

Process Instructions for Robur 400®

Partial Alloy

Robur 400® is an extremely pure model cast alloy on cobalt base, exclusively made of fresh and pre-tested ore. This is an important requirement for high histocompatibility. It goes without saying that our alloy meets DIN EN ISO 22674 and is conform to the CE-specification.

Robur 400® Highest mechanical features and best cast ability make room for individual and esthetical denture creation. Simple elaboration as well as good polishing- and gloss results are typical.

The ingredients have proved its worth over years

According to DIN EN ISO 6871-1

Manufacturing and testing according to ISO 9001:2000

Embedding:

Robur 400® compatible with all model cast embed masses usual in the trade.

Casting:

Robur 400® will be melted in a ceramic melting pot until the last cube is collapsed, then insert muffle into the centrifuge and melt the alloy until the shade is disappeared in the center, art cast procedure after 2-3 seconds. After the cast the muffle has to be cooled to room temperature and outbedded. Don't use water bath.

Don't use graphite crucible!

Open melting:

With acetylene/oxygen. The instructions of the burner manufacturer need to be noticed. A careful adjusted flame prevents the soiling of the alloy.
Don't use flux.

Soldering:

Solders as usual in the trade can be used for **Robur 400®**

Cleaning:

Robur 400® will be cleaned in ultrasonic bath or with steam jet cleaning.

Guarantee:

All recommendations are based on our own experiences. The user is responsible for correct use and processing. If nevertheless the claim for compensation should be asserted, this is only related to the value of goods that have been delivered.