

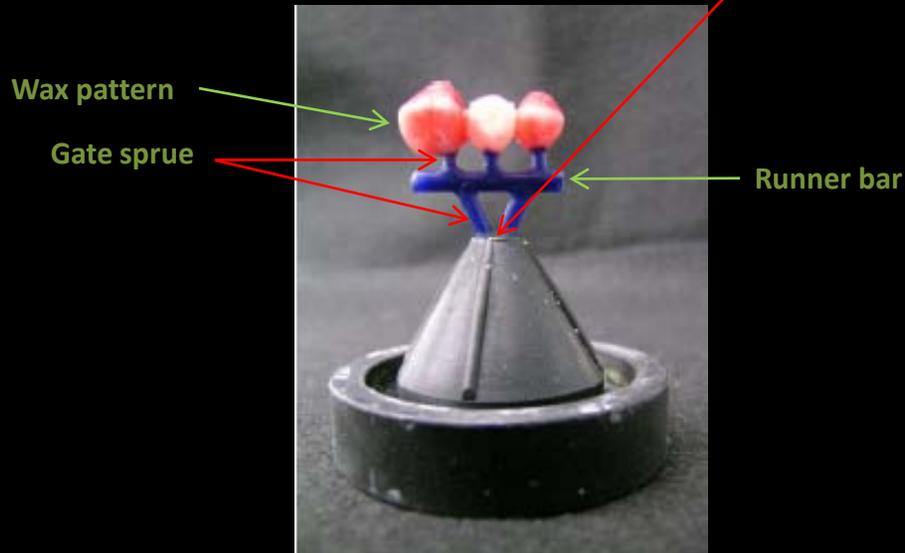


Fabrication of Spruing

General Spruing Suggestions

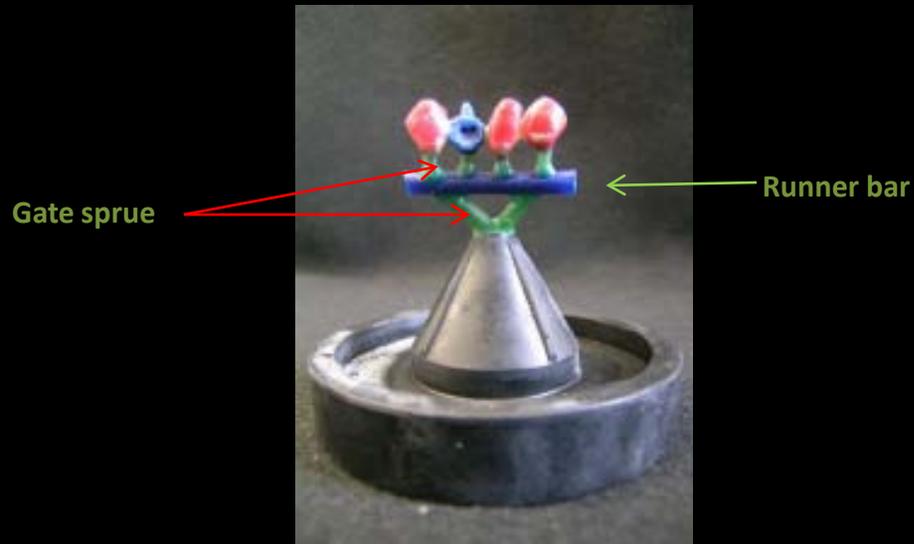
- **Wax pattern** should be sprued as thick (0.4mm~) and in short distance as possible
- **Runner bar** 3.0 – 3.5mm diameter
- **Gate Sprue** 2.0 – 2.5mm diameter, (3mm) in length, to be sprued with each neighboring crowns and bridge pattern

Important !* • **Sprues have to be centered to one place

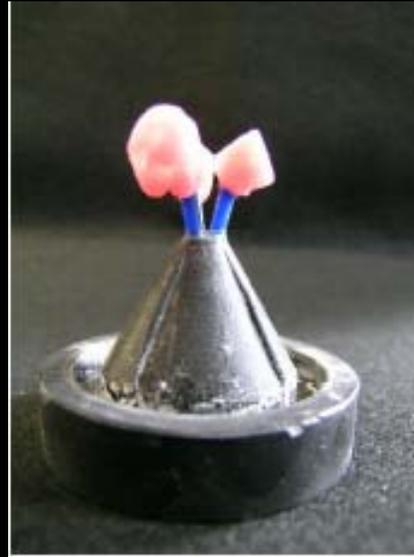


Spruing Bridge Patterns

We recommend you to attach a runner-bar on the gate sprue and connect all patterns including pontics with gate sprues. Even in case of long span bridge, positioning of patterns and sprue cone possibly at a short distance is recommended.



Spruing Example



Spruing Example



Miscast



- Gate sprues are too long
- Insufficient burnout
- Insufficient amount of alloy

- No runner bar

- Insufficient pressure
- Insufficient burnout

Miscast

**Important !*



- No gate sprue below runner bar
- Insufficient amount of metal



- Gate Sprues must be concentrated and gethered in one spot (Center)**



Pressure must enter from one point



- No gate sprue below runner bar