



Indications
Inlays, Onlays, 3/4 Crowns, Crowns

Au	77.2	<1.0	Pt	Pd	12.7	8.5	Cu	5.8	Sn	2.8	Zn	1.0	In	0.6	Fe	1.0	Other	<1.0
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Composition
Weigh the wax pattern including the sprue to determine the quantity of the alloy to be used. (See wax conversion sheet/formula: weight x density = gr. of alloy). Use investment following the manufacturer's instruction.

BURN-OUT
The suggested burnout temperature:
High heat temperature investment: 650-760C/1200-1400F
Low heat temperature investment: 480-540C/900-1000F

MELTING AND CASTING
Use a separate carbon/ceramic crucible for each alloy. Used and new alloy must be in a ratio of 1:1. Depending on the type of casting machine, follow the manufacturers instructions for use. Ideally a compressed air and natural gas torch should be used to melt C&B alloys because propane and oxygen is much too hot and can easily overheat these alloys. If you are using propane and oxygen the pressure should be a 0.15 bar/2 psi for propane and 0.35 bar/5 psi for oxygen. Keep the alloy in the reducing atmosphere of the flame between the inner and outer cones. Use casting flux if needed. After casting bench cool to room temperature.

CASTING TEMPERATURE: 1035-1095C/1895-2000F
METAL PREPARATION
Carefully divest and clean the object with Al₂O₃ glass beads, or a pickling agent (such as Prevox®). Do not use a hammer for divesting the object to prevent deformation. Finish the framework with carbide burs or with ceramic-bonded grinding instruments. Avoid inhalation of dust during grinding!

HEAT TREATMENT
Annealing: 705C/1300F for 30 minutes; quench immediately (water)
Hardening: 260C/500F for 30 minutes; air cool.

SOLDERS AND FLUXES
Design the soldering patty as small as possible and preheat it in the furnace at approximately 600C/1112F. The soldering gap should be the same thickness as the soldering strip. Allow the object to cool slowly after soldering.
Solder: Universal Solder PKF, 650, 615, 585 Fine Solder
Flux: Bondal Flux
Laser weld material: Laser C&B Yellow

POLISHING
After soldering or heat treatment, remove oxide and flux residue and finish and polish the framework with rubber finishers and polishers.

INDICATIONS
Inlays, onlays, 3/4 crowns, crowns
CONTRAINDICATIONS
For patients with known allergy/sensitivity to any major or minor constituents of this alloy, consultation with a physician is recommended.

SIDE EFFECTS
In individual cases, sensitivity or allergies to components of this alloy may occur.
INTERACTIONS
Galvanic effects may occur between different alloys in the same oral environment.
For additional information look into the alloy property chart.

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INSTRUCTIONS FOR USE

MODELLATION
Wax to full contour for crown and bridge frame design. For composite, build up the framework in a reduced anatomic shape taking the planned veneer into consideration. Single crowns require a thickness of minimum 0.3 mm; abutment crowns thickness a minimum of 0.5 mm. Make sure the framework demonstrates adequate stability of shape. Avoid sharp angles. Design the connector areas to be adequate for the position and alloy being used. If a composite or resin veneer is required, mechanical retention is recommended.

SPRUNG
Provide the modeled bridge framework or coping with sprues of a suitable size. Use the direct or indirect technique being sure that the reservoir is positioned in the heat center. The connection sprues between the reservoir and the coping should be 2.5-3.0 mm in length and width.

INVESTMENT
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ISTRUZIONI D'USO

MODELLAZIONE IN CERA
Modellare la protesi completamente in cera. Configurare la struttura per i rivestimenti in composito in forma anatomica ridotta tenendo presente il tipo di rivestimento previsto. Lo spessore minimo delle corone singole deve essere di 0,3 mm, per le corone su peri 0,5 mm. Fare attenzione che la struttura sia sufficientemente stabile. Evitare cuspidi accentuate nei punti di collegamento. Porre particolare attenzione alla forma degli spazi interdentali al fine di poter garantire un'igiene orale accurata degli stessi nonché della lega utilizzata. Per rivestimenti estetici in composito, modellare la struttura in forma anatomica ridotta ed applicare ritenzioni meccaniche.

