

TECHNICAL DATA SHEET

PRIMA495I - 70 ‰

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	62	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*: 86.63 a*: 10.58 b*: 16.26
Density	8.82 g/cm ³
Melting Range	Solidus: 958 °C Liquidus: 1042 °C

TAB.3 - Heat treatments

Solution annealing	700 °C 30 min
Recrystallization Annealing	700 °C 30 min
Hardening	n.d.

TAB.4 - Investment casting parameters

Premelting temperature		1142	°C
Casting Temperature	Min:	1092	°C
	Max:	1192	°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