

## Instructions for Use

Gramm Galvanobonder optimizes the compound between the electroforming gold and the porcelain. Gramm's Galvanobonder consists of gold and porcelain particles.

### Mixing instruction

Mix gold powder and liquid to a creamy consistency.

### Working instructions

**1**

Sandblast the electroformed items with 50µm aluminum oxide at 2 bar and fit them to the master dies. After that, the items are cleaned for 10 minutes in an ultrasonic bath containing hot, distilled water. Then let dry; or put the electroformed items into alcohol for 2 minutes after steamcleaning - let airdry, do not use compressed air!

**2**

A refractory plaster die, made out of GES die material (art. No. 901.00.061), serves as working die.

**3**

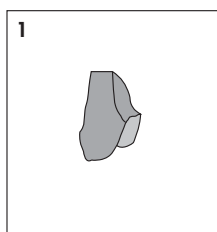
Mix the Galvanobonder thickly and apply a thin layer onto the electroformed items. Let airdry for 10 minutes. Then, let dry the items for 10 minutes in front of the open firing chamber and dry the Galvanobonder at 540°C with open chamber for another 10 minutes.

**4**

Galvanobonder is baked at 940 - 950°C with a heat rate of 50 - 60°C per minute, no vacuum or delay required. After the bonder bake, leave the items inside the open firing chamber to cool down. Steamclean the electroformed items before you apply the opaque.

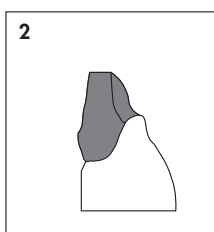
### Important

See to it that the brush is always clean; clean it with alcohol if required. If bubbles appear when layering the porcelain facing, this points to a dirty sandblasting agent.

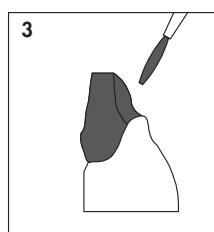


**Cleaning the framework**  
Use 50µm aluminum oxide at 2bar (30 psi) to sandblast the electroformed item (do not use a circulating unit!). Adapt it to the master die.

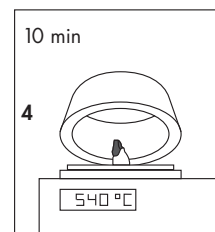
Then put it into an ultrasonic bath of hot, distilled water for 10 minutes. Let dry; or steamclean the electroformed item and put it in alcohol for approx. 2 minutes and let it airdry (do not use compressed air!)



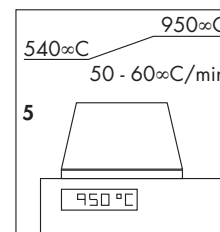
**GES die material**  
A working die made of refractory die material (art. No. 910.00.061) allows easier handling of the GES item.



**GES Bonder**  
Mix Gramm's GES Galvanobonder and apply a thin layer on the surfaces to be faced.



**Bonder bake**  
Let airdry the bonder for 10 minutes. Then let it dry in front of the open firing chamber for another 10 minutes. Bake the Galvanobonder at 540°C in the open firing chamber for 10 minutes to ensure complete drying.



Heat rate: 50 - 60°C per minute (100°- 140°F/min). Bake (fix) at 950°C (1750°F). No vacuum, no delay necessary.



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