

Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*	10K 940	11.22	10K 940	142
Cu	61.40%								
Ag	0.00%								
Zn	21.00%	10K 940	84.32	0.55	9.67				
Ni	17.60%	14K 940	86.36	1.02	11.69	14K 940	12.74	14K 940	157

Melting & Casting Instructions

Temperatures				
	Karat	°C	°F	
Pre alloying	10K - 14K	1080° - 1090° C	1976° - 1994° F	
Casting	10K	1065° - 1085° C	1949° - 1985° F	
	14K	1015° - 1035° C	1860° - 1895° F	
Flask	10K - 14K	540° - 675° C	1004° - 1247° F	
Quench Time	15 - 20 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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