PREPARAZIONE DEI CANALI DI FUSIONE
Fare in modo che i canali di fusione della corona o della struttura del ponte modellati in cera abbiano dimensioni sufficienti, sia nel metodo diretto che indiretto. Posizionare il serbatoio nel punto centrale di calore della muffola. I canali di collegamento tra serbatoio e oggetto della fusione devono avere una lunghezza e un diametro tra 2,5 e 3,0 mm.

INSERIMENTO NELLA MASSA DI RIVESTIMENTO
Pesare l'oggetto in cera compresi i canali di fusione per determinare la quantità di lega necessaria (v. tabella di conversione per la cera: peso cera x densità = quantità di lega in g). Utilizzare il materiale per rivestimento secondo le istruzioni del produttore.

PRERISCALDO
Le temperature di preriscaldamento consigliate:
Rivestimenti per alte temperature nel campo di: 650-760C/1200-1400F
Rivestimenti per basse temperature nel campo di: 480-540C/900-1000F

FUSIONE E COLATA
Impiegare un crogiolo in grafite/ceramica separatamente per ogni lega. Le leghe nuove e le matorozze si dovrebbero utilizzare in un rapporto di 1:1. A seconda dell'apparecchio di fusione osservare le indicazioni del produttore. Per la fusione delle leghe C&B si presta meglio un canello per gas metano/aria compressa visto che il propano e l'ossigeno producono troppo calore e la lega può essere facilmente surriscaldata. Nell'uso di propano/ossigeno regolare la pressione per il propano a 0,15 bar/2 psi e per l'ossigeno a 0,35 bar/5 psi. Liquefare la lega con la parte della fiamma riduce (tra il cono interno ed esterno della fiamma). Utilizzare il flux a secondo la necessità Dopo la fusione lasciare raffreddare la muffola a temperatura ambiente.

Temperatura di fusione: 1035-1095C/1895-2000F
LAVORAZIONE
Togliere con cautela l'oggetto della fusione dalla massa di rivestimento e pulirlo. Per la sabbiatura impiegare Al₂O₃ o perle di vetro. Non togliere l'oggetto fuso dalla massa di rivestimento avvalendosi del martello perché c'è il rischio di deformazione. Rifornire l'oggetto fuso e lucidarlo. Evitare l'inalazione di polvere di rifinitura!

Temperatura di fusione: 1035-1095C/1895-2000F
Temperatura di fusione: 1035-1095C/1895-2000F

RICOTTURA: a 705C/1300F per 30 minuti; quindi raffreddamento rapido (acqua)
Tempera: a 260C/500F per 30 minuti; Lasciar raffreddare in ambiente.

SALDATURA
Dare una forma possibilmente piccola al blocco di brasatura e preriscaldare in forno a ca. 600C/1112F. La fessura tra gli oggetti da collegare deve essere inferiore al diametro del materiale di apporto impiegato per la brasatura. Dopo la brasatura lasciar raffreddare l'oggetto lentamente.
Leghe brasante: Universal Solder PKF, 650, 615, 585 Fine Solder
Fondente: Bondal Flux
Filo per la saldatura al laser: Laser C&B Yellow

LUCIDATURA
Dopo la brasatura o l'invecchiamento, rimuovere i residui di ossidi e di fondente e rifinire la struttura con gommini per la rifinitura e lucidatura.

INDICAZIONI
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CONTRAINDICAZIONI
Nel caso di allergia o sensibilità nota a uno dei componenti si dovrebbe consultare un medico.
EFFETTI COLLATERALI
In casi isolati può insorgere sensibilità o allergia ai componenti di questa lega.

INTERAZIONE
Diversi tipi di lega nel medesimo cavo orale possono generare reazioni galvaniche.
Per ulteriori dati su questa lega consultare la tabella delle leghe.

