

TECHNICAL DATA SHEET

PLAST322L - 585 ‰

Master alloy for the production of yellow 375 - 417 - 585 - 750 - 875 - 917 ‰ 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	131	HV
Hardness hardened	236	HV
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	Pale yellow		
Colour Coordinates	L*:	89.06	
	a*:	2.9	
	b*:	19.18	
Density	12.94	g/cm ³	
Melting Range	Solidus:	809	°C
	Liquidus:	859	°C

TAB.3 - Heat treatments

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

TAB.4 - Mechanical working parameters

Premelting temperature		959	°C
Casting Temperature	Min:	909	°C
	Max:	1009	°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