



PRODUCER OF SPECIAL ALLOYS SINCE 1975

MAGNUM H75 CE 0123

Cobalt based dental alloy for prostheses, Type 5* (*According to ISO 22674:2016)

The alloy MAGNUM H75 is distinguished by an outstanding fluidity, which allows the alloy to fill even the thinnest details of the frame, down to three tenth of a millimeter (3/10mm). Its molecular structure allows you to obtain a smooth, compact surfaces with little oxide formation.

MAGNUM H75 is produced in conformity with standards ISO 22674:2016, it is highly corrosion resistant and is free of toxic elements like beryllium, indium and gallium.

INSTRUCTIONS FOR USE

Modeling

Keep a thickness not less than 0.6mm, so you can get finished parts up to 0.3mm thick. Avoid elbows, and be careful not to incorporate impurities during waxing.

Casting Sprues

Use direct casting sprues of 3.5-4mm diameter.

Casting

Cast MAGNUM H75 alloys in pre-heated and cleaned ceramic crucibles used for this alloy only. Each should have its own crucible; do not overheat the alloy and no use the flux.

Reach a temperature between 950 and 1050°C, maintenance time in pre-heated oven depends on investment characteristics and on the dimensions of the cylinder.

Induction Casting: Start the casting when cylinders melt together and just before the superficial crust opens.

Open Flame Melting: place ingots in the pre-heated ceramic crucible and heat them evenly with circular movements. When ingots have melted, start centrifugal unit. Use multi-flame welding torches only. Do not use any flux.

Indicative values for flame regulation:

Acetylene 0.4 bar/ Oxygen 2 bar

Propane 0.2 bar/Oxygen 2 bar

Manufacturing

Let the cylinder cool down at room temperature, remove the investment and sandblast with aluminum oxide between 110 to 150 um at a pressure of 3-4 bar. Continue manufacturing process using tungsten carbide burs.

Re-use of Sprues

The best results are obtained with pure MAGNUM H75. It is nonetheless possible to re-use sprues and cones only once, given that new metal from the same lot is added in equal quantity.

Soldering

We suggest using our MAGNUM MAGNUM SALDATURA Co to weld.

Waste Disposal

The processing scrap must be disposed of as a special waste in accordance with the EG directive 2008/98/CEE on waste, and 94/62/CEE on packaging and packaging waste and in compliance with national legislation in force on the subject.

SAFETY INSTRUCTIONS

- Cobalt-Chrome based alloys can seldom cause dermatitis on sensitive subjects. A patch-test is thus advisable.
- Metals dusts and smoke are dangerous for health. Use exhaust fans while casting and polishing.
- Before prosthesis application verify if other metals implants are in patients oral cavity. Coexistence of different metals cause a "pile" effect.
- We identify every bath with a number. We recommend to write it down in patients file to allow its complete traceability.
- This product does not need any special preservations precautions. MESA keeps batch traceability for 15 years.
- It is recommended that the patient be made aware of the possibility for dental alloys to affect MRI Results

Exclusive Distribution of MESA alloys in Malaysia by:



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