

EN	INSTRUCTIONS FOR USE	EN	Gebrauchsinformation	DE	Mode d'emploi	FR	Istruzioni d'uso	IT	Instrucciones de uso	ES	Instruções de Uso	PT	Bruksanvisning	SV	Brugsanvisning	DA	Käyttöohjeet	FI
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1) PRODUCT DESCRIPTION
Au-based dental metal-ceramic alloy, Type 4

2) INDICATIONS*
Inlays, Onlays, 3/4 Crowns, Crowns, Telescopic Crowns, Conus Crowns, Bridges, Wide Bridges, Cast Posts / Cores, Splints, Orthodontic retainers, Adhesive-retained Superstructures, Partial Dentures

3) FIXING/MODELLATION
Design the framework in a reduced anatomical shape taking the planned veneer into consideration. Single crowns require a minimum thickness of 0.3 mm. Abutment crowns require a minimum thickness of 0.5 mm. Circumferential design provides adequate support for the veneering material. Avoid sharp angles. Connectors must have the required dimensions to provide resistance to deformation. Create large surface areas for planned soldering, with a gap of 0.05–0.2 mm.

4) FINISHING
Provide the modeled single-tooth restoration or bridge framework with sprues of a suitable size. In general the reservoir, sprue leads, and connector sprues, whether pair shaped or traditional, must be sized according to the model. The casting design must be made using the direct or indirect technique to be sure that the reservoir is positioned in the heat center. The connector sprues between the reservoir and the casting should be a maximum of 2.5–3.0 mm in length and width. The wax pattern including the sprues must be weighed in grams in order to determine the needed amount of alloy. Wax conversion formula: wax weight (gram) × alloy density = grams of alloy required

5) INVESTING
Use a phosphate-bonded investment material. Follow the manufacturer's instructions.

6) PREHEATING / BURN-OUT
Recommended burn-out temperature: 800 °C

7) MELTING AND CASTING
Torch: Propane 0.35 bar, Oxygen 0.7 bar
Other specifics may be required by the type of casting machine. It is recommended to use a separate and separate clean burner. Do not use the same burner for the investment and the burn-out furnace. The recommended ratio of used material to new material is 1:1. Do not use flux.

8) CASTING TEMPERATURE: 1300 °C

9) FRAMEWORK FINISHING
After bench cooling, the casted framework must be cleaned and clean the casting with aluminum oxide (Al₂O₃). Do not use a hammer for divesting. Finish the casting with carbide burrs and/or with ceramic-bonded grinding instruments. Blast the surface with 50–110 micron aluminum oxide (Al₂O₃) at 2.0 bar. Subsequently, steam clean and ultrasonic clean with distilled water or ethanol and dry the framework.

10) OXIDATION
Place the framework on the firing tray providing adequate support. To achieve a uniform result follow the oxidation cycle.

Temperature: 930 °C, **Holding time:** 5 min; **Vacuum:** No
If the oxide layer is stained, grind and blast the surface again. Repeat the oxide firing. In the case of Zn containing alloy, the addition of sulphating the oxide layer in 10% sulfuric acid or similar pickling solution is recommended. Note: Always observe proper safety procedures when handling acid. Before equate application Clean framework carefully with water. Use the appropriate ceramic veneering material, following the manufacturer's instructions.

Highest recommended firing temperature: 950 °C

11) HEAT TREATMENT
Hardening: 450 °C for 15 min; bench cool

12) SOLDERING AND LASER WELDING
The soldering gap should not be wider than the thickness of the soldering material. Allow the soldered casting into the furnace without disturbance.

Pre Solder: BioPorta Lot W-2
Post Solder: BioPorta OP Lot W-2
Flux: Bondal Flux
Flux: High Fusing Bondal Flux
Flux: Bondal Flux

13) POLISHING
Carefully remove any oxide and flux residue. Smooth the metal surfaces with rubber polishers. Polish to a high gloss finish using polishing paste. Subsequently, clean using ultrasonic cleaning equipment or careful steam cleaning.

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1) PRODUKTBESKRIVNING
Au-baseret dental metal-ceramik-legering, Typ 4

2) INDIKATIONER*
Inlays, Onlays, 3/4 kroner, kroner, teleskopykroner, kronkrøner, broer, vejspännige broer, vortelstøtter, ortodontiske rettskæder, implantatrettskæder, proteser

3) WACHSMODELLATION
Design the framework in a reduced anatomical form unter Berücksichtigung der geplanten Verklebung. Die Krone erfordert eine geringste Dickenstärke von 0,3 mm. Abstützkronen erfordern eine Dickenstärke von mindestens 0,5 mm. Eine kreisförmige Gestaltung bietet ausreichende Unterstützung für das Verklebmaterial. Vermeiden Sie scharfe Winkel. Die Verbindungsfugen müssen die notwendigen Dimensionen aufweisen, um Widerstand gegen Verformung zu gewährleisten. Erstellen Sie große Oberflächen für die geplante Lötung, wobei ein Spalt von 0,05–0,2 mm.

