



Process Instructions for ROBUR 400[®]

Non-precious-dental-model cast alloy on cobalt base, Type 5



0434

ROBUR 400[®] is an extremely pure model cast alloy on cobalt base, exclusively made of fresh and pre-tested ore. This is an important requirement for high histocompatibility. It goes without saying that our alloy meets DIN EN ISO 22674 is conform to the CE-specification.

ROBUR 400[®] Highest mechanical features and best cast ability make room for individual and esthetical denture creation. Simple elaboration as well as good polishing- and gloss results are typical.

Embedding:

ROBUR 400[®] compatible with all customary model casting investment material.

Casting:

ROBUR 400[®] is melted in a ceramic melting pot. Wait until the last cube is collapsed, then insert muffle into the centrifuge and melt the alloy until the shade is disappeared in the center. Cast procedure after 2-3 seconds. After the cast the muffle has to be cooled down to room temperature and out bedded. Do not chill in water bath.

Don't use graphite crucible!

Open melting: With acetylene/oxygen. The instructions of the manufacturer need to be followed. A careful adjusted flame prevents the soiling of the alloy. Do not use any fluxes.

The frameworks are working out with the usual carbide cutters or Al-Oxidstones.

Soldering:

Customary solders can be used for **ROBUR 400[®]**. It is also suitable for laser welding (Kera[®]LA-con from Eisenbacher). **ROBUR 400[®]** parts should not be soldered with gold or palladium.

Cleaning:

ROBUR 400[®] is cleaned in ultrasonic bath or with steam jet cleaning.

Recommendation for single-use:

We do not recommend the reuse of the sprue cone since the characteristics of the alloy can be changed negatively.

Guarantee:

All recommendations are based on our own experiences. The user is responsible for correct use and processing. If nevertheless the claim for compensation should be asserted, this is only related to the value of goods that have been delivered.

Safety information:

Metal dusts are dangerous to health. Therefore we suggest to wear a respiratory mask and to exhaust when finalizing and sand blasting. Recommendation: filter FFP2

Our information and recommendations are based on the present scientific and technical knowledge and are to our knowledge and experiences to be seen as correct. The present version replaces all former indications.