

## CASTING-TO AN ID FEMALE

The prefabricated precious metal ID female offers retention and lateral stability to the prosthesis.

The **RE 0053 IR (M2) / 703 D (M3)** (IRAX 1400-1460 °C / 2552-2660 °F) can be cast-to  
(**only** with precious and palladium-based alloys) or soldered.

1. Determine the path of insertion of the prosthesis (see INFO 079).
2. The proximal area where the female will be positioned must allow for the incorporation of the **intracoronal** sliding part into the contour of the crown.
3. Press the **P 9** paralleling mandrel into the sliding part and activate if necessary.
4. Position the female in its correct position over the papilla on the crown.
5. Adapt the proximal area of the abutment crown for optimum incorporation of the sliding part.
6. Attach the female to the crown and remove the **P 9** paralleling mandrel after the wax is hard.
7. Finish the wax pattern of the abutment retainers.
8. Apply the sprues.
9. With an appropriate instrument cut a small slot along the metal backplate in the wax pattern to prevent metal from overflowing.
10. Keep debubbler off the metal female.
11. Carefully invest and avoid air-entrapments.
12. Allow the casting ring to bench cool slowly after casting.
13. Carefully deinvest without damaging the female – **DO NOT SANDBLAST!**
14. Only use plastic beads to remove the investment material from the female under light pressure.