

ABI Precious Metals

TECH SPECS: # 467 alloy

Alloy Name:	#467 WHITE
Description:	White casting alloy with excellent fluidity and reusability
Karat:	10K, 14K, 18K
Karating:	Pre karating outside the casting machine is the preferred production procedure. Melt under a reducing or an inert atmosphere. Hold at pouring temperature for “2 minutes” when melt reaches 2010°F to 2045°F (1100°C to 1120°C). It is especially critical for white gold to make sure the nickel is melted.
Casting:	Use a boric acid flux in a open system. Use a forming or argon cover gas where possible. The casting temperature for 10k and 14k is 1830F – 1890F (1000 to 1015C).
Flask Temp:	Depending on the pieces being cast, a good starting point would be 1100°F for 3 dwt rings with detail - use 950°F for heavy rings.
Quench Time:	10 minutes after casting, 15 minutes for large castings (increasing quench time may harden metal)
Reusability:	A 70% new to 30% recycle ratio is recommended. Regraining is not necessary.
Technical Questions:	Please feel free to call at any time if you have questions or comments.

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