4) ANSTIFTEN DER GUSSKANÄLE
Entwerfen Sie den modellierten Einzelzahnrestaurations- oder Brückengerüst mit ausreichenden dimensionierten Gusskanälen versehen. Grundätzlich sollte die Größe des Reservoirs, der Gusskanäle und der Verbindungskanäle bündigformig oder traditionell geformt sein und der angewendeten Technik entsprechen. Bei Anwendung der direkten oder indirekten Anstiftmethode muss die Reservoirgröße sowie die Größe der Verbindungsstäbe zwischen dem Reservoir und der Gusskanäle so bemessen werden, dass die Verbindungsfuge genügend Dimensionierung aufweist, um Widerstand gegen Verformung zu gewährleisten. Erstellen Sie große Oberflächen für die geplante Lötung, wobei ein Spalt von 0,05–0,2 mm.

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15) INVESTING
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16) PREHEATING / BURN-OUT
Recommended burn-out temperature: 800 °C

17) MELTING AND CASTING
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Highest recommended firing temperature: 950 °C

21) HEAT TREATMENT
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22) SOLDERING AND LASER WELDING
The soldering gap should not be wider than the thickness of the soldering material. Allow the soldered casting into the furnace without disturbance.

Pre Solder: BioPorta Lot W-2
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Flux: Bondal Flux
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1) DESCRIZIONE PRODOTTO
Liga dentaria per metallo-ceramica a base di Au, Tipo 4

2) INDICAZIONI*
Inlays, Onlays, Corone a 3/4, Corone, Corone telescopiche, Corone coniche, Ponti, Ponti estetici, Reticoli parziali/ Parziali, Armeggi, Barre, Adattamenti, Superstrutture impianti/portadenti, Denture parziali.

3) MODELLOZIONE IN CERA
Modellare la struttura in forma anatomica riducida tenendo in considerazione il rivestimento estetico previsto. Le lamiere di Corone unitarie esigono spessore minima di 0,3 mm. Le Corone-pilare richiedono un spessore minimo di 0,5 mm. Certificare se e come il design della infrastruttura fornisce adeguato supporto per il materiale di rivestimento. Evitare angoli acuti. I connessori devono avere le dimensioni necessarie per proporcionar resistenza al deformazione. Creare grandi superfici per la saldatura pianificata, con una separazione di 0,5–0,2 mm.

4) IMPIERNTURA DEI CANALI DI COLATA
Dotare il restauro del dettato singolo modello o della struttura del ponte con canali di colata di forma adeguata. In genere le dimensioni dei canali di colata e dei canali di fusione, che siano a forma di T o di forma U, devono essere della stessa dimensione, corrispondenti alla tecnica utilizzata. Utilizzando il metodo di temperatura diretta o indiretto, accertarsi che il serbatoio venga posizionato nel centro termico del cilindro. I canali di colata e i connessori devono essere dimensionati in base alla lunghezza e al diametro massimo di 2,5–3,0 mm. Occorre pesare la modellazione in cera comprendente i canali di fusione per determinare la quantità di lega necessaria. Tabella di conversione: Peso in cera (in grammi) × densità della lega = quantità di lega necessaria in grammi.

5) MESSA IN RIVESTIMENTO
Utilizzare una massa da rivestimento aglutinato a legante fosfato. Attenerci alle istruzioni del produttore.

6) REVESTIR
Usar un material de revestimento aglutinado con fosfato. Sigue el manual del fabricante.

7) PRECALZAMENTO / QUEMA
Temperatura de aquecimento sugerida: 800 °C

8) FUNDICIÓN
Llama: Propano 0.35 bar, Oxígeno 0.7 bar
Outras especificações podem ser necessárias. É necessário usar um cadinho limpo e separado, de grafite/cerâmica, para cada liga. Pré-aquecer o cadinho de cerâmica no forno de aquecimento gradiente/keramicko/vácuo em temperatura recomendada na mistura de materiais usados e novos e: 1:1. Não usar flux.

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Outras especificações podem ser necessárias. É necessário usar um cadinho limpo e separado, de grafite/cerâmica, para cada liga. Pré-aquecer o cadinho de cerâmica no forno de aquecimento gradiente/keramicko/vácuo em temperatura recomendada na mistura de materiais usados e novos e: 1:1. Não usar flux.

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Llama: Propano 0.35 bar, Oxígeno 0.7 bar
Outras especificações podem ser necessárias. É necessário usar um cadinho limpo e separado, de grafite/cerâmica, para cada liga. Pré-aquecer o cadinho de cerâmica no forno de aquecimento gradiente/keramicko/vácuo em temperatura recomendada na mistura de materiais usados e novos e: 1:1. Não usar flux.

