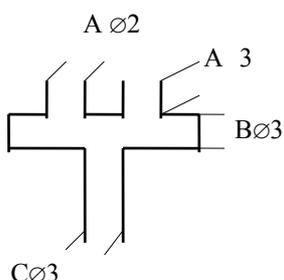


INSTRUCTIONS FOR USE

PFM ALLOYS

Spruing :

A valid example or standard diagram is as follows:

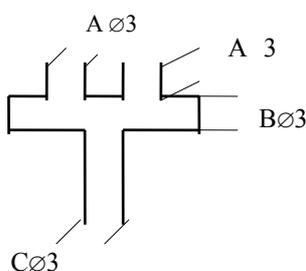


A length 3mm, diameter 2mm.

B diameter 3mm.

C diameter 3mm.

gold-porcelain (high count)

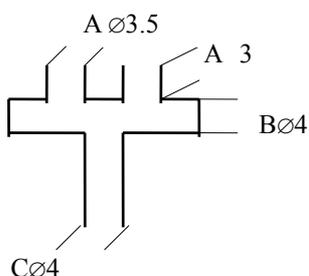


A length 3mm, diameter 3mm.

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 phosphatic investment for PFM alloys, 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 30-60* minutes, according to the size and number of cylinders.

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

INSTRUCTIONS FOR USE

PFM ALLOYS

Casting :

It's possible to use the various casting techniques known, always adding at least 50% of a new alloy. The use of ceramic crucibles is recommended without the use of flux. 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.

Homogenising (heat treatment) :

Free the item from investment, cut the sprues and carry out a cycle in a porcelain furnace with the starting temperature of the porcelain, the rate of rise of the dentine, the stabilisation temperature is that of the oxidation for 10 minutes.

The entire cycle must be carried out in vacuum.

Finishing and cleaning: Use rotating tungsten instruments for the first polishing and finish off by using mounted tips specifically for precious alloys.

Sandblast the metal with new -not recycled- aluminium oxide (50 microns). Clean using jets of steam or ultrasounds for 10 minutes.

Oxidisation * :

Carry out a cycle in a porcelain furnace using the starting temperature of the porcelain, the rate of rise of the dentine, the stabilisation temperature and stay time are indicated in the Alloys & Solders table and/or the Manufacturer's instructions.

The entire cycle must be carried out in atmosphere.

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).

Opaque : Follow the manufacturer's instructions for use of the dental porcelain used.

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.