

Tech Specs: #51

Alloy Name:	#51 Red
General Description:	10K, 14K, and 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 1960°F-2000°F (1070°C-1093°C) pour shot.
Casting:	Melting can be done in any atmosphere with a boric acid reflux. The casting temperature should be about 1940°F (1060°C)
Flask Temp:	Dependent on parts; a starting point would be 1100°F(593°C) for 3dwt rings with detail, and 950°F(510°C) for heavy gents rings.
Quench Time:	As soon as glow is gone from button - quench
Pickling:	Sodium bi-sulfate or equivalent should be used. Heating is not necessary and proper safety gloves and goggles should be worn.
Reusability:	A 50% fresh 50% 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.