

Color - Dark Yellow

Purpose - All Purpose

Karat - 20K - 22K

Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	67.00%	22K 385	85.00	7.52	23.28	22K 385	17.62	22K 385	109
Ag	15.00%								
Zn	10.00%								
Ni	8.00%								

Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	22K	1100° C - 1130° C	2012° F - 2066° F
Casting	22K	1035° C - 1055° C	1895° F - 1931° F
Flask	22K	510° C - 675° C	950° F - 1248° F

Quench Time	15 - 20 Minutes
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Remelting	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](tel:1-800-999-3463) / [1-800-999-FINE](tel:1-800-999-FINE)

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