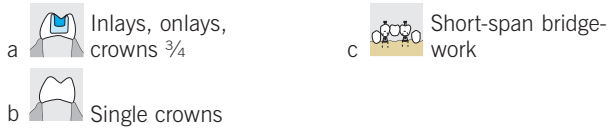


Instructions for use

**Silver-Palladium-Gold dental casting Alloy, hard, white, type 4****Indication**

C&amp;B technique, conventional crowns, small bridges, inlays, onlays.

**Physical properties**

Composition in weight %

Au + Pt group metals	31.41
Au	12.50
Pd	18.90
Ru	0.01
Ag	53.65
Cu	14.29
Zn	0.65
Density g/cm <sup>3</sup>	11.1
Melting range °C	900–980
Young's Modulus GPa*	110

**Mechanical properties**

	1	2	3
Hardness HV5*	135	185	240
0.2% Proof stress, Rp 0.2% MPa*	300	435	340
Elongation A5%*	25	22	12

**State**

1	soft
2	as cast
3	hardened

Solders	Melting range
S.G 810	750–810°C
S.G 750	695–750°C

\* The values indicated result from measurements obtained under exactly defined conditions. Individual deviations of  $\pm 10\%$  are possible and to be considered as normal.

**Preventive measure (contraindication) and important notes**

These instructions for use must be precisely followed. It has been suggested in specialized literature that some of its components can, in extremely rare cases, have allergy effects. The choice of the material is the decision of the practitioner based on his knowledge of the sensitivity of the patient.

**Corrosion resistance and biocompatibility**

Pagaliner® 2 has been submitted to the following tests:

**Corrosion resistance** according to ISO 22674

**Cytotoxicity** test according to ISO 10993-5

**Mutagenicity** test no component is considered as mutagen according to the specialized literature.

The alloy is considered to be highly corrosion resistant and showed no cytotoxic potential.

Launch year 1972

Pagaliner® 2 corresponds to the standards EN ISO 22674 – except § 8.6.

Pagaliner® 2 has been manufactured according to the quality standards ISO 9001 / ISO 13485.

Rx only

The products carry the CE sign.  
See packaging for details.

**Waxing up**

The ultimate thickness of the cast metal coping should not be less than **0.3 mm**.

Therefore: Consideration must be given to this fact at the wax-up stage, long span frameworks require structural reinforcement to ensure stability and anticipated solder joints should be of adequate surface area to provide sufficient stability to the frame.

**Spruing**

Wax sprues of no less than  $\varnothing$  **3.5 mm** are required. Direct ( $\varnothing$  **3.5 mm**) and cross bar ( $\varnothing$  **5 mm**) spruing produce excellent results. Feeder sprues to heavy pontics should be of at least  $\varnothing$  **4 mm**. Air vents ( $\varnothing$  **1 mm**) may be used to advantage. Wax patterns should be set outside the thermal centre, i.e. near the casting ring wall and about **5 mm** from the end. For individual copings and small bridges (up to three units), use of the circular sprue provides ideal positioning of the wax patterns and ensure controlled solidification of the frameworks.

**Investing**

When using steel casting rings always use refractory liner in order to allow free expansion of the investment. All regular or phosphate-bonded (e.g. **Univest®Plus** or **Univest®Rapid**) investments for precious metal alloys may be used. Follow the procedures recommended by the manufacturer.

**Preheating**

Observe manufacturer's recommendations with regard to setting times, temperature levels etc. On reaching the end temperature a soaking period of **20 to 45 min.** is advisable depending on the size of the cylinder.

Preheating temperature: 650°C–680°C

**Crucibles**

Glaze the crucible before first use with a recommended flux (e.g. Borax/Boric acid). The following crucibles can be used:

Ceramic crucible: Casting temperature 1180°C

**Re-melting**

When melting down thoroughly cleaned casting buttons, add at least **½ of new alloy**. The used copings have to be clean, free of investment and flux residue.

**Melting**

It is important, when using a torch for melting (for inst. **Meteor type «O»**) that the recommended propane (approx. **0.5 bar** or **7.25 psi**) / oxygen (approx. **1.0 bar** or **14.5 psi**) mixture and pressure is observed. Before melting add a pinch of flux to the alloy. Once the alloy has completely melted, continue heating for a further approx. **5 sec.** before releasing the casting machine arm. When melting by resistance heating, the power must be maintained for an additional **20–40 sec.** before casting. Always ensure that both furnace and crucible have reached this temperature before adding the alloy.

Flux: Borax

**Cooling**

Bench cool the casting ring.

**Devesting/Cleaning**

Clean by blasting with glass beads or pure aluminium oxide ( $\text{Al}_2\text{O}_3$ ) particle size (**50µm** to **125µm**) at **1.5 to 2.0 bar** (**21.7 to 29 psi**) pressure.

**Pickling**

Following casting or soldering, the frame at room temperature may be pickled in hot **Desoxid** for at least **2 min.** – Desoxid II (63 %).

**Finishing**

Use abrasive grinding points of your choice.

**Preparation for resin bonding**

Blast with aluminium oxid ( $\text{Al}_2\text{O}_3$ ), particles size approx. **110µm** and steam clean. Follow manufacturers recommendations when bonding resin veneers.

**Soldering/Laser**

We recommend using a propane/oxygen torch (**Meteor Type «L»**) for soldering and a flux like **Fluxor**. During soldering wear dark goggles for protection. The design of the soldering block is a compromise between minimising its thermal mass whilst retaining sufficient strength to avoid its fracturing during soldering. Leave a parallel gap of **0.1–0.2 mm** between surfaces to be soldered and sufficient area to ensure adequate strength of the joint. Laser welding wire: LW No. 6

**Heat treatments**

Annealed 700°C/10 min. – quench in water

Self-hardened by slow (bench-) cooling of the casting ring

Hardened (only after annealing) 375°C/15 min. – let bench-cool

**Polishing**

Thorough rubberwheeling ensures easy prepolishing. For best polishing results, soft brushes, felts and cotton wheels are employed using **Legabril Diamond** diamond-paste. «Whiting chalk» (chalk-powder) mixed with water on soft brushes or cotton wheels may be used for final high polish.