

TECHNICAL DATA SHEET

PRIMA495I - 170 ‰

Alloy for the production of red brass items, jewels and models obtained by investment casting. The elements contained in this product ensure a high deoxidation after casting and a high surface quality, making it suitable for castings with and without stones in place. The use is suggested with the addition of 0 - 20 % of pure silver.

TAB.1 - Mechanical data

Hardness as cast	79	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*: 88.63 a*: 7.64 b*: 17.08
Density	9.13 g/cm ³
Melting Range	Solidus: 948 °C Liquidus: 1018 °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		1118	°C
Casting Temperature	Min: Max:	1068 1168	°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