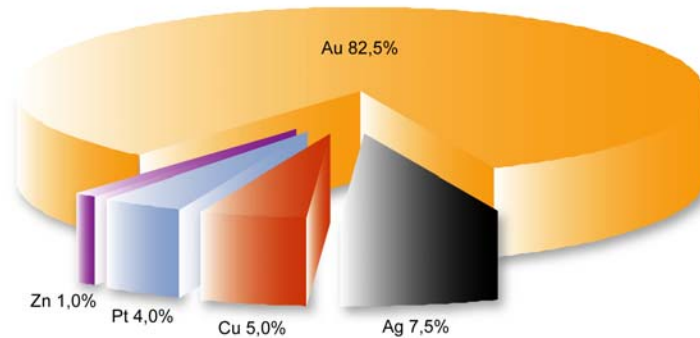


## Technical Data Sheet BIORPLID® G

<b>Content:</b>	<b>Au</b>	82,5	<b>Pt</b>	4,0
	<b>Ag</b>	7,5	<b>Zn</b>	1,0
	<b>Cu</b>	5,0		



<b>NORM:</b>	DIN EN ISO 22674
<b>Typ:</b>	2
<b>Colour:</b>	deep yellow
<b>Melting range °C:</b>	985-900
<b>Vickers hardness (HV 5/30):</b>	s: 110 h: 165 c/f: 130
<b>0,2% Yield strenght (MPa):</b>	s: 180 h: 280 c/f: 260
<b>Elongation (%):</b>	s: 41 h: 23 c/f: 25
<b>Softening:</b>	15 min at 750 °C / quench in water
<b>Hardening:</b>	15 min at 500 °C / air
<b>Pre-heating temperature °C:</b>	700
<b>Casting temperature °C:</b>	1120
<b>Heating after melting (s):</b>	electric.: 15 - 20 inductive: 5 - 8 flame: 5 - 8
<b>Density g/cm<sup>3</sup>:</b>	17,5
<b>Solders:</b>	Orplid Solders 825, 790, 760

## Processing Guide BIORPLID® G

**Applying of casting sprues:** according to dental norms (see general operating instruction)

**Investing:** phosphate bonded investings (Cehacast P or Cehacast Speed); plaster bonded investings

**Pre-heating:** 700 °C, 30 to 120 min at end temperature, corresponding to muffle size

**Casting:** 1120 °C, graphite crucible resp. at open flame with ceramic crucible

**Trimming:** with carbide milling and/or ceramical bonded abrasives

**Cleaning:** ultrasonic cleaning or steaming with steam device

**Soldering:** Orplid Solders 825, 790, 760

**Proof of conformity:**



Please find results of the extensive analysis of bio-compatibility online at [www.c-hafner.de](http://www.c-hafner.de)

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