

Color - Rose Pink

Purpose - Casting

Karat - 14K - 18K

Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	93.50%	14K 551	87.13	11.82	18.59	14K 551	13.00	14K 551	130
Ag	3.5%					18K 551	14.92	18K 551	223
Zn	3.0%								
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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