Heraeus

TECHNICAL SPECIFICATIONS

Master Alloy: H-153F

Suitable karatage	**: 10/14/18K**	**Colour**	**: Pink**
Nickel Content	**: 0%**	**Silver Content**	**: 4.0%**
Palladium Content	**: 0%**	**Platinum Content**	**: 0%**
Hardness	**: 166HV (18K)**		
Applications	**: Suitable for loss wax casting, torch melting**		
Advantages	**: Shiny, not easily cracked, high re-casting rate**		

Recommended Casting Parameters :

Metal Casting Temperature	: 10K / 1075ºC , 14K / 1020ºC, 18K / 1020ºC	
Investment Flask Temperature	: 540ºC - 650ºC	(Vacuum-assisted Casting)
	: 430ºC - 530ºC	(Centrifugal Casting)
Quenching Time	: 10 - 15 minutes	

Technical Advice :

1. To avoid oxidation, the alloys must be covered with inert gas or yellow flame during casting.
2. Not more than 50 % of old material should be used for recasting.
3. The old material must be pickled in dilute sulfuric acid (10 %) for 15 - 20 minutes to remove the oxide, followed by tumbling to remove the investment powder residue.
4. The sprue should be placed at the thickest position. Additional sprue must be applied if necessary. Fluted sprue is preferred to avoid any turbulence.

Remarks: The information is for your reference only. The parameters should be adjusted according to the particular casting conditions. If you have any technical questions, please do not hesitate to contact us.

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