

# ABI Precious Metals

## Tech Specs: # 26

<b><i>Alloy Name:</i></b>	# 26
<b><i>General Description:</i></b>	Standard 10k, 14k & 18k alloy for casting with good reusability.
<b><i>Color:</i></b>	White
<b><i>Karating:</i></b>	Pre karating is preferred production procedure. Charge alloy, cover with gold and cover with boric acid. Mechanically stir. Once metal reaches (1960°F) 1070°C pour shot.
<b><i>Casting:</i></b>	Melting should be done in an inert atmosphere (Argon). Use flux only in an open system. The casting temperature should be about 1905°F for 10k and 1870°F (1020°C) for 14k and 18k.
<b><i>Flask Temp:</i></b>	Dependent on parts, a starting point would be 1150°F for 3 dwt rings with detail, and 950°F for heavy gents rings.
<b><i>Quench Time:</i></b>	20-25 minutes after casting.
<b><i>Reusability:</i></b>	A 50% fresh to 50% old recycle ratio is recommended. Re-graining is not necessary.
<b><i>Technical Questions:</i></b>	Please feel free to call at any time if you have any question or comments.

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