

A B I PRECIOUS METALS

Tech Specs: Allura White #7005

Melt:	Solidus (1551F (844C) Liquidus (1767F (964C)
Pasty Range:	N/A
Casting Range:	1925F – 2000F (1052 – 1094 C) ~ Best results usually occur when casting at the high end of the range (large pieces)
Flask Range:	Men’s Rings: 950 – 1030F (510 – 556C) Smaller Rings: 1050 – 1180F (565 – 638C)
Investment:	Same Investment as your current Gold & Silver Investment (Gypsum)
Burnout Cycle:	No changes in burnout cycle times / temperatures
Quench:	12 – 20 Minutes
Hardness:	As Cast: 110 – 125 Hv (81 Rockwell 15-T)
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 or 10% Nitric Acid and 90% Water (heated to 150F).
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. Leave in machine for 2 minutes after pour. “DO NOT MOVE THE FLASK”

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