

# Casting Recommendations for Degutron® eco

Alloy group	Example / Exception	Power	Heat-soaking
High gold ceramic alloys for high fusing ceramics to be molten in graphite crucibles	<b>Examples:</b> BiOcclus® Kiss, Degudent® H, Degudent® U94	P080	5 s
	<b>Exceptions:</b> Fe containing alloys like Degudent® U	P070	15–20 s
Gold reduced and palladium basis ceramic alloys for high fusing ceramics to be molten in ceramic crucibles	<b>Examples:</b> Pors-on 4 Degupal® G, Econolloy® Pd, Deva® 4	P090	5 s
GoldenGate System, ceramic alloy for low fusing ceramics, universal alloys (graphite crucible)	<b>Examples:</b> Degunorm® alloys	P070	5 s
Eco ceramic alloys for low fusing ceramics (Gold or silver basis)	Econolloy® Au, Econolloy® Ag, Degulight® and Econolloy® in graphite crucible	P070	5 s
	Econolloy® Ag, Degulight® and Econolloy® in ceramic crucible	P070	5–10 s
Crown and bridge alloys (graphite crucible)	<b>Examples:</b> Degulor® alloys, Stabilor® alloys	P070	5 s
Non precious alloys (ceramic crucible)	<b>Examples:</b> StarLoy® C, Biosil® f, Biosil® l (always use reduced vacuum)	P100	5 s
	<b>Exceptions:</b> W containing alloys like StarLoy® soft	P100	5–10 s

## Special recommendations:

- The minimum material quantity yields 10 g in a graphite crucible and 15 g in a ceramic crucible respectively 2 ingots of CoCr alloy.
- When using a ceramic crucible for precious metal, glaze crucible wall with flux powder.
- Use flux agent when casting precious metal in a ceramic crucible.
- To enable the coupling of the inductive field into the metal the ingots should be laid parallel to the bottom of the crucible. Do not wedge the ingots in the crucible because heated metal expands and can crack the crucible.
- If the material does not fit into the crucible at once, divide the cast into two steps: First melt one half of the material followed by pressing stop. Add the second half of the material, insert the preheated mould and start the second melting process and finally cast.
- The standard casting chamber pressure is 2 bar.
- Using alloys which tend to spark during vacuum, reduce vacuum by pressing “Start” for a second time after reaching a pressure below -0,4 bar.
- Remove residual alloy and slag out of the crucible to avoid sparking.

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