

ABI Precious Metals

Tech Specs: #700-C

Alloy Name:	#700-C
General Description:	18K alloy for casting.
Color:	Yellow / Green
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. regraining is not necessary.
Technical Questions:	Please fell free to call at any time if you have any questions or comments.

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