



BODENT P

TYPE IV

WHITE - CASTING - 33.34% PALLADIUM

Ag=46.66%, Pd=33.34%, Cu=19%, Others=1%

- Excellent economic white crown and bridge alloy
- Super finishing and polishing performance
- Ideal for posts and full crowns

Properties:

MELTING RANGE	1000 - 1035°C. Cast at 1140°C
DENSITY	10.6g/cm ³
HARDNESS	Softened 180 HV2.5 - Hardened 285 HV2.5
0.2% PROOF STRESS	Softened 480 MPa - Hardened 780 MPa
ELONGATION	Softened 15% - Hardened 3%

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.

FLASK PRE-HEATING

650°C for 30 - 120 minutes dependent on the flask size.

CASTING

Casting temperature is 1140°C.

FINISHING

Air blast with aluminium oxide.

SOLDERING

Charles Booth 750°C white.

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