

Argenco 60S

“Argenco 60S is a type IV, yellow colour crown and bridge alloy.”

Composition

Au	Pd	Ag	Ir	Cu	Zn	In
60.0%	3.5%	21.75%	<1.0%	13.49%	1.0%	<1.0%

Technical Data

Type	Melting Range °C	Modulus of Elasticity MPa	Density gm/cc
IV	860-905	-	13.7

Vickers Hardness DPN		Yield Stress MPa (0.2% offset)		Tensile Stress MPa		Elongation %	
S	H	S	H	S	H	S	H
180	270	366	662	476	738	25	10

Solders

Solder	Argesol 720	Argesol Lo
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Laser Wire

Laser Wire	LWO 56
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Argenco 60S

Argenco 60S is a type IV, yellow colour crown and bridge alloy. Its micro-fine grain structure and superior physical properties permit the fabrication of inlays, onlays, full cast crowns, short and long span bridgework.

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 gypsum-bonded investment is recommended. (Phosphate-bonded investments may be used). Follow the manufacturer's instructions.
Burnout:		After adequate bench setting, place the invested ring into a room temperature furnace and raise the temperature to 650°C for gypsum-bonded investments, or 700°C for phosphate-bonded investments. Heatsoak for 30 minutes.
Melting:		It is recommended to use a quartz crucible using a gas/air torch with a multi-orifice tip. If using an induction casting machine, set the temperature to 1010°C and melt in a graphite-lined crucible. The alloy melts readily, so avoid overheating the alloy. Borax flux may be used. 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