

## Technical sheet - Alloy T7

Color - Premium White

Purpose - Casting

Karat - 14K - 18K

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	40.00%	14K T7	85.89	0.64	10.87	14K T7	12.72	14K T7	200
Ag	10.00%					18K T7	88.01	1.63	13.47
Zn	20.00%								
Ni	30.00%								

### Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	14K - 18K	1060° - 1070° C	1940° - 1958° F
Casting	14K	980° - 1000° C	1796° - 1832° F
	18K	995° - 1015° C	1723° - 1859° F
Flask	14K - 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 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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