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GEBRAUCHSINFORMATION

WACHSMODELLATION
Restauration vollständig in Wachs modellieren. Gerüst für Komposit-Verblendungen in verkleinerter anatomischer Form unter Berücksichtigung der geplanten Verblendung gestalten. Die Wandstärke bei Einzelkronen soll mindestens 0,3 mm, bei Pfeilerkronen mindestens 0,5 mm betragen. Auf ausreichende Formstabilität des Gerü

NL PRODUCTINFORMATIE

WASMODELLATIE

Modeller de restauratie volledig in was. Maak voor composiet-verblijndtoepassingen een onderstructuur die iets kleiner is dan de noodzakelijke anatische vorm. Dit in verband met de toepassing van de geplande verblijndtechniek. De wanddikte moet bij solitaire kronen ten minste 0,3 mm bedragen en bij pijlerkronen minimaal 0,5 mm. Let er op dat de onderstructuur in voldoende mate vormstabiel is. Vermijd scherpe overgangen. Maak de verbindingsszones tussen de verschillende elementen zo stabiel dat ze voldoende aan de bestaande eisen voor interdentale hygiëne en de gebruikte legering. Breng op de onderstructuur mechanische retenties aan.

PLAATSEN VAN GIETKANALEN

Voorzie de in was gemodelleerde kroon- of brugstructuur van gietkanalen die voldoende groot zijn voor zowel de directe als de indirecte methode. Zorg dat het reservoir zich in het hittecentrum van de mofel bevindt. De verbindingsskanalen tussen het reservoir en het gietobject moeten een lengte resp. een doorsnee van 2,5 à 3,0 mm hebben.

INBEDDEN

Weeg het wasobject inclusief de gietkanalen om de benodigde hoeveelheid legering te kunnen bepalen. (Zie daartoe de wasomrekeningstabel: wasgewicht x dichtheid = hoeveelheid legering in g). Let bij gebruik van de inbedmassa op de aanwijzingen van de fabrikant.

UITBRANDEN

Aanbevolen uitbrandtemperatuur:

Inbedmassa's voor hoge temperatuurgebieden: 650-760C/1200-1400F

Inbedmassa's voor lage temperatuurgebieden: 480-540C/900-1000F

SMELTEN EN GIETEN

Gebruik voor iedere legering een aparte grafietkroes / keramiekkroes. De oude en nieuwe legering moeten in een verhouding van 1:1 worden gebruikt. Let bij gebruik van het gietapparaat op de aanwijzingen van de fabrikant. Het best kan voor het smelten van C&B-legeringen gebruik worden gemaakt van een brander die werkt met perslucht en aardgas. Een propanaan/zuurstofbrander genereert te veel hitte, waardoor de legering gemakkelijk oververhit kan raken. Stel de druk bij gebruik van een propanaan/zuurstofbrander bij propanaan op 0,15 bar/ 2 psi en bij zuurstof op 0,35 bar/5 psi in. Smelt de legering met het zuurstofarme gedeelte van de vlam. Dit gedeelte bevindt zich tussen de binnenste en de buitenste vlamkegel. Laat de mofel na het gieten tot kamertemperatuur afkoelen.

Giettemperatuur: 1035-1095C/1895-2000F

BEWERKEN

Bed het gietobject voorzichtig uit een reinig het met behulp van Al₂O₃ of glasparels. Gebruik bij het uitbedden van het gietobject geen hamer teneinde vervorming van het object te voorkomen. Bewerk een polijst vervolgens het object. Voorkom inademing van stof tijdens het slippen!

WARTMEBEHANDELING

Zachtgieten: 30 minuten bij 705C/1300F; vervolgens onmiddellijk afschrikken (met water)

Gehard in oven: 30 minuten bij 260C/500F; laten afkoelen.

