Heraeus

TECHNICAL SPECIFICATIONS

Master Alloy: H-889 (Pd & Ni free)

Suitable karatage	**: 8/10/14K**	**Colour**	**: White**
Nickel Content	**: 0%**	**Silver Content**	**: 84%**
Palladium Content	**: 0%**	**Platinum Content**	**: 0%**
Hardness	**: 86HV (10K)**		
Applications	**: Suitable for loss wax casting, stone casting, hand-making**		
Advantages	**: Palladium & Nickel free, low melting point**		

Recommended Casting Parameters :

Metal Casting Temperature	: 8K / 1020ºC, 10K / 1025ºC, 14K / 1030 ºC	
Investment Flask Temperature	: 480ºC - 590ºC	(Vacuum-assisted Casting)
	: 430ºC - 530ºC	(Centrifugal Casting)
Quenching Time	: 15 - 25 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.

Main Office:
Heraeus Ltd.
Heraeus Technology Centre
30 On Chuen Street, On Lok Tsuen
Fanling, N.T., Hong Kong
Tel : (852) 2675 1200
Fax: (852) 2682 3220

總公司:
賀利氏有限公司
香港新界粉嶺安樂村
安全街 30 號
賀利氏科技中心
電話：(852) 2675 1200
傳真：(852) 2682 3200

Hunghom Sales Office:
Heraeus Ltd.
Rm. 2111-3, Peninsula Square
18 Sung On Street, Hunghom
Kowloon, Hong Kong
Tel : (852) 2773 1733
Fax: (852) 2773 1090

紅磡營業部:
賀利氏有限公司
香港九龍紅磡
崇安街 18 號
半島廣場 2111-3 室
電話：(852) 2773 1733
傳真：(852) 2773 1090