



BODENT 75

TYPE IV

YELLOW - CASTING - 71% GOLD

Ag=12%, Cu=12%, Au=71%, Pt=4%, Others=1%

- Top-of-the-range alloy with a superb yellow colour and excellent tarnish resistance
- The technicians choice for superbly finished yellow crowns and bridges

Properties:

MELTING RANGE	870 - 920°C. Cast at 1020°C
DENSITY	15.4 g/cm ³
HARDNESS	Softened 165 HV2.5 - Hardened 255 HV2.5
0.2%PROOF STRESS	Softened 350 MPa - Hardened 520 MPa
ELONGATION	Softened 55% - Hardened 17%

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 650°C for 30 - 120 minutes dependent on the flask or cylinder size. Usually about 45 mins.

CASTING

Casting temperature is 1020°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 to 325°C for 30 minutes and allow to bench cool.

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