SOLDEER/VLOEIOMIDDEL

Maak het soldeerblok zo klein mogelijk en verwarm het bij een temperatuur van ca. 600C/112F voor in de oven. De spleet tussen de objecten die verbonden moeten worden, moet kleiner zijn dan de diameter van het gebruikte soldeer. Laat het soldeerbijekt na het solderen langzaam afkoelen.
Soldeer: Universal Solder PKF; .650, .615, .585 Fine Solder
Vloeimiddel: Bondal Flux
Laserlasermateriaal: Laser C&B Yellow

POLIJSTEN

Verwijder na het solderen of de wartebehandling oxides en resten vloeimiddel en bewerk de onderstructuur met behulp van rubberen finer- en polijstinstumenten.

INDICATIES

Inlays, onlays, driekwartkronen, kronen

CONTRA-INDICATIES

Wanneer bekend is dat de patiënt allergisch of overgevoelig is voor één van de bestanddelen dient een arts te worden geraadpleegd.

BIJWERKINGEN

In sommige gevallen kan overgevoeligheid of een allergie voor bestanddelen van de legering ontstaan.

INTERACTIES

Bij gebruik van verschillende soorten legeringen in één mondholte kunnen galvanische reacties optreden.

Voor meer gegevens over de legering verwijzen wij naar de legeringstabel.

NO	BRUKSANVISNING
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WASMODELLATIE	WOKSMODELLERING
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Modeller de restauratie volledig in was. Maak voor composiet-verblijndtoepassingen een onderstructuur die iets kleiner is dan de noodzakelijke anatomische vorm. Dit in verband met de toepassing van de geplande verblijndtechniek. De wanddikte moet bij solitaire kronen ten minste 0,3 mm bedragen en bij pijlerkronen minimaal 0,5 mm. Let er op dat de onderstructuur in voldoende mate vormstabiel is. Vermijd scherpe overgangen. Maak de verbindingsszones tussen de verschillende elementen zo stabiel dat ze voldoende aan de bestaande eisen voor interdentale hygiëne en de gebruikte legering. Breng op de onderstructuur mechanische retenties aan.

PLAATSEN VAN GIETKANALEN

Voorzie de in was gemodelleerde kroon- of brugstructuur van gietkanalen die voldoende groot zijn voor zowel de directe als de indirecte methode. Zorg dat het reservoir zich in het hittecentrum van de mofel bevindt. De verbindingsskanalen tussen het reservoir en het gietobject moeten een lengte resp. een doorsnee van 2,5 à 3,0 mm hebben.

INBEDDEN

Weeg het wasobject inclusief de gietkanalen om de benodigde hoeveelheid legering te kunnen bepalen. (Zie daartoe de wasomrekeningstabel: wasgewicht x dichtheid = hoeveelheid legering in g). Let bij gebruik van de inbedmassa op de aanwijzingen van de fabrikant.

NO BRUKSANVISNING

Modeller opp restaureringen fullstendig i voks. Utform skjelettet til fasadeerstatninger av komposit i forminket anatomisk form under hensyntaken til den planlagte fasadeerstatningen. Veggtykkelsen i enkeltkroner skal være på minst 0,3 mm og i profilørar minst 0,5 mm. Pass på at skjelettet er tilstrekkelig stabilt i formen. Unngå skarpe overganger. Hold kontaktpunktene mellom de enkelte enhetene så stabile at de samsvarer med kravene til interdentalomshygiene samt den anvendte legeringen. Utform et evt. skjelett til komposit-fasadeerstatninger i forminket anatomisk form og forsyn det med mekanisk retensjon.

PÅSETTING AV STØPEKANALER

Kronen som er modellert opp i voks henholdsvis broskjelettet må forsynes med tilstrekkelig dimensjonerte støpekanaler, både ved bruk av direkte og indirekte metode. Plasser reservoaret i termisk sentrum i støpemuffelen. Forbindelsekanalene mellom reservoar og støpeobjekt bør ha en lengde eller en diameter på mellom 2,5 og 3,0 mm.

INVESTERING

Vei voksobjektet inkl. støpekanalene for å kunne bestemme den nødvendige legeringsmengden (se voksomregningstabellen: voksvekt x tetthet = legeringsmengde i gram). Ved bruk av investment skal produsentens anvisninger følges.

