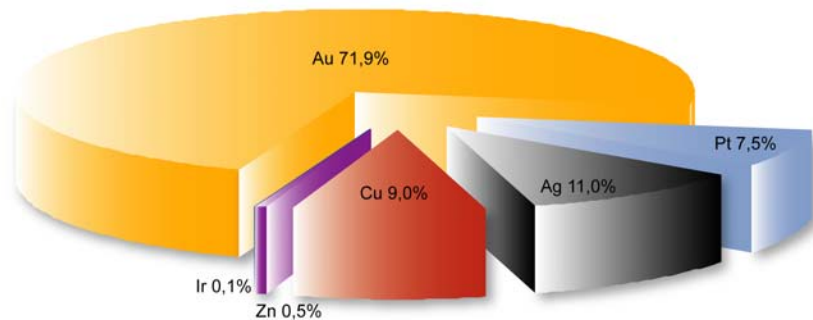


## Technical Data Sheet ORPLID® G 1

<b>Content:</b>	<b>Au</b>	71,9	<b>Pt</b>	7,5
	<b>Ag</b>	11,0	<b>Zn</b>	0,5
	<b>Cu</b>	9,0	<b>Ir</b>	0,1



<b>NORM:</b>	DIN EN ISO 22674
<b>Type:</b>	5
<b>Colour:</b>	yellow
<b>Melting range °C:</b>	970-930
<b>Vickers hardness (HV 5/30):</b>	s: 150 h: 230 c/f: 230
<b>0,2% Yield strenght (MPa):</b>	s: 340 h: 640 c/f: 610
<b>Elongation (%):</b>	s: 35 h: 20 c/f: 23
<b>Softening:</b>	15 min at 800 °C / quench in water
<b>Hardening:</b>	15 min at 450 °C / air
<b>Pre-heating temperature °C:</b>	700
<b>Casting temperature °C:</b>	1100
<b>Heating after melting (s):</b>	elektr.: 15 - 20 induktiv: 5 - 8 Flamme: 5 - 8
<b>Density g/cm<sup>3</sup>:</b>	16,0
<b>Solders:</b>	Orplid Solders 910, CF 720

## Processing Guide ORPLID® G 1

**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:** 1100 °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 910, CF720

**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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