

Vision-Bonding Instruction for Use



Important: Read manual before using Vision-Bonding.

What is Vision-Bonding

Vision-Bonding is a bonding agent, consisting of porcelain and metal oxides.

The Bonding neutralises the metal surface.

Depending on layer thickness and alloy composition, Vision-Bonding has a yellowish slightly shining appearance after firing.

This is various between different alloys.

Vision-Bonding is ready to use.

Vision-Bonding advantages

Excellent bond between porcelain and alloy.

An exceptionally good temperature alternation resistance brings a high security.

The bonder serves as a buffer between alloy and ceramics (CTE reconciliation).

Eliminates wash bake.

Pay attention to

Alloy conditioning according to manufacturer's recommendation.

We recommend you testing with alloys used.

Mix good before use.

Dried out material cannot be used, or remixed.

Processing

1. Process alloy as usual with carbides.
2. Sandblast surface with aluminous oxide (110- 250µm).
3. Oxidize as recommended and after oxidation sandblast again
4. Clean surface with steamer.
5. Apply Vision-Bonding with Vis-Opaque-brush as a thin covering layer.
6. After bonding cycle, proceed to porcelain manual.

Firing parameters

Start temperature	:	550°C / 1022°F
Dry time	:	6 Min.
Heat rate	:	80°C/ 176°F Min
Vacuum	:	Yes
Final temperature	:	980°C / 1796°F
Hold	:	1 Min.