

Color - Ultra White

Purpose - Casting

Karat - 9K - 18K

Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	57.50%	10K 974	87.08	0.525	9.77	10K 974	11.19	10K 974	200
Ag	6.50%	14K 974	86.98	0.91	11.33	14K 974	12.72	14K 974	185
Zn	17.00%	18K 974	87.2	1.71	14.06	18K 974	14.74	18K 974	206
Ni	19.00%								

Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	9K - 14K	1055° - 1065° C	1931° - 1949° F
Casting	10K	1020° - 1040° C	1868° - 1904° F
	14K	1015° - 1034° C	1859° - 1895° F
	18K	980° - 1000° C	1796° - 1832° F
Flask	9K - 18K	540° - 675° C	1004° - 1247° F
Quench Time	15-25 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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