

ABI Precious Metals

Tech Specs: # 670

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| Alloy Name: | # 670 |
| General Description: | 18K alloy for casting. |
| Color: | Yellow (slight greenish tint) |
| Karating: | Pre karating outside the machine 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 should be done in an open atmosphere with a flux. The casting temperature should be about 1960°F (1070°C) for 18K. |
| Flask Temp: | Dependent on parts but 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. |
| Pickling: | Investment Remover should be used. Heat is not necessary and proper safety gloves and goggles should be worn. |
| Reusability: | A 50% fresh 50% recycle ratio is recommended. regaining is not necessary. |
| Technical Questions: | Please fell free to call at any time if you have any questions or comments. |

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