

Technical sheet - Alloy T1

Color - Greenish Yellow Purpose - Casting Karat - 9K - 14K

Physical & Mechanical Properties										
Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)		
Cu	70.0%	Karat	L*	a*	b*	10K T1	11.03	10K T1	111	
Ag	6.0%	narut		5	-	101(11	11.00	101111		
Zn	24.0%	10K T1	90.63	0.68	21.43	1 <i>11</i> T1	12 56	1 <i>4K</i> T1	178	
Ni	0.0%	14K T1	88.08	2.5	20.43	141 11	12.50	14K 11	1/0	
	Cu Ag Zn	Cu 70.0% Ag 6.0% Zn 24.0%	Cu 70.0% Karat Ag 6.0% 10K T1	Composition Color Coor Cu 70.0% Karat L* Ag 6.0% 10K T1 90.63	Composition Color Coordinate Cu 70.0% Karat L* a* Ag 6.0% 10K T1 90.63 0.68	Composition Color Coordinates Cu 70.0% Karat L* a* b* Ag 6.0% 10K T1 90.63 0.68 21.43	Composition Color Coordinates Density Cu 70.0% Karat L* a* b* 10K T1 Ag 6.0% 10K T1 90.63 0.68 21.43 14K T1	Composition Color Coordinates Density (g/cc) Cu 70.0% Karat L* a* b* 10K T1 11.03 Ag 6.0% 10K T1 90.63 0.68 21.43 14K T1 12.56	Composition Color Coordinates Density (g/cc) As cast Hardness (HV) Cu 70.0% Karat L* a* b* 10K T1 11.03 10K T1 Ag 6.0% 10K T1 90.63 0.68 21.43 14K T1 12.56 14K T1	

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Melting & Casting Instructions

Temperatures										
	Karat	°C	°F							
Pre alloying	10K - 14K	1010° - 1040° C	1850° - 1904° F							
Casting	10K	990° - 1010° C	1814° - 1850° F							
Casting	14K	935° - 955° C	1715° - 1750° F							
Flask	10K - 14K	510° - 650° C	950° - 1202° F							
Quench Time	15 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 aggresive 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.

• <u>Gypsum bonded</u> investment is recommended. Follow manufacurer'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 Web-Site / www.unitedpmr.com