

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	59.50%	18K 983	85.69	1.55	13.43	18K 983	14.78	18K 983	199
Ag	10.00%								
Zn	8.00%								
Ni	22.50%								

### Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	18K	1030° C - 1050° C	1886° F - 1922° F
Casting	18K	980° C - 1000° C	1796° F - 1832° F
Flask	18K	540° C - 675° C	1004° F - 1247° F

Quench Time	20-30 Minutes	Remelting	70% Fresh Mix
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### 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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