

Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	55.00%	10K M900	84.73	0.052	8.013	10K M900	11.00	10K M900	196
Ag	0.00%	14K M900	85.54	0.435	9.448	14K M900	12.53	14K M900	206
Zn	20.00%	18K M900	85.91	1.242	12.00	18K M900	14.57	18K M900	224
Ni	25.00%								

Melting & Casting Instructions

Temperatures				
	Karat	°C	°F	
Pre alloying	10K - 18K	1050° - 1070° C	1922° - 1958° F	
Casting	10K	1045° - 1065° C	1913° - 1949° F	
	14K	995° - 1015° C	1823° - 1859° F	
	18K	990° - 1010° C	1814° - 1850° F	
Flask	9K - 18K	540° - 675° C	1004° - 1247° F	
Quench Time	25-30 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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