



BOCAST N

TYPE III

YELLOW - CASTING - 40% GOLD PLUS PALLADIUM

Ag=40%, Pd=20%, Au=20%, In=18%, Zn=2%

- A very economical yellow casting alloy - attractive gold colour
- Meets NHS 33.3% minimum precious alloy specification
- Good resistance to oral tarnish/corrosion

Properties:

MELTING RANGE	865 - 940°C. Cast at 1040°C
DENSITY	10.9g/cm ³
HARDNESS	Softened 145 HV2.5 - Hardened 205 HV2.5
0.2%PROOF STRESS	Softened 248 MPa - Hardened 350 MPa
ELONGATION	Softened 14% - Hardened 12%

Working Procedure:

SPRUES

Use the indirect sprue technique
(3mm on crowns, 3.5mm on pontics, cross beams 4 - 4.5mm for bridges).

INVESTMENT

Use phosphate or gypsum bonded.

PRE-HEATING

630°C for 30 - 120 minutes dependent on the flask or cylinder size.

CASTING

Casting temperature is 1040°C.

FINISHING

Air blast with aluminium oxide, or pickle, and then polish.

SOLDERING

Charles Booth 720°C yellow.

SOFTENING/ANNEALING

Fire at 700°C for 10 minutes and then quench immediately in water.

HARDENING

After softening reheat the alloy for 30 minutes at 350°C and allow to bench cool.

PRODUCED TO NHS/MDD REQUIREMENTS AND COMPLIES WITH ISO 9693:2000