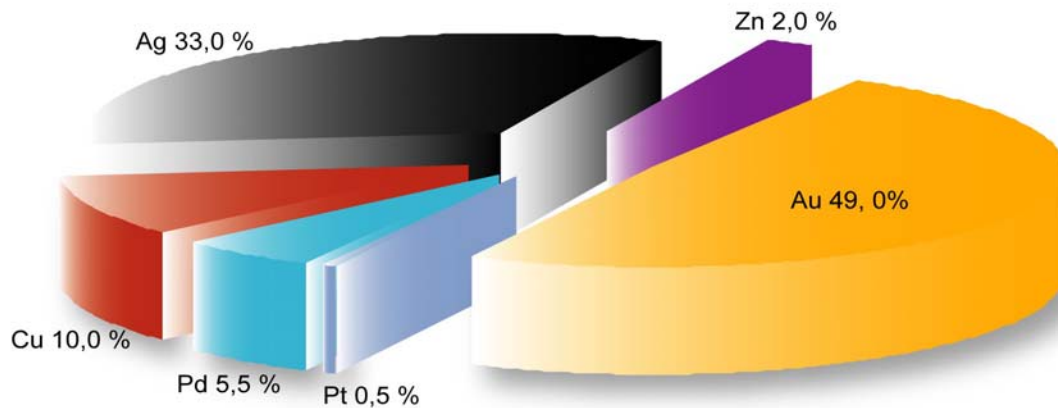


Technical Data Sheet P 3

Content:

Au	49,0	Cu	10,0
Pt	0,5	Ag	33,0
Pd	5,5	Zn	2,0



NORM: DIN EN ISO 22674

Type: 5

Colour: light yellow

Melting range °C: 910 - 860

Vickers hardness (HV 5/30):
s: 160
h: 270
c/f: 270

0,2% Yield strength (MPa):
h: 810
s: 415

Elongation (%):
h: 2
s: 16

Softening: 15 min. at 750 °C/quench in water

Hardening: 15 min. at 350 °C/air

Pre-heating temperature °C: 700

Casting temperature °C: 1060

Heating after melting (s):
electric: 15 - 20
inductive: 15 - 10
flame: 5 - 8

Density g/cm³: 13,2

Solders: Orplid Lot 825, 790, 760

Processing Guide P 3

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

Investing: phosphate bonded investing (Cehacast P or Cehacast Speed)

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

Casting: 1060 °C, graphite crucible resp. at open flame with ceramic crucible.

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

Cleaning: Ultrasonic or steaming with steam device

Soldering: Orplid Lot 825, 790, 760

Proof of conformity:



Please find results of the extensive analysis
of bio-compatibility online at www.c-hafner.de

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