

CERACAST V

Non-Precious Dental Casting Ceramic Alloy

Code: MMI-CERACAST-V

Instruction & Technical Information

Technical Data:	
Melting Range	1165°C – 1207°C
Yield Strength	880 MPa
Tensile Strength	1160 MPa
Elongation	7.0%
Density	7.9 (g/cc)
Coefficient of the Liner Expansion	13.4 (25-500°C)

Composition:	
Nickel	73.0%
Chrome	14.0%
Molybdenum	8.5%
Aluminum	1.7%
Beryllium	1.8%
Titanium, Silicon, Cobalt	<1%

WAXING:

Waxing procedure is very similar to the application of precious and semi-precious alloys. However, waxing could be as thin as 0.3 mm

SPRUEING:

A- Direct for single units. Sprueing should be ¼ (6 mm) in length. Based on the size and the thickness of crowns use 6-8 gauge sprues.

B- Indirect, for multiple units. Use straight 8 gauge sprue, about 1/8" (3 or 4 mm) in length, and connect it to the unit.

For long spanned bridges use an additional sprue connected to the last unit.

INVESTING:

Use high heat investments; follow the manufacturer's instructions carefully. Use debubbler. Use one-two ring liner.

After investment has set, scrape the top of the investment to allow gases to escape.

BURNOUT:

Place the ring in the furnace at room temperature (or as high as 600°F if needed) and raise the temperature (to 1700°F for Ni based alloys; 1750°F for Co based alloys). Increase the temperature to 1800°F prior to casting, with one hour holding time. Soaking time: 45-60 minutes. DO NOT heat soak at 1800°F (982°C).

MELTING & CASTING:

Can be melted with the induction machine or with gas/oxygen torch.

A- Torch casting: Use multiple orifice torch tips. Do not use crucible used for other alloys. Move the torch allowing even distribution of heat.

Adjust oxygen regulators at approximately 25-30 Lbs. Propane. Adjust valves until the inner flame cone is blue and approximately ½" long; the outside of the flame cone should be 3 ½" from the inner cone. Preheat the crucible.

Release the casting arm when the ingots lose definition and puddle: molten ingots usually vibrate from the force of the flame.

Bench cool the cast until the redness goes away.

B- Induction Casting: Set the temperature to 2700°F (1480°C). Set the casting arm speed between 425 and 450 rpm.

When ingots pool together and shadow disappears, release the arm.

METAL FINISHING:

Sandblast the investing with pure non-recycled aluminum oxide. Do not smooth the surface of the frame bearing porcelain.

Use carbides, discs, diamonds and stones for metal finishing.

METAL PREPERATION:

Sandblast the area bearing porcelain, and do not touch the area accepting porcelain; clean with ultrasonic cleaner.

De-gasing the metal is to achieve the desirable oxidation. Place the metal work in a furnace at 1200°F (650°C): create a vacuum and increase the temperature 100°F (38°C) per minute to 1900°F (1035°C); brake the vacuum and let it cool down.

OPAQUE & PORCELAIN APPLICATION:

Bonding slurry must be applied to all surface bearing porcelain, apply slurry and dry it quickly in the oven with open muffle; fire the slurry coating in 10° higher temperature, as per instructions for opaque. Quicker method is using the same procedure without degas procedure. Use opaque manufacturer's instructions. Try to complete opaque firing in a single step.

PORCELAIN APPLICATION:

Follow the instructions of the ceramics manufacturers. Build up your porcelain and try to save extra firing.

Note: For best results use at least 50% new metal with 50% sandblasted and cleaned buttons.

Caution: This alloy contains Ni & Be, not to be used in individuals with Ni sensitivity. Inhalation of Be dust and fumes can be toxic, grind and polish with adequate ventilation, and wear protective clothing.



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