

TECHNICAL DATA SHEET

PRIMA187HPLUS - 750 ‰

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	205	HV
Hardness hardened	327	HV
Tensile strength	560	MPa
Yield strength	363	MPa
Elongation	27	%

TAB.2 - Physical data

Color	Deep red		
Colour Coordinates	L*:	86.03	
	a*:	9.07	
	b*:	16.71	
Density	14.81	g/cm3	
Melting Range	Solidus:	894	°C
	Liquidus:	903	°C

TAB.3 - Heat treatments

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

TAB.4 - Investment casting parameters

Premelting temperature		1003	°C
Casting Temperature	Min: Max:	953 1053	°C °C
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