

Pre Soldering Technique for Talladium Tilite® Alloys

Invest as you would for any post solder case. Use Talladium's Pre Solder (#200) and Pre Solder Flux (#700). This flux/solder combination was formulated to eliminate the individual oxide in the Talladium Tilite Alloys during soldering.

TECHNICAL INSTRUCTIONS

Applications

- Tilite Alloys

Joint Preparation

After cutting the joint to be soldered, rough up the joint area with a T-2 Diamond. Grind the area that was cut as well as the perimeter around the joint, eliminating all sharp corners and edges. The clearance of the joint should be approximately 1 mm. Use Zapit and a dowel pin to stabilize the bridge on the model. Do not use Zapit or Duralay in the joint area. Place a small piece of red utility wax underneath the joint after it has been taken off the model.

Invest

Flow a thick mixture of Talladium's Easy Stack High Heat Soldering Investment into the coping and set the case on a patty. Bench set for a half hour, trim the patty down, and place it into the burnout oven at 1000°F / 538°C for 20 minutes.

Torch Adjustments

Using Talladium's Soldering Torch, set the oxygen regulator at 2-4 lbs. If using Propane, set the regulator at 1 psi and draw the flame out to 4 - 5 inches. Introduce the oxygen until the center cone stops expanding - approximately 1/8 - 1/4" in length.

Flux Preparation

Stick the soldering rod into the jar of flux and gather a generous amount to the tip. After the flux is on the solder rod, slightly tease the moisture out using the flame of the torch.

Application Flux/Solder

After the joint is brought up to a bright orange-red hue, touch the solder rod with flux on end to the lingual of the joint. Pull the solder rod back and allow the flux to work the joint for 2 seconds, then introduce the solder rod.

Finishing

Thoroughly sandblast the area with aluminum oxide, shape and expose the fresh metal around the joint with a silicon carbide disc or a porcelain finishing disc.



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