

TECHNICAL DATA SHEET

STAR325L - 375 ‰

Universal master alloy for the production of yellow 375 - 417 - 585 ‰ gold jewellery obtained by investment casting and mechanical working. The elements contained in this product ensure a high surface quality in investment casting, while in mechanical working a high deformation capability thanks the small grain structure, making it suitable for the production of hand and machine made hollow and solid chains, deep drawn items and tube.

TAB.1 - Mechanical data

| | | |
|-------------------|------|----|
| Hardness as cast | 127 | HV |
| Hardness hardened | n.d. | |
| Tensile strength | n.d. | |
| Yield strength | n.d. | |
| Elongation | n.d. | |

TAB.2 - Physical data

| | | | |
|--------------------|-------------|-------------------|----|
| Color | Pale yellow | | |
| Colour Coordinates | L*: | 91.28 | |
| | a*: | -0.25 | |
| | b*: | 18.25 | |
| Density | 11.13 | g/cm ³ | |
| Melting Range | Solidus: | 767 | °C |
| | Liquidus: | 859 | °C |

TAB.3 - Heat treatments

| | | |
|-----------------------------|-----------|-----------|
| Solution annealing | 675 20 | °C min |
| Recrystallization Annealing | 675 20 | °C min |
| Hardening | 275 | °C |
| | 180 | min |

TAB.4 - Investment casting parameters

| | | | |
|--|--------|-------|-------------------------|
| Premelting temperature | | 959 | °C |
| Casting Temperature | Min: | 909 | °C |
| | Max: | 1009 | °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 |

TAB.5 - Mechanical working parameters

| | | | |
|--------------------------------|-------------|------|-----|
| Premelting temperature | | 959 | °C |
| Casting Temperature | Min: | 909 | °C |
| | Max: | 1009 | °C |
| First thickness reduction | Lamination: | 50 | % |
| | Drawing: | 25 | % |
| Following thickness reductions | Lamination: | 75 | % |
| | Drawing: | 50 | % |
| Pickling after annealing | H2SO4: | 20 | % |
| | Temp: | 50 | °C |
| | Time: | 5 | min |