

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	20.00%	10K 575	93.5	-1.91	15.38	10K 575	12.48	10K 575	159
Ag	78.00%	14K 575	92.84	-2.38	19.63	14K 575	13.89	14K 575	141
Zn	2.00%	18K 575	90.61	-1.11	26.77	18K 575	15.65	18K 575	96
Ni	0.00%								

### Melting & Casting Instructions

Temperatures				
	Karat	°C	°F	
Pre alloying	9K - 18K	1040° - 1050° C	1904° - 1922° F	
Casting	10K	920° - 940° C	1689° - 1725° F	
	14K	965° - 985° C	1769° - 1805° F	
	18K	975° - 995° C	1787° - 1823° F	
Flask	9K - 18K	510° - 650° C	950° - 1202° F	
Quench Time	8 - 12 Mins		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 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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