



Metaltech srl | Via Saviabona 113/G | 36010 | Cavazzale di Monticello Conte Otto (VI) | ITALIA C.F. e P.IVA 03955300243 | Reg. Imprese VI: 03955300243 | REA: VI - 367516 | Cap. Soc. € 10.000,00 i.v.





# TECHNICAL DATA SHEET PRIMA187HPLUS - 585 ‰

Master alloy for the production of red 585 - 750 % gold jewellery obtained by investment casting. This product, thanks to its complex composition made of numerous different special elements, ensures an extreme level of deoxidation, an extreme surface quality, an enhanced fluidity and a long lasting of this features also after many reuses of casting scraps, making it the most advanced solution for castings with and without stones in place.

### TAB.1 - Mechanical data

Hardness as cast	134 HV
Hardness hardened	145 HV
Tensile strength	530MPa
Yield strength	286 MPa
Elongation	37 %

## TAB.2 - Physical data

Color	[	Deep red	
Colour Coordinates	L*: a*: b*:	85.5 9.09 15.07	
Density		12.96	g/cm3
Melting Range	Solidus: Liquidus:	889 920	°C

### TAB.3 - Heat treatments

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











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# TAB.4 - Investment casting parameters

Premelting temperature		1020	°C
Casting Temperature	Min: Max:	970 1070	္င
Water investment powder ratio		36-38	%
Flask temperature	Min: Max:	450 700	°C °C
Quenching time without stones in place	Min: Max:	5 20	min min
Quenching time with stones in place		15	min in boiling water
Pickling	H2SO4: Temp: Time:	20 50 50	% °C min