

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
Cu	36.00%	Karat	L*	a*	b*	18K PD16	15.70	18K PD16	208
Ag	1.00%								
Zn	12.00%	18K PD16	80.03	2.45	7.92				
Pd	51.00%								

### Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	18K	1200° C - 1220° C	2192° F - 2228° F
Casting	18K	1130° C - 1150° C	2066° F - 2102° F
Flask	18K	540° C - 675° C	1004° F - 1247° F

Quench Time	20-25 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.
- Platinum investment and Platinum casting machine 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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