UTBRENNINGSTEMPERATURER

Anbefalte utbrenningstemperaturer:

Investment for høyere temperaturområder: 650-760C/1200-1400F

Investment for lavere temperaturområder: 480-540C/900-1000F

SMELTING OG STØPING

Bruk en separat grafitt/grafite/keramisk digel for hver av legeringene. Gammel og ny legering bør brukes i forholdet 1:1. Følg opplysningene fra produsenten avhengig av støpeapparat. Ideelt sett bør man ved smelting av krone- og brolegeringer bruke en trykkluft- og naturgassbrenner, siden det ved propan og oksygen oppstår for sterk varme og legeringen lett kan bli overopphetet. Ved bruk av propan/oksygen skal trykket for propanen stilles inn på 0,15 bar/2 psi og for oksygenet på 0,35 bar/5 psi. Smelt legeringen med den oksygenreduserede delen av flammen, mellom indre og ytre flammesenter. Bruk flussmiddel om nødvendig. Etter støpingen skal kvyetten avkjøles til romtemperatur.

Støpetemperatur: 1035-1095C/1895-2000F

BEARBEIDING AV OBJEKET

Ta støpeobjektet forsiktig ut og Brukfiner resten av investmentmassen med Al₂O₃ eller glassperler eller bruk avsyning (Prevox). På grunn av deformeringsfaren må det ikke brukes hamner når støpeobjekt tas ut. Bearbeid og poler støpeobjektet. Unngå innånding av slipestøv ved sliping!

HERDING

Mykløding: 30 minutter ved 705C/1300F; deretter rask avkjøling (med vann)

Herdes: ved 260C/500F i 30 minutter, avkjøles.

Loddemidler / FLUSSMIDLER

Lag loddeblokken så liten som mulig og forvrm den i ovnen ved ca. 600C/112F. Loddespalten mellom objektene som skal forbindes med hverandre, må være mindre enn diameteren på det anvendte loddemiddelet. Avkjøl loddeobjektet langsomt etter loddingen.

Loddemiddel: Universal Solder PKF; .650, .615, .585 Fine Solder
Flussmiddel: Bondal Flux
Laserloddemiddel: Laser C&B Yellow

POLIERING

Etter loddingen eller herdingen skal oksider og flussmiddelrester fjernes og skjelettet bearbeides med gummi finerer-/polerere.

INDIKASJONER

Inlays, onlays, 3/4-kroner, kroner

KONTRAINDIKASJON

Ved kjent allergi eller overfølsomhet overfor en av bestanddelene bør lege konsulteres.

BIVIRKNINGER

I enkelte tilfeller kan det oppstå overfølsomhet eller allergi overfor bestanddeler i denne legeringen.

VEKSELVIRKNINGER

Forskjellige legeringstyper i samme munnhule kan føre til galvaniske reaksjoner.

Ytterligere data om legeringen finner du i legeringstabellen.

PT	INSTRUÇÕES DE USO
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CEROPLASTIA

Modelar o padrão totalmente em cera. Para coraas e pontas metalo-plásticas, construir a estrutura em forma anatômica reduzida, considerando o planejado revestimento estético. Coraas simples exigem espessura mínima de 0,3 mm; pilares de pontes exigem espessura mínima de 0,5 mm. As estruturas devem apresentar apropriada estabilidade de forma. Evitar ângulos agudos. Projetar áreas de soldagem compatíveis com o seu posicionamento intra-oral e com a liga a ser empregada. Se for necessário o revestimento estético com resina ou composto, a retenção mecânica está recomendada.

COLOCAÇÃO DOS SPRUES

Prover as estruturas modeladas com sprues de adequados tamanhos. Usar a técnica direta ou indireta, mantendo as câmaras de compensação situadas no centro térmico. Os sprues de conexão, entre a câmara de compensação e o padrão de cera, devem possuir 2,5-3,0 mm de comprimento e de largura.

INCLUSÃO

Pesar o padrão de cera, incluindo o sprue, para determinar a quantidade de liga a ser usada. (Consultar a tabela "conversão de cera" /fórmula: peso x densidade = gramas de liga). Usar o revestimento de acordo com as instruções do fabricante.

