Argenco 333

"Argenco 333 Is a type IV, white colour casting alloy."

Composition

Pd	Ag	Ir	Cu	Zn
33.34%	48.06%	<1.0%	16.9%	1.6%

Technical Data

Type	Melting Range °C	Modulus of Elasticity MPa	Density gm/cc
IV	950-1010		10.6

Vickers Hardness DPN		Yield Stress MPa (0.2% offset)		Tensile Stress MPa		Elongation %	
S	H	S	H	S	H	S	H
210	230	482	606	641	723	10	7

Solders

Solder	830W	Argesol R

Laser Wire

Laser Wire	LWO 33

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*Note the colour of this card in no way represents the colour of the alloy.

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Argenco 333 Is a type IV, white colour casting alloy. Its micro-fine grain structure and superior physical properties permit the fabrication of inlays, onlays, posts, single crowns and multi-unit bridges. The economic attractiveness of this gold-free alloy is further enhanced by its low density.

Instructions for use:

Spruing	Single:	Use direct spruing with adequate reservoirs. Use 2.5 mm to 3.5 mm diameter sprues, 10 – 15 mm in length.
	Multiple:	Use indirect spruing with 4.0 mm diameter reservoir bars. Use 2.5 mm diameter sprues from the crowns to the reservoir bar and 3.5 mm diameter sprues from the reservoir bar to the sprue former cone.
Investment:		A high quality phosphate-bonded investment is required. Follow the manufacturer's instructions.
Burnout:		After adequate bench setting, place the invested ring into a room temperature furnace and raise the temperature to 430°C and heatsoak for 20 minutes. Then raise the temperature to 700°C and heatsoak for 30 minutes.
Melting:		It is recommended to use a quartz crucible using a gas/air torch with a multi-orifice tip. Cast as soon as the ingots pool together and roll in the crucible. If using an induction casting machine, set the temperature to 1125°C and melt in a graphite-lined crucible. Be careful to avoid overheating the alloy. Do not use flux. After casting, allow the ring to bench cool before devesting. Add 50% new alloy to the clean buttons.
Pickling:		Do not use any pickling solution. Microblast only.
Finishing:		Lightly grind the alloy with aluminum oxide stones, sintered diamonds or carbide burs. After grinding, use rubber wheels or bristle brushes with polishing paste.
Polishing:		Polish to a high lustre using impregnated polishing wheels or a woollen mop with polishing paste. Finally clean in a recommended solution in an ultrasonic cleaner for 5 minutes.

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