

TECHNICAL DATA SHEET

SPARK582

Brass for the production of 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.

TAB.1 - Mechanical data

Hardness as cast	200	HV
Hardness hardened	n.d.	
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	yellow
Colour Coordinates	L*: 85.70 a*: 1.22 b*: 14.32
Density	8.54 g/cm ³
Melting Range	Solidus: 835 °C Liquidus: 940 °C

TAB.3 - Heat treatments

Solution annealing	660 °C 30 min
Recrystallization Annealing	660 °C 30 min
Hardening	n.d.

TAB.4 - Investment casting parameters

Premelting temperature		n.d.	
Casting Temperature	Min: Max:	990 1090	°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