



BOPAL

TYPE IV

WHITE - CASTING - PALLADIUM + 3.3% GOLD

Ag=46.7%, Pd=30.0%, Cu=19%, Au=3.3%, Others=1%

- The 3.3% gold content gives a very attractive lustre
- Superb finishing and polishing performance
- Ideal for posts and full crowns

Properties:

| | |
|-------------------------|---|
| MELTING RANGE | 970 - 1080°C. Cast at 1180°C |
| DENSITY | 10.7g/cm ³ |
| HARDNESS | Softened 178 HV2.5 - Hardened 290 HV2.5 |
| 0.2%PROOF STRESS | Softened 380 MPa - Hardened 760 MPa |
| ELONGATION | Softened 30% - 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 1180°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