

TECHNICAL SPECIFICATIONS

Master Alloy : H-6688S

Suitable karatage : 14/18K	Colour : White
Nickel Content : 24.3 %	Silver Content : 0 %
Palladium Content : 0 %	Platinum Content : 0 %
Hardness : 180 HV (18K)	
Applications : Suitable for loss wax casting, torch melting, stone casting	
Advantages : 18KW complies with the new Nickel Releasing Test (EN1811), good fluidity, less porosity,	

Recommended Casting Parameters :

Metal Casting Temperature : 14K / 1070 °C, 18K / 1030 °C
Investment Temperature : 530 – 660 °C (Vacuum-assisted Casting)
: 450 – 550 °C (Centrifugal Casting)
Quenching Time : 15 – 25 minutes

Technical Advice:

1. Not more than 50 % of old material should be used for recasting.
2. 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.
3. The sprue should be placed at the thickest position. Additional sprue must be applied if necessary. Fluted sprue is preferred to avoid any turbulence.
4. Since the surface texture on casting item can severely affect the nickel releasing result according to the new testing method, we highly suggest at least 1 minute of Rh-plating should be applied prior to testing to ensure a consistent result can be obtained.

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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