

## Technical sheet - Alloy 952

Color - Ultra White

Purpose - Casting

Karat - 9K - 14K

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	51.50%	10K 952	85.22	-0.178	9.180	10K 952	11.22	10K 952	194
Ag	15.50%					14K 952	12.75	14K 952	217
Zn	15.00%								
Ni	18.00%								

### Melting & Casting Instructions

Temperatures				
	Karat	°C	°F	
Pre alloying	10K - 14K	1050° - 1070° C	1922° - 1958° F	
Casting	10K	1055° - 1075° C	1931° - 1967° F	
	14K	1025° - 1045° C	1877° - 1913° F	
Flask	10K - 14K	540° - 675° C	1004° - 1247° F	
Quench Time	15 - 20 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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