Technical sheet - Alloy 920

Color - Medium White
Purpose - Casting
Karat - 9K - 14K

Physical & Mechanical Properties

Composition	
Cu	55.70%
Ag	0.80%
Zn	17.50%
Ni	26.00%

Color Coordinates			
Karat	**L***	**a***	**b***
10K 920	87.44	-0.194	10.16
14K 920	87.83	0.5	11.25

Density (g/cc)	
10K 920	10.91
14K 920	12.45

As cast Hardness (HV)	
10K 920	150
14K 920	176

Melting & Casting Instructions

Temperatures			
	Karat	**°C**	**°F**
Pre alloying	9K - 14K	1060° - 1080° C	1940° - 1976° F
Casting	10K	1055° - 1075° C	1931° - 1967° F
	14K	1000° - 1020° C	1832° - 1868° F
Flask	9K - 14K	540° - 675° C	1004° - 1247° F

Quench Time	10 - 12 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 aggresive 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 manufacurer'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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