

TECHNICAL DATA SHEET

PRIMA477IA

Alloy for the production of brass items, jewels and models 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	81	HV
Hardness hardened	n.d.	
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	pink
Colour Coordinates	L*: 88.61 a*: 7.68 b*: 17.12
Density	9.1 g/cm ³
Melting Range	Solidus: 951 °C Liquidus: 1022 °C

TAB.3 - Heat treatments

Solution annealing	680 °C 30 min
Recrystallization Annealing	680 °C 30 min
Hardening	n.d.

TAB.4 - Investment casting parameters

Premelting temperature		1122	°C
Casting Temperature	Min:	1072	°C
	Max:	1172	°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