

ABI Precious Metals

Tech Specs: #260

Alloy Name:	#260
General Description:	Standard 14K alloy for casting.
Color:	Yellow / Green
Karating:	Pre karating is the preferred production procedure. Charge alloy, cover with gold and cover with boric acid. Mechanically stir. Once metal reaches 1950°F (1066°C) pour shot.
Casting:	Melting can be done in an atmosphere with a boric acid flux. The casting temperature should be about 1800°F (980°C).
Flask Temp:	Dependent on parts, a starting point would be 1100°F for 3dwt rings with detail, and 950°F for heavy gents rings.
Water Quench:	20 to 25 minutes after casting. This alloy will harden if air cooled to room temperature.
Pickling:	Investment remover should be used. Heating is not necessary and proper safety gloves and goggles should be worn.
Reusability:	A 50% fresh 50% recycle ratio is recommended. regraining is not necessary.
Technical Questions:	Please feel free to call at any time if you have any questions or comments.

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