

TECHNICAL DATA SHEET

PLAST327H - 750 ‰

Master alloy for the production of yellow 750 - 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	170	HV
Hardness hardened	272	HV
Tensile strength	480	MPa
Yield strength	320	MPa
Elongation	35	%

TAB.2 - Physical data

Color	Deep yellow		
Colour Coordinates	L*:	89.65	
	a*:	3.17	
	b*:	21.8	
Density	14.93	g/cm ³	
Melting Range	Solidus:	832	°C
	Liquidus:	854	°C

TAB.3 - Heat treatments

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

TAB.4 - Mechanical working parameters

Premelting temperature		954	°C
Casting Temperature	Min:	904	°C
	Max:	1004	°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