

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	53.0%	10K 982	86.16	1.226	11.29	10K 982	11.51	10K 982	180
Ag	20.0%	14K 982	87.53	1.216	11.15	14K 982	13.01	14K 982	220
Zn	10.0%	18K 982	86.86	2.18	14.69	18K 982	14.97	18K 982	208
Ni	17.0%								

Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	9K - 18K	1050° - 1060° C	1922° - 1940° F
Casting	10K	960° - 980° C	1760° - 1796° F
	14K	985° - 1005° C	1805° - 1841° F
	18K	980° - 1000° C	1796° - 1832° F
Flask	9K - 18K	540° - 675° C	1004° - 1247° F
Quench Time	15-25 Minutes	Remelting	60% 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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