

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	71.75%	10K VHF3	89.62	2.16	19.79	10K VHF3	11.23	10K VHF3	116
Ag	11.25%					14K VHF3	12.76	14K VHF3	127
Zn	17.00%	14K VHF3	88.46	3.21	19.81				
Ni	0.00%								

### Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	9K - 14K	1000° - 1030° C	1832° - 1885° F
Casting	10K	955° - 975° C	1750° - 1786° F
	14K	935° - 955° C	1715° - 1750° F
Flask	9K - 14K	510° - 650° C	950° - 1202° F
Quench Time	20 - 25 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 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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