

Tech Specs: # 670

Alloy Name:	# 670
General Description:	18K alloy for casting.
Color:	Yellow (slight greenish tint)
Karating:	Pre karating outside the machine is the preferred production procedure. Charge alloy, cover with gold and boric acid. Mechanically stir. Once metal reaches 1950°F (1066°C) pour shot.
Casting:	Melting should be done in an open atmosphere with a flux. The casting temperature should be about 1960°F (1070°C) for 18K.
Flask Temp:	Dependent on parts but a starting point would be 1100°F for 3dwt rings with detail, and 950°F for heavy gents rings.
Water Quench:	20 to 25 minutes after casting.
Pickling:	Investment Remover should be used. Heat is not necessary and 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 any time if you have any questions or comments.