

AURIBOND 97 CERAMIC GOLD ALLOY TECHNIQUE OUTLINE

Elite II is a bio-compatible, yellow premium alloy for metal bonded to porcelain restorations. Auribond 97 special formulation permits easy polishing to a lustrous finish with Aurident's Polishing Kit and Compound.

Wax-up: Sprues should be no smaller than 10 gauge and no longer than 1/4". Minimum thickness of wax should be no less than 0.3mm. for single units.

Investing and Burnout: Aurivest investment or equivalent is recommended. No more than 1/4" of investment should cover highest point of wax pattern. Ring should be burned out at 1400° F for a minimum of 45 minutes or according to manufacturer's recommended time.

Casting: Centrifugal type casting machines should be wound 3 1/2 to 4 turns. A sufficient amount of metal should be used to leave a button of 6 dwt. At least 2 dwt. of new metal should be added for each casting using a previously used button. A gas-oxygen torch flame should be adjusted so that the inner cone of the flame at least 1/2 inches long to avoid excessive oxidation during melting. Casting temperature is 2150 to 2200 °F (1175-1200 °C). At the casting temperature, the metal appears fluid and will vibrate if the casting machine arm is gently tapped.

Cleaning and Finishing: The bulk of adhering investment should be removed with a burr. Finish with conventional aluminum oxide stones. Avoid heatless stones or any abrasive containing graphitic or silicone materials. Final porcelain surfaces should be finished with a fluted carbide burr. Clean for 5 minutes in distilled water in an ultrasonic cleaner.

Degas: Heat casting to 1800°F for 2 minutes in air and 2 minutes in vacuum, for a total of 4 minutes (either the air exposure or the vacuum exposure may be done first). After this step, care should be taken to avoid contact with fingers or any object that could contaminate surface. Surface is then ready for application of opaque according to porcelain manufacturer's instructions.

Sandblasting: Interior surfaces of the restoration can be sandblasted using glass beads of 50 microns at 20 psi. Smaller sized beads tend to be difficult to remove and should be avoided.