

IMPERIAL TRADING LTD.

Alloy Specification Sheet
No Nickel No Beryllium No. 800

Color: WHITE

Type: PFM,IV ADA Classification: Cobalt BASE

PGM: 0%

Composition

Mn	Co	Si	Mo	Cr	Other
1	59.5	2	5	31.5	1

'x' denotes a content of less than one percent.

Thermal Properties

Melting Range	Casting Temperature	Density g/cm ³
2265-2460°F	2695°F	8.8
1240-1350 °C	1480 °C	

Mechanical Properties

Vickers Hardness (VHN)			Yield Strength N/mm ² (0.2% Offset)		Tensile Strength N/mm ²		Elongation %		Co-Eff. of Expansion (um/m-°C)	
A.F.	Soft	Hard	Soft	Hard	Soft	Hard	Soft	Hard	25-500	25-600
280		280		450		765		9	14.3	14.8

PROCESS**INSTRUCTIONS FOR USE****Modeling**

Maintain a minimum wax thickness of 0.3 to 0.4 mm. The wax pattern design should have lingual collars and no sharp corners. Lingual eyelet rings help support castings during firing.

Spruing (Single Crowns)

Use direct sprues, 8-10 gauge, (3.3-2.6 mm diameter) and 1/2 in. (12 mm) long with adequate reservoirs. There should be no more than 1/4 in. (6 mm) of investment from the top of the pattern to the top of the investment.

Spruing (Multi-Units & Bridges)

Use a 6 gauge (4.1 mm diameter) runner bar, connecting the units to the bar with 10 gauge (2.6 mm diameter) sprues 1/8 in. (3 mm) long and joining the bar to the sprue base with 8 gauge (3.3 mm diameter) and 1/2 in. (12 mm) long sprues coming from a domed central entry point. There should be no more than 1/4 in. (6 mm) of investment from the top of the pattern to the top of the investment.

Investing

Use debubbler and blow off any excess before investing. Recommended Investment: Phosphate Bonded. Follow the manufacturer's instructions.

Burnout

After adequate set-up time, place the ring(s) in a room temperature oven and raise the temperature to 870°C plus 10 minutes for each additional ring. If you are using a rapid fire investment, follow the manufacturer's instructions.

Crucible Type

Quartz or Zircon

Torch Casting

Wind the casting machine one more turn than you would for precious ceramic alloys. A quartz or zircon crucible is necessary. Use a propane/oxygen torch with a multi-orifice tip. Do not use flux. Place the alloy (at least 50% new metal) in a pre-heated crucible. Keep the torch moving to heat all the metal in the crucible at an even rate. The individual ingots will not pool together to form a single mass. Do not stir or rupture the oxide surface. When the flame appears to move the alloy, cast. After casting bench cool before deinvesting.

Induction or Electrical Casting

When using induction casting machine, pre-heat the crucible. Set the arm speed to 400-450 rpm & set the power to high and be sure that the alloy is pulsating and slumping. The casting temperature of automatic casting equipment should be set for 2700°F (1480°C) with a five seconds heat soak.

Cooling

Allow casting ring to cool to room temperature. DO NOT quench in water.

Divesting and Cleaning Divest and sandblast with 50 micron aluminum oxide, be careful of margins.

Finishing Grind the metal surfaces for porcelain application with non-contaminating aluminum oxide stones in one direction. Blast with non-recycled 50 micron aluminum oxide. Do not exceed a blast pressure of 4 bars or 60 psi. Clean in distilled water in an ultrasonic cleaner for 10 minutes.

Oxydizing or Degassing 650-980°C, no hold, Removal of oxide optional, Vacuum

Presolder Solder joints should be as large as possible (at least 5 mm²). Soldering gap approximately 0.05-0.2 mm. The solder joints should be parallel and free of debris. Preheat invested units and pressure blast with 50 micron just before soldering.

Use: P, NP, Flux-N-Sol

INTERNATIONAL / DOMESTIC

Porcelain Application Follow the recommendations of the porcelain manufacturer. For a better bond, fire a thin wash 10 - 15 °F (10 °C) above normal temperature, followed by regular opaque coats.

Post Soldering After Firing Solder joints should be as large as possible (at least 5 mm²). Soldering gap approximately 0.05 - 0.2 mm. Cover ceramically-veneered units with wax before investing. The soldering investment should not come in contact with the ceramic. The soldering surfaces should be parallel, smooth and free of debris.

Use: LO, R

INTERNATIONAL / DOMESTIC

Polishing Use Tripoli and rouge or other similar products.