



CE
2862



Heimerle + Meule Group



Cookson Precious Metals Ltd,
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Cookson Drijthout BV
Keienbergweg 12 1101 GB Amsterdam

Device Name: Anglobond

Device Type: Palladium Bonding Alloy

Indications: TYPE 3: For multiple unit fixed prostheses

Intended Use: Fabrication of custom-made dental restorations

Intended Patients: Any (no restriction on patient characteristics)

Intended Users: Dental laboratory technicians.

There are no specific contraindications, warnings, or precautions for patients, though see composition if patient allergies are known or suspected.

There are no special storage requirements for this material.



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REF

ZCX 000

Technical Data

Density	11.5 g/cm ³	
Composition	Pd 79.0% Sn 11.4% Cu 4.2% Ga 4.2% Ru 1.0%	
Melting Range	1210 - 1250°C	
Elongation	8%	After simulated porcelain firing
0.2% Proof Stress	350MPa	
Coefficient of Thermal Expansion	14.1 x 10 ⁻⁶ K ⁻¹ (25 - 500°C) 14.3 x 10 ⁻⁶ K ⁻¹ (25 - 600°C)	
Casting Temperature	1400°C	
Casting Ring Pre-Heat	900°C for 40 minutes.	
Solders: Pre-Bonding	Mattiflo 1110W-Tenacity 125	
Flux: Post-Bonding	Mattiflo 715Y	
Typical Applications	Single units, Multiple units Long spans, Posts and Pins	
Typical Porcelains	Vita VMK, Doric Universal	

Additional Information

Disposal / Re-Use

Considerations:

Clean scrap can be reused to make further restorations, however alloys that have been used on patients should not be reused to minimize contamination risk. Once appropriately cleaned, precious metal alloys may be sent for recycling.

In the event of a defective device

Contact Cooksongold on +441212338170.
If the defect has only become apparent after the alloy has been used on a patient, then also contact the competent authority of the Member State in which the patient is established (refer to https://ec.europa.eu/health/md_sector/contact_en)

Summary of Safety and Clinical Performance (SSCP)

The Summary of Safety and Clinical Performance (SSCP) is available on request and can also be found at <https://ec.europa.eu/tools/eudamed> by searching for the Basic UDI-DI 5057531 ALLOYTL (when the website is operational).

DIRECTIONS FOR USE

WAXING

A minimum wax thickness of 0.3 mm for single crowns and 0.5 mm for multiple units is recommended. The connection area of abutments must be greater than 3 mm x 3 mm. Sprue each unit individually with 3 mm wax rods. Reservoir bars should be a minimum of 4 mm in diameter and vent rods 1 mm if used. Avoid sharp joints and ensure all shoulders and edges are well rounded. Stress relieve the wax pattern by immersing it in water at 32 °C for 5 - 10 minutes.

INVESTMENT

Only use suitable high temperature investment powders that are described as graphite or carbon free. Invest the wax pattern according to the manufacturer's instructions.

BURN OUT AND PRE - HEAT

Follow normal procedures for wax burn out and then heat the investment according to the manufacturer's instructions. Heat soak the casting ring for a minimum of 40 minutes at 900°C. Time necessary to successfully heat soak the casting ring increases with size.

CASTING

Always melt **ANGLOBOND** in ceramic crucibles.

Clean scrap may be reused provided a minimum of 50% new metal is in the charge. NEVER reuse metal if contamination with carbon or other alloys is suspected. A little Tenacity 125 flux added to the melt immediately before casting will improve overall cleanliness. Ensure the alloy is fully liquid and spinning before casting. The time taken to reach both melting and casting temperature must be kept to a minimum and the alloy cast promptly. Over heating the metal results in miscasts and porosity. If using an oxy-propane torch to melt the metal, the flame must be correctly adjusted to avoid contamination by carbon.

Allow the castings to bench cool. **DO NOT** quench the metal as this may cause fitting problems later on.

Finally clean the castings in steam, acetone or by ultrasonic cleaner The use of strong acids such as HF is not advised.

DEGASSING AND OXIDATION

These two procedures can be combined by heating at 960 °C for three minutes in vacuum followed by further heating at 960 °C for three minutes in air. Correctly oxidised, **ANGLOBOND** should have a uniform charcoal grey colour. If patchy, strip the metal and re-oxidise.

Lighter porcelain shades can be achieved whilst retaining bonding strength by degassing the metal, oxidising, stripping away the oxide layer by sand blasting with 125µm aluminium oxide, and applying a pre-opaque wash to the clean metal surface.

Following one of the above methods the castings should always be cleaned in hot water or by ultrasonic cleaner prior to the porcelain being applied.

PORCELAIN APPLICATION

Porcelain bonding will benefit from the application of a pre-opaque wash. Both this and Porcelain application should be carried out as specified by the supplier and with consideration to the furnace used. **NOTE** Re-glazing or excessive baking is not recommended with this type of alloy as this may result in the porcelain cracking.

ANGLOBOND requires a short cooling cycle after porcelain firing.

SOLDERING

Any soldering is best performed prior to bonding with Mattiflo 1110W.

For Post bonding soldering please contact the sales office for both solder and the relevant data sheet.

Caution: *Suitable protective clothing and the wearing of safety glasses is recommended when melting this product.*

CLEANING

Break out the metal and clean by brushing or by sand blasting with non-recycling aluminium oxide. Prepare the surface of the metal with pink or brown stones kept solely for use on **ANGLOBOND** Use of worn diamond stones or those used for other alloys causes bonding problems due to contamination.

No special storage requirements.