

TECHNICAL DATA SHEET

PLAST321 - 417 ‰

Master alloy for the production of yellow 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	130	HV
Hardness hardened	257	HV
Tensile strength	380	MPa
Yield strength	175	MPa
Elongation	42	%

TAB.2 - Physical data

Color	Pale yellow		
Colour Coordinates	L*:	90.58	
	a*:	3.47	
	b*:	17.66	
Density	11.5	g/cm ³	
Melting Range	Solidus:	800	°C
	Liquidus:	879	°C

TAB.3 - Heat treatments

Solution annealing	675	°C
	20	min
Recrystallization Annealing	675	°C
	20	min
Hardening	275	°C
	180	min

TAB.4 - Mechanical working parameters

Premelting temperature		979	°C
Casting Temperature	Min:	929	°C
	Max:	1029	°C
First thickness reduction	Lamination:	50	%
	Drawing:	25	%
Following thickness reductions	Lamination:	75	%
	Drawing:	50	%
Pickling after annealing	H2SO4:	20	%
	Temp:	50	°C
	Time:	5	min