Technical sheet - T5

Color - Medium White
Purpose - Casting
Karat - 9K - 18K

Physical & Mechanical Properties

Composition	
Cu	68.00%
Ag	0.00%
Zn	16.00%
Ni	16.00%

Color Coordinates			
Karat	L*	a*	b*
10K T5	87.03	0.845	12.01
14K T5	88.06	1.41	12.43
18K T5	86.94	2.48	14.73

Density (g/cc)	
10K T5	11.05
14K T5	12.59
18K T5	14.63

As cast Hardness (HV)	
10K T5	144
14K T5	153
18K T5	194

Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	9K - 14K	1070° - 1090° C	1958° - 1994° F
	18K	1050° - 1060° C	1922° - 1940° F
Casting	10K	1065° - 1085° C	1949° - 1985° F
	14K	1060° - 1080° C	1940° - 1976° F
	18K	980° - 1000° C	1796° - 1832° F
Flask	9K - 18K	540° - 675° C	1004° - 1247° F

Quench Time	12 - 14 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 aggresive 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 manufacurer'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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