

Tech specs: Allura-White #1005

Compositions:	Palladium, Silver Alloy
Melt:	Solidus 844*c Liquidus 964*c
Pasty Range:	N/A
Casting Range:	1052-1093*C Good results the high side (large rings)
Flask Range:	Men's Rings: 510-524*c Lady's Rings: 565-620*c
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 contaminates 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 t temperature reaches set point. Leave in machine for 2 minutes after pour " DO NOT MOVE THE FLASK"
Fabrication:	Recommend 20-25% Reduction between annealing 670*c