



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 PRIMA215AIB - 375 %

Master alloy for the production of white 375 - 417 - 585 % 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	157	HV
Hardness hardened	206	HV
Tensile strength	659	MPa
Yield strength	466	МРа
Elongation	25	%

# TAB.2 - Physical data

Color	Premiu	um white	
Colour Coordinates	a*: -(	7.15 ).12 .96	
Density	1	1.13 g/cm3	
Melting Range		367 °C 923 °C	

## TAB.3 - Heat treatments

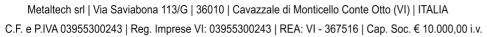
Solution annealing	675 20	°C min
Recrystallization Annealing	675 20	°C min
Hardening	300 180	°C min











# TAB.4 - Investment casting parameters

Premelting temperature		1023	°C
Casting Temperature	Min:	973	°C
	Max:	1073	°C
Water investment powder ratio		36-38	%
Flask temperature	Min:	450	°C
	Max:	700	°C
Quenching time without stones in place	Min:	5	min
	Max:	20	min
Quenching time with stones in place		15	min in boiling water
Pickling	H2SO4:	20	%
	Temp:	50	°C
	Time:	50	min