AQUECIMENTO

Temperatura de aquecimento sugeria:

Revestimento de alta temperatura: 650-760C/1200-1400F

Revestimento de baixa temperatura: 480-540C/900-1000F

FUNDIÇÃO

Separar um cadinho de grafite/cerâmica para cada liga. As ligas novas e usadas devem ser misturadas na proporção de 1:1. Seguir as instruções dos fabricantes, de acordo com o tipo de máquina de fundição. Na condição ideal, para fundir as ligas C&B (coraas e pontes), deve ser empregado um maçarico com chama de gás natural e ar comprimido, porque propano e oxigênio podem promover muito calor e superaquecer facilmente estas ligas. Quando forem usados propano e oxigênio, as pressões devem ser de 0,15 bar/2 psi para o propano e de 0,35 bar/5 psi para o oxigênio. Manter, sobre a superfície da liga, a parte redutora da chama, situada entre os cones internos e externos. Usar um flux de fundição, se necessário. Após a fundição, deixar esfriar normalmente até a temperatura ambiente.

Temperatura de fusão: 1035-1095C/1895-2000F

ACABAMENTO DA ESTRUTURA

De modo cuidadoso, remover o revestimento e limpar a estrutura metálica com Al₂O₃, pérolas de vidro ou um agente para decapagem. Para evitar a deformação da estrutura, não usar martelo na remoção do revestimento. Acabar e polir a estrutura metálica com brocas de carbono de tungstênio ou com pontas cerâmicas. Evite a inalação de poeiras durante o fabrico usinagem!

TRATAMENTO TÉRMICO

Recozimento: 705C/1300F durante 30 minutos; temperar imediatamente

Endurecedor: 260C/500F; durate 30 minutos; deixar esfriar.

SOLDAS / FLUXOS

Construir o bloco de soldagem tão pequeno quanto possível e pré-aquecer no forno, até aprox. 600C/112F. O espaço para a solda deve apresentar a mesma dimensão da espessura da tira de solda. Após a soldagem, deixar o objeto esfriar normalmente.

Solda: Universal Solder PKF; .650, .615, .585 Fine Solder
Fluxo: Bondal Flux
Solda a laser: Laser C&B Yellow

POLIMENTO

Após a soldagem ou o tratamento térmico, remover os resíduos de óxido e de fluxo. Efetuar o acabamento e o polimento com pontas montadas de silicose.

INDICAÇÕES

Inlays, onlays, coraas 3/4, coraas

CONTRA-INDICAÇÕES

Para os pacientes que apresentam comprovada alergia ou sensibilidade a qualquer um dos constituintes desta liga, uma consulta médica preliminar é recomendada.

EFEITOS COLATERAIS

Em casos individuais, podem ocorrer sensibilidade e alergias relacionadas com os componentes desta liga metálica.

INTERAÇÕES

A presença de diferentes ligas, no mesmo ambiente bucal, pode promover efeitos galvânicos.

Para maiores informações, consultar a tabela de propriedades da liga.

DA	BRUGSANVISNING
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RECOMENDAÇÕES	INDIRETO:
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INSTRUÇÕES:

1. Confeccionar o sprue com câmara de compensação igual ou maior que a secção transversal mais espessa da restauração.
2. Manter al(s) câmara(s) de compensação no centro térmico do revestimento; posicionar a(s) restauração(ões) aproximadamente 5 mm aquém do limite superior do revestimento e 5 mm aquém dos limites laterais do revestimento.
3. Conectar o sprue com a região mais espessa da restauração.
4. A conexão entre o sprue e a restauração deve ser alargada em forma de sino (configuração de trompete) para eliminar a turbulência da liga metálica (que causa a erosão do revestimento) e para facilitar o fluxo normal da liga, durante a fundição e solidificação.
5. Empregar apropriada quantidade de liga metálica para evitar o efeito negativo de um botão metálico muito grande durante a solidificação. A regra para determinar o peso adequado de liga é: peso total da cera x densidade relativa da liga = peso apropriado da liga.

