

Color - Pink

Purpose - Casting

Karat - 14K - 18K

Physical & Mechanical Properties

| Composition | | Color Coordinates | | | | Density (g/cc) | | As cast Hardness (HV) | |
|-------------|--------|-------------------|-------|------|-------|----------------|-------|-----------------------|-----|
| | | Karat | L* | a* | b* | | | | |
| Cu | 87.50% | 14K 544M | 86.16 | 8.71 | 16.28 | 14K 544M | 13.04 | 14K 544M | 139 |
| Ag | 9.0% | | | | | 18K 544M | 14.99 | 18K 544M | 199 |
| Zn | 3.5% | | | | | | | | |
| Ni | 0.0% | | | | | | | | |

Melting & Casting Instructions

| Temperatures | | | |
|--------------|---|-----------------|-----------------|
| | Karat | °C | °F |
| Pre alloying | 14K - 18K | 1050° - 1060° C | 1922° - 1940° F |
| Casting | 14K - 18K | 980° - 1010° C | 1796° - 1850° F |
| Flask | 14K - 18K | 510° - 650° C | 950° - 1202° F |
| Quench Time | 14K - 15 minutes 18K - 2-3 min, button first | Remelting | 50% 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.
- *Fluoric 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 remover 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: Available... Call 1-800-999-3463 / 1-800-999-FINE

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