

Technical sheet - Alloy F1

Color - Natural White

Purpose - All Purpose

Karat - 10K - 14K

Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*	10K F1	12.12	10K F1	88
Cu	0.00%								
Ag	84.20%								
Zn	12.50%	10K F1	91.36	-0.73	9.73				
Sn	3.30%	14K F1	92.68	-1.83	12.14	14K F1	13.64	14K F1	86

Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	10K - 14K	1040° - 1050° C	1904° - 1922° F
Casting	10K	930° C - 950° C	1706° - 1742° F
	14K	975° C - 995° C	1787° - 1823° F
Flask	10K - 14K	510° - 650° C	950° - 1202° F

Quench Time	25 - 30 Minutes	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 / 1-800-999-FINE

E-mail - techteam@unitedpmr.com Web-Site - www.unitedpmr.com