SUGESTÕES:

1. Espessura e conformação do padrão de cera: seguir as instruções dos respectivos fabricantes.
2. Usar canais de resfriamento (suspiros) quando fundir restaurações muito grandes ou muito pesadas.

EL	ΟΔΗΓΙΕΣ ΧΡΗΣΕΩΣ
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ΤΟΠΟΘΕΤΗΣΗ ΑΓΩΓΩΝ

Τοποθετήστε στο διαμορφωμένο κέρνο κλειστό, ελαστικό κέντρο. Είτε χρησιμοποιείτε την άμμο, είτε τη έμηση με θεόδο, εσφαλώνεται ότι η δεξμενήρή βήρακτα στο θερμικό κέντρο. Οι αγωγοί σύνδεσης των στεφάνων με τη δεξμενή θα πρέπει να έχουν 2,5-3,0 χιλ μήκος και πλάτος.

ΕΠΕΝΔΥΣΗ

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ΑΠΟΚΗΡΩΣΗ

Προτεινόμενη θερμοκρασία αποκήρυσης:
Πυρόμαγμα υψηλής θερμοκρασίας: 650-760C/1200-1400F
Πυρόμαγμα χαμηλής θερμοκρασίας: 480-540C/900-1000F

SMELTING OG STØBNING

Til hver legering anvendes en separat smeltedigel af grafit eller keramik. Ny og gammel legering bør anvendes i forholdet 1:1. Støbeapparatets respektive brugsanvisning følges. Det er bedst at anvende en trykluft- og naturgasbrænder til smelting af C&B legeringen efter som propan og ilt udvikler for kraftig varme og legeringen let bliver overopphet. Ved anvendelse af propan/ilt skal propan indstilles til 0,15 bar/2 psi og ilt indstilles til 0,35 bar/5 psi. Legeringen smeltes med den indtrædende del af flammen (mellem den indre og den ydre flammekægle). Flussmiddel kan anvendes efter behov. Efter støbningen skal kvyetten stå til afkøling til støuetemperatur.

Støbetemperatur: 1035-1095C/1895-2000F

BEARBEJNING

Støbeobjektet tages forsigtig ud af kvyetten og rengøres. Al₂O₃ eller glassperler anvendes til sandblæsning. Kvyetten må ikke skilles ad med en hammer på grund af risiko for deformation af støbeobjektet. Støbeobjektet bearbejdes og poleres. Undgå indånding af støv ved slipning!

HÆRDNING

Blødgøring: 30 minutter ved 705C/1300F; Hurtig-afkøl straks

Hærdning: 30 minutter ved 260C/500F; afkøling ved henstand.

LOD / FLUSSMIDDEL

Loddeblokken udformes så lille som muligt og forvarmes i ovnen ved ca. 600C/112F. Loddespalten mellem de to loddepunkter bør være mindre end diameteren af det anvendte lod. Efter lodning skal objektet afkøle langsomt.

Lodning: Universal Solder PKF; .650, .615, .585 Fine Solder
Flussmiddel: Bondal Flux
Laser-lodemateriale: Laser C&B Yellow

POLERING

Efter lodning eller hærdning fjernes oxider og flussmiddelrester og stellet bearbejdes med gummi finerer-/polerere.

INDIKATION

Indlæg, onlays, 3/4-kroner, kroner

KONTRAINDIKATION

Ved erkendt allergi eller intolerance mod en del af indholdet bør en læge konsulteres.

BIVIRKNINGER

I enkelte tilfælde kan der optræde allergi eller intolerance mod dele af legeringens indhold.

VEKSELVIRKNINGER

Forskellige legeringstyper i samme mundhule kan medføre galvaniske reaktioner.

Yderligere oplysninger om legeringen findes i legeringstabellen.

DA	BRUGSANVISNING
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EL	ΟΔΗΓΙΕΣ ΧΡΗΣΕΩΣ
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Støbetemperatur: 1035-1095C/1895-2000F