

## Technical sheet - Alloy 907

Color - Premium White

Purpose - Casting

Karat - 14K - 18K

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	40.0%	14K 907	83.97	-0.443	5.67	10K 907	12.6	14K 907	215
Ag	0.0%					18K 907	14.64	18K 907	233
Zn	20.0%								
Ni	40.0%								

### Melting & Casting Instructions

Temperatures				
	Karat	°C	°F	
Pre alloying	14K - 18K	1080° - 1090° C	1976° - 1994° F	
Casting	14K	1055° - 1075° C	1931° - 1967° F	
	18K	1010° - 1030° C	1850° - 1886° F	
Flask	14K - 18K	540° - 675° C	1004° - 1247° F	
Quench Time	8 - 10 Minutes		Remelting	70% 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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