

EQUITY

HIGH NOBLE WHITE CERAMIC ALLOY

Au & Pt Group: 90%

PROPERTIES*	
Melting Range	2110-2280°F 1155-1250°C
Coefficient of Thermal Expansion from 25-500°C	14.2
from 25-600°C	14.6
Density	15.4 g/cm ³

CHEMISTRY	
Gold	68%
Palladium	22%
Silver	3%
Indium	7%
Ruthenium, Rhenium	<1%

AFTER PORCELAIN FIRING*	
Hardness	240 HV
Tensile Elongation	11%
Tensile Yield Strength/Proof Stress	79,700 psi / 550 MPa
Ultimate Tensile Strength	98,500 psi / 680 MPa
Modulus of Elasticity	17.2 x 10 ⁶ psi / 118,000 MPa

* Test methods conform to ISO Standard 9693 and ANSI/ADA 38

PROCESSING TECHNIQUE

WAXING	0.3mm for single units and 0.5mm for bridgework
INVESTMENT	Phosphate-bonded high heat investment with or without carbon
BURNOUT	1400°F (760°C)
MELTING AND CASTING	Wind the casting arm one more time than normal (3-4 winds). Multi-orifice torch: 10 psi fuel and 20 psi oxygen (0.7 bars fuel and 1.4 bars oxygen). Heat until cloudy surface clears before releasing the casting arm. DO NOT OVERHEAT. DO NOT USE CASTING FLUX. Casting temperature ~2400°F (1315°C).
FINISHING	Finish with aluminum oxide stones. Blast porcelain receiving surfaces with non-recycled aluminum oxide. Clean in ultrasonic for 10 minutes.
CONDITIONING	(Degassing, Oxidation) Oxidize at 1800°F (980°C) in air. Hold for 5 minutes. Bench cool. Proceed with normal opaque technique.
SOLDERING	Pre-solder P-80 Solder Post-solder 1400 Solder Flux Brown Fluoride Flux (for both pre & post soldering)

Jensen Technical Service is available 8:00 AM - 8:00 PM EST by calling 1-800-243-2000

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