

**CEKALLOY MC**

**Hard Co-Cr-Mo-based alloy for the model casting technique.  
The superb strength and high precision make this alloy  
the best choice to combine with attachments,  
implant-supported removable prostheses or reinforcements.**

**nickel- and beryllium-free**

**CHEMICAL COMPOSITION**

Co %	Cr %	Mo %	W %	Mn %	C %	Si %	Fe %	Other %
~ 62	~ 29	6	1.0	0.6	< 0.5	0.4	< 1.0	< 0.1

This alloy is contraindicated for patients with a history of sensitivity to cobalt and chromium.

**TECHNICAL DATA**

Density: 8.3 g/cm<sup>3</sup>  
 Melting point (Solidus/Liquidus): 1355-1390 °C (2471-2534 °F)  
 Casting temperature: 1450 °C (2642 °F)  
 Hardness: 410 HV 10  
 Tensile strength: 900 N/mm<sup>2</sup>  
 Extension: > 6 %

ISO 9693 / ISO 22672

## STEP BY STEP INSTRUCTIONS

### Wax-up and sprueing

For optimal results, wax-up no thinner than 0.5 mm.

Always use sprues with reservoir on pontics and full cast crowns.

Distance between reservoir and casting should not exceed 2 mm.

### Investing

Use phosphate-bonded investment.

Preheating temperature of 950 °C (1742 °F) is recommended. Maintain temperature for one hour.

### Casting

- Melt in a ceramic crucible. Do not use graphite inserts.
- Flame melting: propane/oxygen or acetylene/oxygen. Do not use flux. Cast when the ingots slump, deform or roll from pressure of flame. Avoid the oxide skin to burst!
- Induction casting: casting when all ingots have slumped into a molten mass. Avoid the oxide skin to burst.
- Bench cool the muffle.

### Recommendation for single use

We do not recommend the reuse the removed sprue cones as the characteristics of the alloy can be changed.

### Safety information

Metal dusts and fumes are dangerous to your health. Therefore we suggest to wear a respiratory mask and to use suction when melting, grinding, and sandblasting.