Technical sheet - Alloy 320

Color - Standard yellow
Purpose - Casting
Karat - 9K - 14K

Physical & Mechanical Properties

Composition	
Cu	59.0%
Ag	36.0%
Zn	5.0%
Ni	0.0%

Color Coordinates			
Karat	**L***	**a***	**b***
10K 320	88.26	4.22	18.72
14K 320	88.5	4.69	20.44

Density (g/cc)	
10K 320	11.87
14K 320	13.13

As cast Hardness (HV)	
10K 320	148
14K 320	183

Melting & Casting Instructions

Temperatures			
	Karat	**°C**	**°F**
Pre alloying	9K - 14K	1010° - 1040° C	1850° - 1910° F
Casting	10K	905° - 925° C	1661° - 1697° F
	14K	910° - 930° C	1670° - 1706° F
Flask	9K - 14K	510° - 650° C	950° - 1202° F

Quench Time	15-30 Minutes

Remelting	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.
• Gypsum *bonded* 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
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