

ABI Precious Metals

Tech Specs: #229

ALLOY:	#229 YELLOW
DESCRIPTION:	YELLOW ALLOY FOR CASTING
KARAT:	10K and 14K
KARATING METHOD:	Pre-karating outside the casting machine is the preferred production procedure. Charge the alloy with the gold and cover with boric acid if a cover gas is not available. Mechanically stir the melted metal prior to shotting. Once metal reaches a temperature of 1920°F (1050°F), pour the shot.
CASTING:	Melting can be done in any atmosphere with a boric acid flux. The casting temperature should be 1760°F to 1800°F (960°C to 980°C) for 14K - add 20°C for 10K.
FLASK TEMP:	Depending upon the pieces being cast, a good starting point would be 1150°F for 3 dwt rings with detail. Use 950°F for heavy rings.
QUENCH TIME:	20 minutes after casting.
REUSABILITY:	A 50% new to 50% old is acceptable, however a 60/40 is preferable. Re-graining is not necessary.
TECHNICAL HELP:	Please feel free to contact us any time with you questions or comments.

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