

ABI Precious Metals

Tech Specs: 440

ALLOY:	#440 YELLOW
DESCRIPTION:	YELLOW ALLOY FOR CASTING
KARAT:	18K
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 1960°C(1070°C) pour the shot.
CASTING:	Casting is best in a closed system. The casting temperature should be 1850°F to 1885°F (1010°C to 1030°C).
FLASK TEMP:	Depending upon the pieces being cast, a good starting point would be 1150°F for 2 dwt rings with detail. Use 950°F for heavy rings.
QUENCH TIME:	20 to 25 minutes minimum.
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 ABI with your questions

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