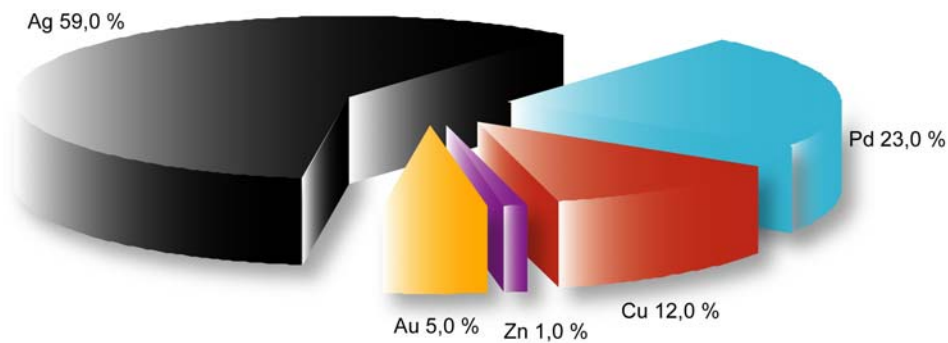


Technical Data Sheet
PANGOLD®

Content:

Au	5,0	Cu	12,0
Ag	59,0	Zn	1,0
Pd	23,0		



NORM:	DIN EN ISO 22674
Type:	5
Colour:	white
Melting range °C:	1020 - 940
Vickers hardness (HV 5/30):	s: 120 h: 230 c/f: 200
0,2% Yield strenght (MPa):	s: 310 h: 650 c/f: 600
Elongation (%):	s: 17 h: 11 c/f: 13
Softening:	15 min at 950 °C/quench in water
Hardening:	15 min at 600 °C/air
Pre-heating temperature °C:	750
Casting temperature °C:	1200
Heating after melting (s):	electric.: 20-30 inductive: 5-10 flame: 5-10
Density g/cm³:	10,8
Solders:	Universal Lot 770

Processing Guide PANGOLD®

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

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

Pre-heating: 750 °C, 30 to 120 min at end temperature, corresponding to muffle size

Casting: 1200 °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: Universal Lot 770

Proof of conformity:



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

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