



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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