

TECHNICAL DATA SHEET

PLAST220I - 417 ‰

Master alloy for the production of white 375 - 417 - 585 - 750 ‰ gold jewellery obtained by mechanical working. The elements contained in this product ensure a high surface quality and a high deformation capability thanks the small grain structure, making it suitable for the production of hand and machine made hollow and solid chains, deep drawn items and tube.

TAB.1 - Mechanical data

Hardness as cast	141 HV
Hardness hardened	n.d.
Tensile strength	583 MPa
Yield strength	313 MPa
Elongation	31 %

TAB.2 - Physical data

Color	Standard white
Colour Coordinates	L*: 86.71 a*: 1.20 b*: 8.20
Density	10.89 g/cm ³
Melting Range	Solidus: 990 °C Liquidus: 1057 °C

TAB.3 - Heat treatments

Solution annealing	675 °C - 20 min
Recrystallization Annealing	700 °C - 30 min
Hardening	n.d.

TAB.4 - Mechanical working parameters

Premelting temperature	1157 °C
Casting Temperature	Min: 1107 °C Max: 1207 °C
First thickness reduction	Lamination: 50 % Drawing: 25 %
Following thickness reductions	Lamination: 75 % Drawing: 50 %
Pickling after annealing	H2SO4: 20 % Temp: 50 °C - 5 min