

TECH SPECS : ALLURA YELLOW #1900

COPOSTION:	Silver, gold, palladium
MELT:	1724°F-1760°F (940°C-960°C)
PASTY RANGE:	1544°F-1598°F (840°C-870°C)
CASTING RANGE:	1810°F-1900°F (999°C-1038°C)
FLASK RANGE:	Lady's rings 950°F-1100°F (510°C-593°C) Men's rings 800°F-950°F (427°C-510°C)
QUENCH:	15 to 20 minutes
HARDNESS:	As cast 140 – 150 Hv (85 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 cycle. Always retrieve flask well before casting temperature is reached, then cast it when the temp reaches set point. Leave in machine for 2 minutes after pour. (DO NOT MOVE THE FLASK)