

## Technical sheet - Alloy 265

Color - European Yellow

Purpose - Casting

Karat - 9K - 14K

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*	10K 265	11.29	10K 265	144
Cu	59.2%	10K 265	91.08	-0.04	19.48	14K 265	12.81	14K 265	165
Ag	20.8%								
Zn	19.5%								
In	0.5%								

### Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	9K - 14K	1010° - 1040° C	1850° - 1910° F
Casting	10K	910° - 930° C	1670° - 1706° F
	14K	895° - 910° C	1643° - 1679° F
Flask	9K - 14K	580° - 700° C	1076° - 1292° F
Quench Time	20-25 Minutes	Remelting	35%-50% Fresh Mix

### General Instructions

- Very little *boric acid* flux is recommended. Do not use carbon flux such as soda ash, saltpeter etc. No flux needed in bottom pour automatic casting unit.
- *Flouric based* investment removers are the best for silicon oxide invisible coating. Use of aggressive acid causes corrosion and surface damage. *United's brite cast* investment removers works effectively.
- To calculate the weight of the metal needed (in grams), *multiply density (gm/cc) with weight of wax (grams)*. Add 10% of the total weight for button.
- *Gypsum bonded* investment is recommended. Follow manufacturer's instruction for burnout cycle.

**Note:** There are proprietary metals in the formulation which are not included in the composition section.

**Technical Assistance:** Always available... Call 1-800-999-3463 / 1-800-999-FINE

E-mail / [techteam@unitedpmr.com](mailto:techteam@unitedpmr.com) Web-Site / [www.unitedpmr.com](http://www.unitedpmr.com)