

Post Soldering Technique for Talladium Tilite® Alloys

Invest as you would for any post solder case. Use Talladium's Post Solder (#201) and Post Solder Flux (#701). This flux/solder combination was formulated to flow at a temperature below the vitrification temperatures of porcelains, so the flux will not stain the porcelain.

TECHNICAL INSTRUCTIONS

Applications

- Tilite
- Tilite to Ceramic Golds
- Tilite to Crown and Bridge Golds

Joint Preparation

After the bridge is cut, roughen the joint area with a T-2 Diamond or T-5 Green Stone. For full porcelain bridges adjust contacts 0.3-0.4mm. Use sticky wax and a dowel pin to stabilize the bridge on the model. Avoid placing wax or Duralay in the joint area.

Invest

Flow white utility wax or Talladium's Galileo™ Pressable Wax over the porcelain that will be in contact with investment. Invest with Easy-Stack Soldering Investment, and let set for 20 minutes.

Boil-out & Dry

Steam or pour boiling water over the invested case to eliminate all the wax. Place the case in drying oven or in front of porcelain oven for two hours.

Make sure soldering paddy is thoroughly dry. Residual moisture will prohibit a rise in temperature above 212°F / 100°C. Solder will not flow until the moisture is completely purged.

Cool to room temperature. Place a thin film of Post Solder flux in the joint then lay 2mm length pieces of solder.

Solder

Dry in front of porcelain oven door for five minutes. Place case into porcelain oven at 1000°F / 538°C. Raise the temperature at a rate of 80°F / 44°C per minute to 1400°F / 760°C no vacuum and hold this temperature until solder flows.*

If additional solder is needed, open the oven door and lay more solder into the joint. Remove case from oven and cool to room temperature.

*If the porcelain oven does not have a view window, hold for approximately:

2-5 Units	20 seconds
6-9 Units	40 seconds
Round House	1 minutes



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