

Tech Specs: #178

Alloy Name:	#178 Red
General Description:	18K alloy for casting
Color:	Red
Karating:	Pre karating is the preferred production procedure. Charge alloy, add gold and cover with boric acid. Mechanically stir. Once metal reaches 1070°C pour shot.
Casting:	Melting can be done in any atmosphere with a boric acid reflux. The casting temperature should be about (1030 to 1060°C)
Flask Temp:	Light weight 620-670C. Medium weight 550-585C. Heavy piece 485-540C rings.
Quench Time:	5-10 minutes after casting.
Pickling:	Sodium bi-sulfate or equivalent should be used. Proper safety gloves and goggles should be worn.
Reusability:	A 60% fresh 40% recycle ratio is recommended. Re-graining is not necessary.
Technical Questions:	Please feel free to call at anytime if you have any questions or comments.