

ABI Precious Metals

TECH SPECS: ALLURA # 5105

Composition:	Gold, Silver, Palladium
Melt:	1724°F – 1760°F (940°C – 960°C)
Pasty Range:	1555°F – 1890°F (1019°C – 1032°C)
Casting Range:	2010°F – 2140°F (1100°C – 1170°C)
Flask Range:	Men's Rings: 1010°F – 1150°F (543°C – 622°C) Lady's Rings: 1050°F - 1250°F (566°C – 680°C)
Quench:	15 – 20 Minutes
Hardness:	As Cast: 86 Rockwell 15-T (150 Vickers)
Heat Treat:	N/A
Metal Mix	We recommend 60% new to 40% old . It is important to “thoroughly clean” the old (used) metal prior to re-using. It is imperative to "re-grain" the buttons & sprues if you plan to reuse them to eliminate sulfur dioxide & other contaminants from previous melts.
Pickle	Sodium Bisulfate (Sparex) or 10% Nitric Acid and 90% Water (heated).
Flux	25% granular Boric Acid and 75% granular Borax mixed.
Machine Notes	If casting with a frequency machine, always cast “on the upswing” of the metal heating cycles. Always retrieve flask well before casting temperature is reached, then cast it when temperature reaches set point

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