

Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	25.50%	14K 269	92.66	-0.75	21.76	14K 269	13.93	14K 269	153
Ag	74.00%								
Zn	0.50%								
Ni	0.00%								

Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	14K	1010° C - 1040° C	1850° F - 1910° F
Casting	14K	945° C - 965° C	1732° F - 1768° F
Flask	14K	510° C - 650° C	950° F - 1202° F

Quench Time	20-25 Minutes
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Remelting	35% - 50% Fresh Mix
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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

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