



BOCRAFT S

SOFT

YELLOW - BONDING - 99.7% GOLD

Au=99.7%, Others=0.3%

- A soft speciality deep yellow bonding alloy, suitable for single crowns
- Especially suitable where there is high oral sensitivity or corrosion potential for gold crowns

Properties:

MELTING RANGE	1035 - 1055°C. Cast at 1155°C
DENSITY	19.2 g/cm ³
HARDNESS	35 HV2.5 - After porcelain firing
MODULUS OF ELASTICITY	79 GPa - After porcelain firing
0.2%PROOF STRESS	49 MPa - After porcelain firing
ELONGATION	60% - After porcelain firing
THERMAL EXPANSION COEFFICIENT	15.4µm/m/°K (20 - 500°C)

Working Procedure:

PRE-HEATING AND INVESTMENT

Use only high quality phosphate bonded investment. Pre-heat at 800°C for 30 - 120 minutes according to cylinder size, usually around 45 minutes.

CASTING

Casting temperature is 1155°C.

FINISHING & CLEANING

Use only aluminium oxide stones, carbide burrs or ceramic bonded stones, then boil in distilled water or use ultrasonic with distilled water for at least 5 minutes.

DEGASSING AND OXIDATION

If vacuum degassing is used - not essential - hold the unit at 960°C for 3 minutes prior to oxidising. As a rule, oxidise for 2 minutes in air at the same firing temperature that is to be used for the first layer of opaque, usually 960°C. The oxidation layer is usually beige in colour and even over the surface of the restoration. If patchy, then air blast the oxide away and re-oxidise.

PORCELAIN - MOST IMPORTANT

This alloy must be porcelainised. Each porcelain firing must have a slow cool; Hold at 850°C for 5 minutes, then slowly lower the platform. This ensures that the expansion differences between the metal and porcelain do not cause cracking during cooling. Cracking in the porcelain may occur through thermal expansion differences if you do not follow this procedure.

SOLDERING

Charles Booth 720°C yellow. Use a low aggressive flux when soldering to ensure no etching of existing porcelain.

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