

# Soldering Investment Instructions

## Hi-Heat

**Hi-Heat** is ideal for any soldering job that requires an oxygen-gas torch, or where an unusually fine and smooth soldering investment is wanted. Excellent with high-fusing solder in the porcelain fused to gold technique and for soldering precision attachments.

**Note:** Hi-Heat Soldering Investment does not have the strength of conventional soldering investments so reasonable care must be used in handling the invested case. Allow a minimum of 20 minutes after investment becomes rigid, before de-waxing.

1. Hand mix water and powder in a ratio of 28 ml water per 100 grams of investment powder. You will have two (2) to four (4) minutes of working time.
2. Invest the inside of the crown or coping and then seat in a patty or mound of Hi-Heat Soldering Investment. (If using for the 'post-solder' technique on Porcelain Fused to Metal crowns and bridges; make sure that you coat the porcelain with wax, so that it does not come in contact with the soldering investment).
3. Allow a minimum of twenty (20) minutes after investing to bench set (wait time).
4. After bench set, trim the excess investment to within 6 mm of the castings around the entire periphery. Reduce the base to a maximum of 9 mm thickness.
5. De-wax using steam or a low flame, taking care not to dislodge the pattern from the investment. Wax on the porcelain should be removed, leaving a space between the porcelain and the investment.
6. Place the invested case in a room temperature burnout oven. Raise the temperature to 650 C (1200 F) at a rate of 10 C (25 F) per minute and hold for 10 minutes.
7. Remove the soldering patty from the oven and transfer to a tri-pod or porcelain furnace (for post-solder technique, set entry temp at 650 C) to continue process.
8. Solder according to alloy manufacturer's instructions for torch or oven post-solder technique.

