

IMPERIAL TRADING LTD.
72-59 KISSENA BLVD , FLUSHING , N.Y. 11367
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CSV Instructions

NICKEL = 73.6 % NOMINAL
CHROMIUM = 16.4 % NOMINAL
MOLYBDENUM = 8.1 % NOMINAL
BERYLLIUM = 1.9 % NOMINAL

Physical Properties of CSV

Co-efficient of Expansion @ 500 C = 13.64×10^{-6}
Brinell Hardness = 228
Elongation = 11%
Casting Temperature = 2400 F - 2450 F (1315 C - 1343 C)

TECHNICAL INSTRUCTIONS

WAXING: 0.3mm thickness

SPRUIING: 8 gauge wax (3.0-3.5mm) sprues direct or indirect with a runner bar, put reservoirs opposite all pontics

INVESTING: High heat phosphate bonded investments. Mix under vacuum (1-1½ min)

BURNOUT: Two stage burnout technique is recommended.
Stage #1: Room temperature to 315 deg C, hold for 30 min.
Stage #2: 315 deg C to 875 deg C, hold for 60 min
Single stage burnout: Room temp to 875 deg C hold 60 min

CASTING: Induction casting with argon is recommended. Use multiple orifice torch, preheat 100% quartz crucibles 20 psi oxygen ÷ 1-psi propane gas. Heat ingots evenly until they all "slump". Use 50% new alloy when casting buttons.

CLEANING: Sandblast with 50 micron white aluminum oxide at 5-6 cm Hg (80psi). Use only aluminum oxide wheels and discs. Ultrasonic cleaner with distilled water for 3-5 minutes.