

INSTRUCTIONS

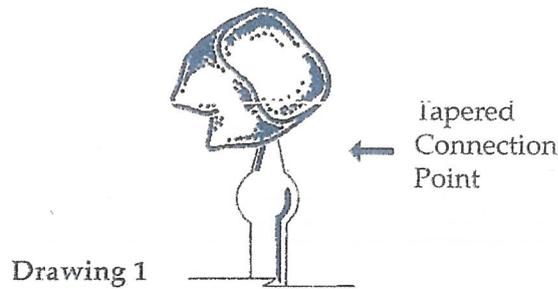
NPG and NPG+2 are a new class of dental casting alloys. Read and follow the instructions closely, specifically the burnout and casting procedures. If you have any questions or difficulties please call our toll free number (800-227-1332) for technical assistance.

APPLICATIONS

- FMC Crown & Bridgework
- Onlays
- Posts & Cores
- Sub-Structure for Polymer C&B Resins

SPRUNG SINGLE UNITS: Use a direct sprue with a reservoir and connect the sprue to the thickest area of the wax pattern. The connection point between the wax pattern and the sprue should be tapered (*reference drawing No. 1*).

SPRUNG BRIDGEWORK: Use an indirect (runner bar) spruing technique. The connection points between the wax pattern and the sprues should be tapered (*reference drawing No. 1*).



INVESTING: Use a high heat phosphate bonded investment.

BURNOUT: The investment heat-soak temperature range for NPG is 1,600 °F to 1,700 °F (871 °C - 927 °C). Consult the "Heat-Soak Time Table" for the minimum heat-soak period requirement.

HEAT-SOAK TIME TABLE

# OF UNITS/RINGS	HEAT-SOAK PERIOD
<i>Small Single Unit Ring</i>	<i>1 hr. 10 min.</i>
<i>Two/Three Unit Ring</i>	<i>1 hr. 30 min.</i>
<i>Four/Five Unit Ring</i>	<i>1 hr. 50 min.</i>
<i>Two Rings in the Oven</i>	<i>add 20 min.</i>
<i>Three Rings in the Oven</i>	<i>add 40 min.</i>
<i>Four Rings in the Oven</i>	<i>add 1 hr.</i>

Page 1

⚠ **CAUTION!** This alloy contains nickel and should not be used for individuals with a known nickel sensitivity.

⚠ **ATTENTION!** Do not breathe dust or fumes generated by mechanical, thermal, or chemical processing. All processing should be done in accordance with good industrial practices, including vacuum for grinding, exhaust fans for thermal processing in compliance with State and Federal standards and procedures.