

## Technical sheet - Alloy 917

Color - Medium White

Purpose - Casting

Karat - 14K

### Physical & Mechanical Properties

Composition		Color Coordinates				Density (g/cc)		As cast Hardness (HV)	
		Karat	L*	a*	b*				
Cu	57.50%	14K 917	85.04	0.61	7.2	14K 917	12.65	14K 917	168
Ag	2.50%								
Zn	19.00%								
Ni	21.00%								

### Melting & Casting Instructions

Temperatures			
	Karat	°C	°F
Pre alloying	14K	1050° C - 1070° C	1922° F - 1958° F
Casting	14K	1020° C - 1040° C	1870° F - 1904° F
Flask	14K	540° C - 650° C	1004° F - 1247° F

Quench Time	15 - 20 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

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