

## **Tech Specs: #200**

<b>Alloy Name:</b>	#200
<b>General Description:</b>	Standard 10 K Alloy for casting with good reusability
<b>Color:</b>	Yellow
<b>Karating:</b>	Pre karating is the preferred production procedures. Charge alloys cover with gold and cover with boric acid. Once metal reaches 1950F (1066C) stir and pour shot.
<b>Melting Temp:</b>	Melting should be done in an inert atmosphere (Argon). Use flux only in an open system. The casting temperature should be about 1880F (1025C)
<b>Flask Temp:</b>	Dependent on parts but a starting point would be 1100F for 3 dwt rings with detail 950F heavy gents rings.
<b>Quench Time:</b>	20-25 minutes after casting.
<b>Reusability:</b>	A 50% fresh 50% recycle ratio is recommended. Re- graining is not necessary.
<b>Technical Questions:</b>	Please feel free to call at any time if you have any questions or comments.