

# ABI Precious Metals

## Tech Specs: #200

Alloy name:	# 200
General Description:	Standard 10K alloy for casting with good reusability.
Color:	Yellow
Karating:	Pre karating is the preferred production procedures. Charge alloys cover with gold and cover with boric acid. Once metal reaches 1950°F (1066°C) stir and pour shot.
Casting:	Melting should be done in an inert atmosphere (Argon). Use flux only in an open system. The casting temperature should be about 1025°C (1880°F) add 50°F for vacuum system.
Flask Temp:	Dependent on parts but a starting point would be 1100°F for 3dwt rings with detail,950°F heavy gents rings.
Quench Time:	20-25 minutes after casting.
Reusability:	A 50% fresh 50% recycle ratio is recommended. Regraining is not necessary.
Technical Question:	Please feel free to call at any time if you have question or comments.

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