

PRODUCTION SPECIFICATIONS

TRIM SIZE: 259mm w x 55mm h
 STOCK: 10 pt card stock, coated, no adhesive
 FINISHED SIZE: Approx. 59mm w x 55mm h
 IN HOUSE PRINTING CAPABILITY: NO

FP 00766

BLEED: NO
 INKS: PMS 021 & Black
 # OF FOLDS: 2
 VARNISH: yes

Magenta die cut line for shape only does not print
 Cyan for imprint only does not print

Indications for use:

Degudent H is a high noble, micro-fine grain porcelain alloy, which may be used with most dental porcelains. Degudent H is highly bio-compatible and features a light golden color. Degudent H is recommended for bridges of any length as well as implant superstructures.

Contraindications: None known.

Warning: Exposure to alloy dust or fumes may cause eye irritation. Ventilate work area when processing this alloy.

Precautions: Use proper safety equipment and a certified industrially ventilated work area when processing this alloy.

Adverse Reactions: Exposure to alloy dust or fumes may cause eye irritation and/or respiratory complications.

Additional information is available on request.
 For dental use only.

Technical Data¹**Lot #**

Melting range	CTE-range (WAK)		Vickers hardness HV5	Tensile strength* MPa	0.2% Yield strength* MPa	Elongation* %	Density g/cm ³
	25-500 °C 77-932 °F	25-600 °C 77-1112 °F					
1100-1210 °C 2010-2210 °F	14.2	14.4	f: 200 h: 220	f: 580 h: 620	f: 480 h: 600	s: 8 h: 3	18.1

f = after porcelain application; h = hard
 *To convert from MPa to psi, multiply by 145
 Tensile strength tests performed in accordance with ISO 9693
 Burnout Temperature: 1560 °F (850 °C); Casting Temperature: 2550 °F (1400 °C).
 Pre-Solder: Flux: DS-1 or Anoxan®.
 Post-solder: Degulor 2 Solder; Flux: T-Flux or DS-1

¹ Technical Data for reference only.

RMC# 743-932 Rev. 01/09

USA 090/0483

See Reverse Side for Working Instructions!

Dental Ceramic Alloy
Type: 5

Color pale yellow

US Reference No. 111120

Au: 84.4%
Pt: 8.0%
Pd: 5.0%
In: 2.5%
Ta: 0.1%



Weight
1 T. oz.
31.1
grams

Micro-Fine Grain Alloy

Degudent® H

Distributed by:

Dentsply International

570 West College Ave

York, PA 17405-0872

1-800-487-0100

1-717-699-4190

Made in Germany



Degudent® H

Instructions for use

Step by Step Instructions:

1. Design:

The minimum crown wall thickness should be 0.3 mm for single crowns and 0.5 mm for bridge abutment crowns.

2. Sprues:

Single Crowns: Sprue directly onto the thickest part of the pattern using 8 or 6 gauge (3.5–4.0 mm diam.) sprues, 10–15 mm in length.

Single Crowns Bridgework: Attach 8 or 6 gauge (3.5–4.0 mm diam.) sprues to wax pattern. Connect the sprued patterns to a 6 or 4 gauge (4.0–5.0 mm diam.) runner bar, measuring the length of the bridge span. Use several 8 or 6 gauge sprues from the runner bar to the crucible cone former.

3. Investment:

Use only phosphate bound investment such as DEGUVEST® F

4. Wax Elimination

At 600 °F (315 °C) until wax is completely eliminated.

5. Burnout:

Heat to 1560 °F (850 °C) and heat-soak for 20–60 minutes depending on size of ring. More time is required with additional rings.

6. Casting:

Casting temperature: 2550 °F (1400 °C). When torch melting continue heating for additional 5–10 seconds. After casting, allow ring to **BENCH COOL** to room temperature. Use at least 50% new alloy! Veriflux may be used to reduce oxide formation during melting.

7. Finishing:

Use only carbide burs and ceramic bound stones. Sandblast with non-recyclable aluminum oxide 50-110 microns and clean thoroughly.

8. Degassing:

Degas to 1835 °F (1000 °C) without vacuum and hold for 5 minutes. Sandblast as in 7 above.

9. Porcelain Application:

Follow manufacturer's instructions. To enhance the bonding properties the opaque should be fired in two layers. Apply the first layer very thin and the second layer to normal thickness.

10. Pre-Soldering:

Use YPG Solder 1950 °F (1065 °C); Flux: DS 1 or Anoxan®.

11. Post-Soldering:

Use Degulor 2 Solder, 1380 °F (750 °C). Flux: T-Flux or DS-1.