



# BODENT 60

## TYPE IV

### YELLOW - CASTING - 60% GOLD

Ag=17%, Cu=19%, Pd=3%, Au=60%, Others=1%

- Superb yellow colour and excellent tarnish resistance
- The technicians choice for superbly finished yellow crowns and bridges

## Properties:

<b>MELTING RANGE</b>	850 - 880°C. Cast at 980°C
<b>DENSITY</b>	13.6g/cm <sup>3</sup>
<b>HARDNESS</b>	Softened 175 HV2.5 - Hardened 280 HV2.5
<b>0.2%PROOF STRESS</b>	Softened 353 MPa - Hardened 730 MPa
<b>ELONGATION</b>	Softened 30% - Hardened 6%

## 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

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

### CASTING

Casting temperature is 980°C.

### FINISHING

Air blast with aluminium oxide.

### SOLDERING

Charles Booth 720°C yellow.

### RECASTING

Make sure all recycled metal is completely clean by air blasting, brushing or pickling.

### 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**