METALTECH
THE POWER OF RESULTS
Metaltech srl | Via Saviabona 113/G | 36010 | Cavazzale di Monticello Conte Otto (VI) | ITALIA
C.F. e P.IVA 03955300243 | Reg. Imprese VI: 03955300243 | REA: VI - 367516 | Cap. Soc. € 10.000,00 i.v.

TECHNICAL DATA SHEET

STAR385L - 375 ‰

Universal master alloy for the production of white nickel and palladium free 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	104	HV
Hardness hardened	173	HV
Tensile strength	396	MPa
Yield strength	236	MPa
Elongation	30	%

TAB.2 - Physical data

Color	Premium white		
Colour Coordinates	L*: a*: b*:	94.86 -1.85 9.65	
Density		12.26	g/cm3
Melting Range	Solidus: Liquidus:	805 893	°C °C

TAB.3 - Heat treatments

Solution annealing	675 20	°C min
Recrystallization Annealing	675 20	°C min
Hardening	300 180	°C min

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TAB.4 - Investment casting parameters

Premelting temperature		993	°C
Casting Temperature	Min: Max:	943 1043	°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

TAB.5 - Mechanical working parameters

Premelting temperature		993	°C
Casting Temperature	Min: Max:	943 1043	°C °C
First thickness reduction	Lamination: Drawing:	50 25	% %
Following thickness reductions	Lamination: Drawing:	75 50	% %
Pickling after annealing	H2SO4: Temp: Time:	20 50 5	% °C min