

# A B I PRECIOUS METALS

## CASTING ALLOY DATA

Alloy Name:	# 671
General Description:	Standard 22 Kt alloy for casting with gold reusability.
Color:	Yellow
Karating:	Pre karating outside the machine is the preferred production procedure. Charge alloy, cover with gold and cover with boric acid. Mechanically stir. Once melt reaches 2050°F (1121°C) pour shot.
Casting:	Melting should be done in an open atmosphere with a flux. The casting temperature should be about 1970°F – 2040°F (1076°C – 1116°C) for 22 Kt.
Flask Temp:	Dependent on parts but a starting point would be 1100°F for 3 dwt rings with detail, and 950°F for heavy gents rings.
Water Quench:	10 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, regraining is not necessary.
Technical Questions:	Please fell free to call at any time if you have any questions or comments.