

Technical sheet - Alloy RM60

Color - Super White

Purpose - Casting

Karat - 18K - 19K

Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
Cu	20.00%	Karat	L*	a*	b*	18K RM60	14.51	18K RM60	305
Ag	0.00%								
Zn	20.00%								
Ni	60.00%								
18K RM60		94.4	0.05	8.1					

Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	18K	1060° C - 1080° C	1940° F - 1976° F
Casting	18K	985° C - 1005° C	1805° F - 1841° F
Flask	18K	540° C - 675° C	1004° F - 1247° F

Quench Time	8 - 10 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

E-mail - techteam@unitedpmr.com Web-Site - www.unitedpmr.com