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Llama: Propano 0.35 bar, Oxígeno 0.7 bar
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15) INVESTING
Use a phosphate-bonded investment material. Follow the manufacturer's instructions.

16) PREHEATING / BURN-OUT
Recommended burn-out temperature: 800 °C

17) MELTING AND CASTING
Torch: Propane 0.35 bar, Oxygen 0.7 bar
Other specifics may be required by the type of casting machine. It is recommended to use a separate and separate clean burner. Do not use the same burner for the investment and the burn-out furnace. The recommended ratio of used material to new material is 1:1. Do not use flux.

18) CASTING TEMPERATURE: 1300 °C

19) FRAMEWORK FINISHING
After bench cooling, the casted framework must be cleaned and clean the casting with aluminum oxide (Al₂O₃). Do not use a hammer for divesting. Finish the casting with carbide burrs and/or with ceramic-bonded grinding instruments. Blast the surface with 50–110 micron aluminum oxide (Al₂O₃) at 2.0 bar. Subsequently, steam clean and ultrasonic clean with distilled water or ethanol and dry the framework.

20) OXIDATION
Place the framework on the firing tray providing adequate support. To achieve a uniform result follow the oxidation cycle.

Temperature: 930 °C, **Holding time:** 5 min; **Vacuum:** No
If the oxide layer is stained, grind and blast the surface again. Repeat the oxide firing. In the case of Zn containing alloy, the addition of sulphating the oxide layer in 10% sulfuric acid or similar pickling solution is recommended. Note: Always observe proper safety procedures when handling acid. Before equate application Clean framework carefully with water. Use the appropriate ceramic veneering material, following the manufacturer's instructions.

Highest recommended firing temperature: 950 °C

21) HEAT TREATMENT
Hardening: 450 °C for 15 min; bench cool

22) SOLDERING AND LASER WELDING
The soldering gap should not be wider than the thickness of the soldering material. Allow the soldered casting into the furnace without disturbance.

Pre Solder: BioPorta Lot W-2
Post Solder: BioPorta OP Lot W-2
Flux: Bondal Flux
Flux: High Fusing Bondal Flux
Flux: Bondal Flux

23) POLISHING
Carefully remove any oxide and flux residue. Smooth the metal surfaces with rubber polishers. Polish to a high gloss finish using polishing paste. Subsequently, clean using ultrasonic cleaning equipment or careful steam cleaning.

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1) DESCRIZIONE PRODOTTO
Liga dentaria per metallo-ceramica a base di Au, Tipo 4

2) INDICAZIONI*
Inlays, Onlays, Corone a 3/4, Corone, Corone telescopiche, Corone coniche, Ponti, Ponti estetici, Reticoli parziali/ Parziali, Armeggi, Barre, Adattamenti, Superstrutture impianti/portadenti, Denture parziali.

3) MODELLOZIONE IN CERA
Modellare la struttura in forma anatomica riducida tenendo in considerazione il rivestimento estetico previsto. Le lamiere di Corone unitarie esigono spessore minima di 0,3 mm. Le Corone-pilare richiedono un spessore minimo di 0,5 mm. Certificare se e come il design della infrastruttura fornisce adeguato supporto per il materiale di rivestimento. Evitare angoli acuti. I connessori devono avere le dimensioni necessarie per proporcionar resistenza al deformazione. Creare grandi superfici per la saldatura pianificata, con una separazione di 0,5–0,2 mm.

4) IMPIERNTURA DEI CANALI DI COLATA
Dotare il restauro del dettato singolo modello o della struttura del ponte con canali di colata di forma adeguata. In genere le dimensioni dei canali di colata e dei canali di fusione, che siano a forma di T o di forma U, devono essere della stessa dimensione, corrispondenti alla tecnica utilizzata. Utilizzando il metodo di temperatura diretta o indiretto, accertarsi che il serbatoio venga posizionato nel centro termico del cilindro. I canali di colata e i connessori devono essere dimensionati in base alla lunghezza e al diametro massimo di 2,5–3,0 mm. Occorre pesare la modellazione in cera comprendente i canali di fusione per determinare la quantità di lega necessaria. Tabella di conversione: Peso in cera (in grammi) × densità della lega = quantità di lega necessaria in grammi.

5) MESSA IN RIVESTIMENTO
Utilizzare una massa da rivestimento aglutinato a legante fosfato. Attenerci alle istruzioni del produttore.

6) REVESTIR
Usar un material de revestimento aglutinado con fosfato. Sigue el manual del fabricante.

7) PRECALZAMENTO / QUEMA
Temperatura de aquecimento sugerida: 800 °C

8) FUNDICIÓN
Llama: Pro

